

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-012961**Date Inspected:** 08-Apr-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

ULTRASONIC INSPECTION

OBG 7CE

ABF Request No: 04082010-01

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 repair areas. Weld identification numbers were.

CA039-002 (7CE- DP to EP, CB side)

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

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No relevant indication observed.

MAGNETIC PARTICLE INSPECTION

OBG 7CE

ABF Request No: 04082010-01

This QA Inspector Witnessed ABF personal performing Magnetic particle Testing (MT) on weld between deck panel and edge panel (cross beam side) of OBG segment 7CE. Weld are identified as

CA039-002 (7CE- DP to EP, CB side)

Relevant indications were observed during the inspection. For more information refer the ABF report dated on 04/08/ 2010.

MAGNETIC PARTICLE INSPECTION

OBG 7BE-7CE

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 splice weld between OBG segment 7BE and 7CE the welds Designation are as follows.

OBE7B-006, 007, 008, 009, 010

TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress.

BIKE PATH #026

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 220067 performing Flux Cored Arc Welding process for weld BK-001-026-056 located on PCMK BK # 026. ZPMC QC Mr. Wang Jie monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-TC-U4B-F.

OBG SEGMENT 8EW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 045246 performing Flux Cored Arc Welding process for weld CA43-004 located on PCMK weld between deck panel and edge panel (counter weight side). ZPMC QC Mr. Li Yang 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-CWR1386.

OBG SEGMENT 8BW

This Quality Assurance (QA) Inspector observed ABF QA Inspector performing ultrasonic inspection on the weld between deck panel and edge panel (counter weight side).

OBG SEGMENT 7AW-7BW

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This Quality Assurance (QA) Inspector observed ABF QA Inspector performing ultrasonic inspection on the deck panel splice weld between OBG segment 7AW and 7BW.

OBG SEGMENT 7CW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 037784 performing Shielded Metal Arc Welding process for weld 008 located on PCMK EP059-001. ZPMC QC Mr. Zhang Hai Tao monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-P-2114-FCM-01.

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 |
| Reviewed By: | Dawson,Paul | QA Reviewer |
