

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-012881**Date Inspected:** 30-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

OBG 7AE & 7AW

ZPMC NOTIFICATION No: 005441

This Q.A Inspector performed Magnetic particle testing 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 7AE and 7AW. The welds Designation are as follows.

CA033-001; CA034-005; CA031-001; CA032-005; SEG033B-001, 011; SEG34C-021, 022; SEG034B-005, 006.

OUTSIDE YARD

ULTRASONIC INSPECTION

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

OBG 9CW

ABF NOTIFICATION No: 03302010-1

This QA Inspector performed Ultrasonic Testing (UT) on approximately 10% of OBG components previously accepted by ZPMC ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3 and Detection of Transverse Planar Discontinuities with Significant Flaw Height Dimension Procedure. Inspection was carried out on the repairs areas. Weld identification numbers were.

CA062-004

This QA Inspector performed conventional UT (Ultrasonic Testing) after ABF UT department for detection of planar transverse indication.

For more information refer the ABF/CT report dated on 03/30/ 2010.

TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress.

OBG SEGMENT 7AE-7BE-7CE

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 220067 performing Flux Cored Arc Welding process for weld SEG036B-046 located on PCMK weld between longitudinal diaphragm and bottom panel (cross beam side) in OBG segment 7BE. ZPMC QC Mr. Wang Li Yang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 220069 performing Flux Cored Arc Welding process for weld SEG031C-046 located on PCMK weld between longitudinal diaphragm and bottom panel (bike path side) in OBG segment 7BE. ZPMC QC Mr. Wang Li Yang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067904 performing Shielded Metal Arc Welding process for weld CA036-004 located on PCMK weld between deck panel and edge panel (bike path side). ZPMC QC Mr. Wang Li Yang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-354-SMAW-4G (4F)-FCM-Repair-1. Critical Weld repair report identified as B-CWR1224.

This Quality Assurance (QA) Inspector observed ABF QA Inspector performing Ultrasonic inspection on the side panel splice weld between OBG segment 7BE and 7CE (cross beam side).

This Quality Assurance (QA) Inspector observed ABF QA Inspector performing Magnetic particle inspection on the deck panel splice weld between OBG segment 7BE and 7CE.

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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 220066 performing Flux Cored Arc Welding process for weld SSD27-PP051-047 located on PCMK FL# 3 in OBG segment 7BE. ZPMC QC Mr. Wang Zhu monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-22333T.

OBG SEGMENT 7WEST

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 222396 performing Flux Cored Arc Welding process for weld SSD25-PP051-047 located on PCMK FL# 3 in OBG segment 7BW. ZPMC QC Mr. Wang Zhu monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-22333T.

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
