

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-014438**Date Inspected:** 27-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 8CE

ABF Report No: UT-8E-048

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 hold back weld between edge panel and deck panel (Bike path side) OBG segment 8CE. The weld designations are as follows.

CA054-002 (OBG 8CE-DP to E.P, Bike path side)

MAGNETIC PARTICLE INSPECTION

OBG LIFT 7&8 EAST/WEST

WELDING INSPECTION REPORT

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ZPMC NWIT No: 005843

This Q.A Inspector performed Magnetic particle testing of approximately 15% of the area previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated a (M.T) report for this date. The members are identified as the lift 7&8 East/West. Designations are as follows.

*Pipe support on deck

ULTRASONIC INSPECTION

OBG SEGMENT 9AE

ABF Report No: UT-9E-030

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 hold back weld between edge panel and deck panel (Bike path side) OBG segment 9AE. The weld designations are as follows.

CA058-006 (OBG 8CE-DP to E.P, Bike path side)

MAGNETIC PARTICLE INSPECTION

OBG LIFT 7&8 EAST

ZPMC NWIT No: 005843

This Q.A Inspector performed Magnetic particle testing of approximately 15% of the area previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated a (M.T) report for this date. The members are identified as the lift 7&8 East . Designations are as follows.

*Heat affected zone of deck panel diaphragm and floor beam of OBG Lift 7 &8 East.

This QA Inspector randomly observed the following work in progress.

OBG SEGMENT 7DW-7EW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 037996 performing Shielded Metal Arc Welding process for weld OBW7N-016 located on PCMK. Counter weight connection plate. ZPMC QC Mr. Zhu Yuan Yuan monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-b-u2-fcm-1.

OBG SEGMENT 8BW-8CW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 045268 performing Shielded Metal Arc Welding process for weld OBW8A-022 located on PCMK. Counter weight connection plate. ZPMC QC Mr. Zhu Yuan Yuan monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-b-u2-fcm-1.

OBG SEGMENT 9AW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 045227 performing Flux Cored Arc

WELDING INSPECTION REPORT

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Welding process for weld SEG049A-014 located on PCMK. Weld between bottom panels to side 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.

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
