

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-014339**Date Inspected:** 25-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

ZPMC NWIT No: 005825

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 member are identified as the. Replaced Longitudinal diaphragm web. Designations are as follows.

LD003-001-014, 013, 015

ULTRASONIC INSPECTION

OBG SEGMENT 7CW

ABF Request No: 05252010-1

WELDING INSPECTION REPORT

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This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern “D” UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as weld between deck panel and edge panel (cross beam side) OBG segment 7CW. Inspection was carried out on repair areas at hold back weld. The weld designations are as follows.

CA038-002 (OBG 7CW-DP to E.P, cross beam side)

ULTRASONIC INSPECTION

OBG SEGMENT 7DW-7EW

ABF Request No: 05252010-2

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern “D” UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the deck panel splice weld between OBG segment 7DW and 7EW. Inspection was carried out on repair areas. The weld designations are as follows.

OBW7A-008, 007, 009

This QA Inspector randomly observed the following work in progress.

OBG SEGMENT 9AE-9BE

This Quality Assurance (QA) Inspector observed ZPMC qualified welders 069841 and 067752 performing Shielded Metal Arc Welding process for weld OBE9B-004 located on PCMK. Side panel splice weld between OBG segment 9AE and 9BE (Bike path 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 welder 068764 performing Shielded Metal Arc Welding process for weld OBE9B-005 located on PCMK. Side panel splice weld between OBG segment 9AE and 9BE (Bike path 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.

OBG SEGMENT 8CE

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 068917 performing Shielded Metal Arc Welding process for weld SEG048*-004 located on PCMK. Weld between deck panel and edge panel (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-Tc-u4b-FCM-1.

OBG SEGMENT 9AW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066261 performing Shielded Metal Arc Welding process for weld CA056-006 located on PCMK. Weld between edge panel and deck panel (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-Tc-u4b-FCM-1.

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OBG SEGMENT 8BW-8CW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 045213 performing Shielded Metal Arc Welding process for weld DP645-001-019 located on PCMK. "I" rib splice weld. ZPMC QC Mr. Zhang Hai Tao monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-3213-b-u3b.

MAGNETIC PARTICLE INSPECTION

OBG SEGMENT 7DW-7EW

ABF Request No. 05252010-2

This QA Inspector Witnessed ABF personal performing Magnetic particle Testing (MT) on the repair areas of deck panel splice welds between OBG segment 7DW and 7EW. Weld identification number was.

OBW7A-008, 007, 009 (OBG 7DW-7EW-D.P)

No relevant indications were observed.

MAGNETIC PARTICLE INSPECTION

OBG SEGMENT 7CW

ABF Request No. 05252010-1

This QA Inspector Witnessed ABF personal performing Magnetic particle Testing (MT) on the repair areas of weld between deck panel and edge panel (hold back weld). Weld identification number was.

CA038-002 (OBG 7CW-DP to E.P, cross beam side)

No relevant indications were observed.

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



WELDING INSPECTION REPORT

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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
