

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-013498**Date Inspected:** 29-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

This QA Inspector randomly observed the following work in progress.

OBG SEGMENT 8CW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 051359 performing Shielded Metal Arc Welding process for weld CA053-004 located on PCMK. Weld between edge panel and deck panel (counter weight side). ZPMC QC Mr. Zang Quing 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-CWR1405.

OBG SEGMENT 7DE

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066258 performing Shielded Metal Arc Welding process for weld CA042-004 located on PCMK. Weld between edge panel and deck panel (bike path side). ZPMC QC Mr. Zang Quing 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-CWR1378.

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OBG SEGMENT 8BE-8CE

This Quality Assurance (QA) Inspector observed ZPMC qualified welders 067904, 067765, performing Shielded Metal Arc Welding process for weld OBE8C-001 located on PCMK. Side panel splice weld between OBG segment 8BE and 8CE (cross beam side). ZPMC QC Mr. Wang Li Yang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-B-U2-FCM-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welders 067609, 068764, performing Shielded Metal Arc Welding process for weld OBE8C-002 located on PCMK. Side panel splice weld between OBG segment 8BE and 8CE(cross beam side). ZPMC QC Mr. Wang Li Yang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-B-U2-FCM-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welders 066258, 051359, 066480 performing Shielded Metal Arc Welding process for weld CA042-004 located on PCMK. Weld between edge panel and deck panel (cross beam side). ZPMC QC Mr. Wang Xiang Jin 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-CWR1411

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 062092 performing Shielded Metal Arc Welding process for weld 003 located on PCMK. OBE8B. ZPMC QC Mr. Wang Li Yang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F)-FCM-Repair-1. Critical weld repair report identified as B-CWR12501.

OBG SEGMENT 7BW

This Quality Assurance (QA) Inspector observed ZPMC personnel performing heat straightening on the deck panel 6471A in between PP 50 to PP52. Heat straightening report identified as HSR1 (B)-8369.

OBG SEGMENT 7CW-7DW

This Quality Assurance (QA) Inspector observed ZPMC QA Inspector performing magnetic particle inspection on the deck panel splice weld between OBG segment 7CW-7DW.

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.

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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