

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-013109**Date Inspected:** 16-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 SEGMENT 7DE

ABF Request No. 04152010-1

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. Rejectable indications were observed. Inspection was carried out on repair areas. Weld identification numbers were.

CA042-004 (7DE- DP to EP, BP side)

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 04/15/2010.

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This QA Inspector randomly observed the following work in progress.

OBG SEGMENT 7DE-7EE

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067752 performing Shielded Metal Arc Welding process for weld DP658-001-007 located on PCMK deck panel "I" rib to deck panel near PP58. ZPMC QC Mr. Zang Yang Gang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-4114-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 220069 performing Shielded Metal Arc Welding process for weld OBE7A-006 located on PCMK edge panel splice weld between OBG segment 7DE and 7EE (bike path side). ZPMC QC Mr. Zhang Yang Gang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2234-B-U2-FCM-1.

OBG SEGMENT 8BE

This Quality Assurance (QA) Inspector observed ZPMC qualified welders 048047, 044779, 050232 performing Shielded Metal Arc Welding process for weld CA052-004 located on PCMK weld between edge panel and deck 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-345-SMAW-2G (2F)-FCM-Repair-1. Critical weld repair report identified as B-CWR1406.

OBG SEGMENT 7BW-7CW

This Quality Assurance (QA) Inspector observed ZPMC qualified welders 045246 performing Shielded Metal Arc Welding process for weld OBW7B-006 located on PCMK side panel splice weld between OBG segment 7BW and 7CW (counter weight side). ZPMC QC Mr. Wang Zhu monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCM-Repair-1. Critical weld repair report identified as B-CWR1408.

This Quality Assurance (QA) Inspector observed ZPMC qualified welders 047864 performing Shielded Metal Arc Welding process for weld OBW7B-007 located on PCMK side panel splice weld between OBG segment 7BW and 7CW (counter weight side). ZPMC QC Mr. Wang Zhu monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCM-Repair-1. Critical weld repair report identified as B-CWR1408.

This Quality Assurance (QA) Inspector observed ZPMC qualified welders 045196 performing Shielded Metal Arc Welding process for weld OBW7B-008 located on PCMK bottom panel splice weld between OBG segment 7BW and 7CW. ZPMC QC Mr. Wang Zhu monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCM-Repair-1. Critical weld repair report identified as B-CWR1408.

OBG SEGMENT 7BW-7AW

This Quality Assurance (QA) Inspector observed ABF QA Inspector performing magnetic particle inspection on the repair areas of the side panel splice weld OBG segment 7AW to 7BW (counter weight side).

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

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the repair areas of the deck panel splice weld OBG segment 7AW to 7BW.

MAGNETIC PARTICLE INSPECTION

OBG SEGMENT 7DE

ABF Request No. 04152010-1

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

CA042-004 (7DE- DP to EP, BP side)

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
