

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-013497**Date Inspected:** 27-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 7BW-7CW

ZPMC NWIT No: 005611

This Q.A Inspector performed Ultrasonic testing of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated a (U.T) report for this date. The members are identified as the "I" rib splice weld. The welds Designation are as follows.

DP639-001-021

ULTRASONIC INSPECTION

OBG SEGMENT 8BW

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 area. Rejectable indication was observed. Weld identification numbers were.

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CA049-001-021 (OBG 8BW- D.P to E.P, counter weight 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 04/27/2010.

MAGNETIC PARTICLE INSPECTION

OBG SEGMENT 7AW-7BW

ZPMC NWIT No: 005607

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 longitudinal diaphragm hold back weld. The welds Designation are as follows.

SEG035B-007, 006

SEG033B-021, 022

MAGNETIC PARTICLE INSPECTION

OBG SEGMENT 8BW

ABF Request No. 04262010-1

This QA Inspector Witnessed ABF personal performing Magnetic particle Testing (MT) on weld between edge panel and deck panel (counter weight side) of the OBG segment 8BW. Inspection was carried out on repair areas. Weld identification number was.

CA049-001-021 (OBG 8BW- D.P to E.P, counter weight side)

This QA Inspector randomly observed the following work in progress.

OBG SEGMENT 7CW-7DW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 069683 performing Shielded Metal Arc Welding process for weld CA037-005 located on PCMK. Corner assembly. ZPMC QC Mr. Wang Zhu monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-B-U2-FCM-1.

OBG SEGMENT 7DE-7EE

This Quality Assurance (QA) Inspector observed ABF QA Inspector performing magnetic particle inspection on the bottom panel splice weld between OBG segment 7DE-7EE.

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

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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
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Reviewed By:	Dawson,Paul	QA Reviewer
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