

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-012661**Date Inspected:** 18-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**MAGNETIC PARTICLE INSPECTION**

ZPMC Notification No: 005375

OBG SEGMENT 6 WEST

This Q.A Inspector performed Magnetic particle Inspection of approximately 15% of the area previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated a (M.T) report for this date. The members are identified as the OBG segment 6West. Designation is as follows.

*Sole plate on edge panel.

OBG SEGMENT 6 WEST

ZPMC Notification No: 005375

This Q.A Inspector performed Magnetic particle Inspection of approximately 15% of the area previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated a (M.T) report for this date. The members are identified as the OBG segment 6West. Designation is as follows.

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*Utility pipe support clips on deck.

This QA Inspector randomly observed the following work in progress.

OBG SEGMENT 7CW-7BW

This Quality Assurance (QA) Inspector observed ZPMC qualified welders 066361, 066326, 037996 performing Shielded Metal Arc Welding process for weld OBW7-008 located on PCMK deck panel splice weld between OBG segment 7CW and 7BW. ZPMC QC Mr. Feng Yang Jing 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 045196 performing Shielded Metal Arc Welding process for weld OBW7-007 located on PCMK deck panel splice weld between OBG segment 7AW and 7BW. ZPMC QC Mr. Feng Yang Jing monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-P2214-B-U2-FCM-1.

OBG SEGMENT 7AE

This Quality Assurance (QA) Inspector observed ZPMC Inspector performing magnetic particle inspection for the hold back weld near the splice weld between OBG segment 7AE and 6CE.

OBG SEGMENT 7CE-7BE

This Quality Assurance (QA) Inspector observed ZPMC qualified welders 067572 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. Li Yang 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 068250 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. Li Yang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-P2213-B-U2-FCM-1.

OBG SEGMENT 7CE

This Quality Assurance (QA) Inspector observed ZPMC qualified welders 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 7CE. 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.

OBG SEGMENT 7CW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 045221 performing Shielded Metal Arc Welding process for weld CA037-004 located on PCMK weld between edge panel and deck panel (counter weight 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-CWR1228.

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This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066028 performing Shielded Metal Arc Welding process for weld CA038-006 located on PCMK weld between edge panel and deck panel (counter weight 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.

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.

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| Inspected By: | Utekar,Shrikant | Quality Assurance Inspector |
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| Reviewed By: | Dawson,Paul | QA Reviewer |
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