

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-014498**Date Inspected:** 02-Jun-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 11CE

ABF Request No: 06022010-1

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 weld between edge panel and deck panel of OBG segment 11CE. Inspection was carried out on repair areas. The weld designations are as follows.

CA088-004 (OBG 11CE-D.P-E.P, Bike path side)

CA087-004 (OBG 11CE-D.P-E.P, Cross beam side)

ULTRASONIC INSPECTION

WELDING INSPECTION REPORT

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OBG SEGMENT 8WEST/7WEST

ZPMC NWIT: 005879

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 lift 7&8 West (Counter weight connection plate). Designations are as follows.

OBW8-021

OBW7-015

ULTRASONIC INSPECTION

OBG SEGMENT 9EAST/8EAST

ZPMC NWIT: 005881

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 lift 8&9 east. Designations are as follows.

DP697-001-019; EP162-001-014; SP706-001-035; SP318-001-078, 049; SP345-001-037; BP70-001-041, 042; DP710-001-019; SP582-001-037; EP143-001-014; SP687-001-032; SP622-001-040~042; BP129-001-038, 039. SEG048D-032, 034; SEG050B-016, 018.

MAGNETIC PARTICLE INSPECTION

OBG SEGMENT 11CE

ABF Request No: 06022010-1

This QA Inspector Witnessed ABF personal performing Magnetic particle Testing (MT) on the between edge panel and deck panel of cross OBG segment 11CE. Inspection was carried out on repair areas. Weld identification number was.

CA088-004 (OBG 11CE-D.P-E.P, Bike path side)

CA087-004 (OBG 11CE-D.P-E.P, Cross beam side)

No relevant indications were observed.

This QA Inspector randomly observed the following work in progress.

OBG SEGMENT 8WEST

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067665 performing Shielded Metal Arc Welding process for weld OBW8-025 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-Tc-u4b-fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 068097 performing Shielded Metal Arc Welding process for weld OBW8-023 located on PCMK. Counter weight connection plate. ZPMC QC Mr. Zhu

WELDING INSPECTION REPORT

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Yuan Yuan 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 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
