

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012660**Date Inspected:** 17-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress.

OBG SEGMENT 7AW-7BW

This Quality Assurance (QA) Inspector observed ZPMC qualified welders 045196, 066361 performing Shielded Metal Arc Welding process for weld OBW7-003 located on PCMK deck panel splice weld between OBG segment 7AW and 7BW. ZPMC QC Mr. Tang Ya Jun monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-P2214-B-U2-FCM-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066326 performing Shielded Metal Arc Welding process for weld OBW7-004 located on PCMK deck panel splice weld between OBG segment 7AW and 7BW. ZPMC QC Mr. Tang Ya Jun monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-P2214-B-U2-FCM-1.

This Quality Assurance (QA) Inspector observed ZPMC Inspectors performing magnetic particle inspection for

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the hold back weld between “:T” stiffener and bottom panel , side panel near the splice weld between OBG segment 7AW and 6CW .

OBG SEGMENT 7AE-7BE

This Quality Assurance (QA) Inspector observed ZPMC Inspector performing ultrasonic inspection for the deck panel splice weld between OBG segment 7AE and 7BE.

This Quality Assurance (QA) Inspector observed ABF QA Inspector performing ultrasonic inspection for the bottom panel & side panel splice weld between OBG segment 7AE and 7BE.

This Quality Assurance (QA) Inspector observed ZPMC Inspector performing ultrasonic inspection for the edge panel splice weld between OBG segment 7AE and 7BE (cross beam side).

This QA Inspector observed ZPMC personnel performing carbon air arc gouging for the weld between longitudinal diaphragm and bottom panel near the PP48 bike path side.

OBG SEGMENT 7CE-7BE

This Quality Assurance (QA) Inspector observed ZPMC qualified welders 067572, 062092 performing Shielded Metal Arc Welding process for weld OBE7C-008 located on PCMK bottom panel splice weld between OBG segment 7CE and 7BE. ZPMC QC Mr. Wang Jian monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-P2214-B-U2-FCM-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welders 048659 performing Shielded Metal Arc Welding process for weld OBE7A-010 located on PCMK edge panel splice weld between OBG segment 7CE and 7BE (bike path side). ZPMC QC Mr. Wang Jian monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-P2213-B-U2-FCM-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welders 066413 performing Shielded Metal Arc Welding process for weld OBE7-002 located on PCMK edge panel splice weld between OBG segment 7CE and 7BE (cross beam side). ZPMC QC Mr. Wu Zhi Zhang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-P2213-B-U2-FCM-1.

OBG SEGMENT 7CW-7BW

This Quality Assurance (QA) Inspector observed ZPMC qualified welders 066422 performing Shielded Metal Arc Welding process for weld DP639-001-021 located on PCMK splice weld between deck panel “I” rib. ZPMC QC Mr. Tang Ya Jun monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-3213-B-U3B.

This Quality Assurance (QA) Inspector observed ZPMC qualified welders 066028 performing Shielded Metal Arc Welding process for weld CA038-006 located on PCMK weld between edge panel and deck panel (bike path side) in OBG segment 7CW. ZPMC QC Mr. Tang Ya Jun monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-P-2212-B-U2-FCM-1.

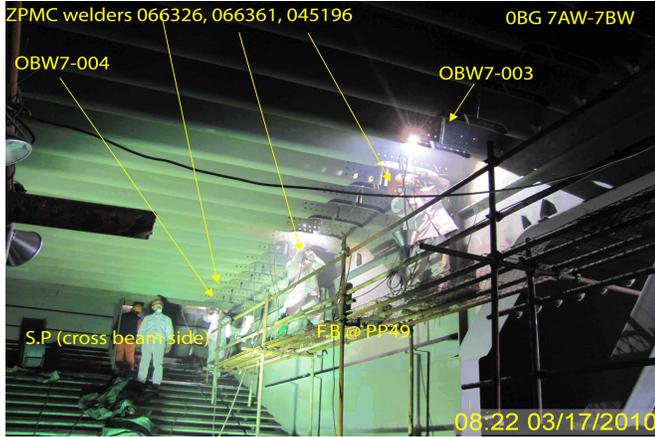
OBG SEGMENT 7CE

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This Quality Assurance (QA) Inspector observed ZPMC qualified welders 068764, 058087, 048047 performing Shielded Metal Arc Welding process for weld CA040-004 located on PCMK weld between edge panel and deck panel (bike path side) in OBG segment 7CW. ZPMC QC Mr. Tang Ya Jun monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G (2F) -FCM-Repair-1. Critical weld repair report identified as B-CWR1227.

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, +(86) 1500 042 2372, who represents the Office of Structural Materials for your project.

Inspected By: Utekar,Shrikant

Quality Assurance Inspector

Reviewed By: Dawson,Paul

QA Reviewer