

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-014618**Date Inspected:** 10-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:	N/A	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

ULTRASONI INSPECTION

OBG SEGMENT 8AW-8BW

ABF Request No: 06092010-2

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 weld between side panel and bottom panel (Counter weight side) of OBG segment 8AW and 8BW. Inspection was carried out on repair areas. The weld designations are as follows.

SEG043A-043 (OBG 8AW- S.P to B.P, Counter weight side)

SEG045A-013 (OBG 8BW- S.P to B.P, Counter weight side)

OBG SEGMENT 9AE-9BE

WELDING INSPECTION REPORT

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ABF Request No: 06092010-1

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 edge panel splice weld between OBG segment 9AE and 9BE (Bike path side). Inspection was carried out on repair areas. The weld designations are as follows.

OBE9-005 (OBG 9AE-9BE, E.P-Bike path side)

OBG SEGMENT 8AW-8BW

ZPMC NWIT No: 005945

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 OBG segment 8AW and 8BW.

SEG043A-028; CA047-005; CA049-001; CA050-005

MAGNETIC PARTICLE INAPECTION

OBG SEGMENT 9AE/9BE

ABF Request No: 06092010-1

This QA Inspector Witnessed ABF personal performing Magnetic particle Testing (MT) on the edge panel splice weld between OBG segment 9AE and 9BE (Bike path side). Inspection was carried out on repair areas. Weld identification number were.

OBE9-005 (OBG 9AE-9BE, E.P-Bike path side)

No relevant indications were observed.

MAGNETIC PARTICLE INAPECTION

OBG SEGMENT 8AW-8BW

ABF Request No: 06092010-2

This QA Inspector Witnessed ABF personal performing Magnetic particle Testing (MT) on the weld between bottom panel and side panel of OBG segment 8AW and 8BW (Counter weight side). Inspection was carried out on repair areas. Weld identification number were.

SEG043A-043 (OBG 8AW- S.P to B.P, Counter weight side)

SEG045A-013 (OBG 8BW- S.P to B.P, Counter weight side)

During the magnetic particle inspection ABF QA Inspector found a longitudinal linear indication.

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:

Only general conversation was held between QA and QC

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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