

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-013873**Date Inspected:** 03-May-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 7BE

ABF Request No: UT-7E-071

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. Weld identification numbers were.

SEG036A-011 (7BE, S.P to E.P- cross beam 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 05/02/2010 & 05/03/2010.

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ULTRASONIC INSPECTION

OBG SEGMENT 8AE-8BE

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. Weld identification numbers were.

OBE8B-001, 002 (8AE-8BE, S.P-cross beam 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 05/02/2010 & 05/03/2010.

ULTRASONIC INSPECTION

OBG SEGMENT 7BE

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 OBG segment 7BE. The welds Designation are as follows.

CSD002-PP52-089

This QA Inspector randomly observed the following work in progress.

BIKE PATH 33

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 222396 performing Flux Cored Arc Welding process for weld BK001-033-005 located on PCMK. Bike path 33. ZPMC QC Mr. Wu Zhi Zhang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-TC-U4B-F.

OBG SEGMENT 7WEST

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 068097 performing Shielded Metal Arc Welding process for weld DP649-014 located on PCMK. "T" rib to Deck panel. ZPMC QC Mr. Zhang Hai Tao 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 066038 performing Shielded Metal Arc Welding process for weld OBW7N-006 located on PCMK. Counter weight connection plate. ZPMC QC Mr. Li Yang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2214-B-U2-FCM-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067610 performing Shielded Metal Arc Welding process for weld OBW7N-004 located on PCMK. Counter weight connection plate. ZPMC QC Mr. Li Yang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2214-B-U2-FCM-1.

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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
