

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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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-013967**Date Inspected:** 14-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 7CW

ABF Report No: UT-7W-063

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 hold back weld. Weld identification numbers were.

CA037-006 (7CW, 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 05/13/2010 & 05/14/2010.

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ULTRASONIC INSPECTION

OBG SEGMENT 7DW

ABF Request No: UT-7W-064

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 hold back weld. Weld identification numbers were.

CA041-002 (7DW, 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 05/13/2010 & 05/14/2010.

ULTRASONIC INSPECTION

OBG SEGMENT 7DW

ABF Report No: UT-7W-065

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 hold back weld. Weld identification numbers were.

SEG039*-044 (7DW, D.P to D.P- Cross beam side)

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

No relevant indications were observed.

ULTRASONIC INSPECTION

OBG SEGMENT 7EW

ABF Request No: UT-7W-066

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 hold back weld. Weld identification numbers were.

CA043-002 (7EW, 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 05/13/2010 & 05/14/2010.

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ULTRASONIC INSPECTION

OBG SEGMENT 7EW

ABF Request No: UT-7W-067

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 hold back weld. Weld identification numbers were.

CA046-006 (7EW, D.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 05/13/2010 & 05/14/2010.

TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress.

OBG SEGMENT 7DE-7EE

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 054467 performing Shielded Metal Arc Welding process for weld OBE7C-009 located on PCMK. Side panel splice weld between OBG segment 7DE and 7EE (Bike path side). ZPMC QC Mr. Wu Zhi Zhang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F)-FCM-Repair-1.

OBG SEGMENT 8BW-8CW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 068097 performing Shielded Metal Arc Welding process for weld OBW8C-002 located on PCMK. Side panel splice weld between OBG segment 8BW and 8CW (Counter weight side). ZPMC QC Mr. Zhang Hai Tao 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 welder 067942 performing Shielded Metal Arc Welding process for weld OBW8C-001 located on PCMK. Side panel splice weld between OBG segment 8BW and 8CW (Counter weight side). ZPMC QC Mr. Zhang Hai Tao 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 welder 067764 performing Shielded Metal Arc Welding process for weld OBW8C-004 located on PCMK. Side panel splice weld between OBG segment 8BW and 8CW (Cross beam side). ZPMC QC Mr. Zhang Hai Tao 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 welder 066261 performing Shielded Metal Arc Welding process for weld OBW8C-005 located on PCMK. Side panel splice weld between OBG segment 8BW and 8CW (Cross beam side). ZPMC QC Mr. Zhang Hai Tao monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-B-U2-FCM-1.

WELDING INSPECTION REPORT

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OBG SEGMENT 8BW-8AW

This Quality Assurance (QA) Inspector observed ZPMC QA Inspector performing ultrasonic inspection on side panel splice weld between OBG segment 8AW and 8BW (Counter weight 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
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Reviewed By:	Dawson,Paul	QA Reviewer
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