

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-014390**Date Inspected:** 26-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 8BE

ABF Report No: UT-8E-047

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 bottom panel and side panel (cross beam side) OBG segment 8BE. The weld designations are as follows.

SEG046A-013 (OBG 8BE-SP to B.P, cross beam side)

This QA Inspector randomly observed the following work in progress.

OBG SEGMENT 8CW-8BW

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This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067103 performing Flux Cored Arc Welding process for weld SEG047B-047 located on PCMK. Weld between side panel and bottom panel (cross beam side). ZPMC QC Mr. Wang Zhu monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-B-U2-F.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067571 performing Shielded Metal Arc Welding process for weld DP645-001-10 located on PCMK. "I" rib to deck panel. ZPMC QC Mr. Wang Zhu monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-P-4114-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 045213 performing Shielded Metal Arc Welding process for weld DP653-020 located on PCMK. "I" rib to deck "I" rib splice weld. ZPMC QC Mr. Wang Zhu monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-P-3213-b-u3b.

OBG SEGMENT 8CE

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 220063 performing Flux Cored Arc Welding process for weld SEG048-034 located on PCMK. Weld between longitudinal diaphragm webs to floor beam at PP71. ZPMC QC Mr. Liu Hua Jie monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-Tc-u4b-f.

OBG SEGMENT 9AE-9BE

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 069841 performing Shielded Metal Arc Welding process for weld 015 located on PCMK. DP696-001. ZPMC QC Mr. Liu Hua Jie 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 053753 performing Shielded Metal Arc Welding process for weld DP710-001-20 located on PCMK. "I" rib to deck "I" rib splice weld. ZPMC QC Mr. Liu Hua Jie monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-P-3213-b-u3b.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067752 performing Shielded Metal Arc Welding process for weld 011 located on PCMK. SEG050A. ZPMC QC Mr. Liu Hua Jie monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-Tc-u4b-fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 068704 performing Shielded Metal Arc Welding process for weld 012 located on PCMK. SEG050A. ZPMC QC Mr. Liu Hua Jie monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-Tc-u4b-fcm-1.

OBG SEGMENT 8CE

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 068917 performing Shielded Metal Arc Welding process for weld 044 located on PCMK. SEG048*. 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.

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

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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
