

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-016073**Date Inspected:** 06-Aug-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:** Zhu Zhong Hai**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(QA) Inspector Mr. 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. The QA Inspector observed and/or found the following:

TRIAL ASSEMBLY YARD

ULTRASONIC TESTING

OBG SEGMENT 9BE

ABF Request No: 08042010-2

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 separate data sheet that Caltrans QA generates after performing a joint inspection with ABF ultrasonic testing personnel. The location of the inspection was identified as the weld between side panel and edge panel of OBG segment 9BE on bike path side. The inspection was carried out on repair areas only. The weld designations were as follows:

CA060-005 (OBG 9BE, S.P to E.P, BK side)

MAGNETIC PARTICLE TESTING

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

OBG SEGMENT 9BE

ABF Request No: 08042010-2

This QA Inspector witnessed ABF personal performing Magnetic Particle Testing (MT) on the weld between side panel and edge panel of OBG segment 9BE on bike path side. The Inspection was carried out on repair areas only. The weld identification numbers were.

CA060-005 (OBG 9BE, S.P to E.P, BK side)

No relevant indications were observed by this QA Inspector on this date.

ULTRASONIC TESTING

OBG SEGMENT 9DE-9EE

ZPMC NWIT: 06345

This QA Inspector performed Ultrasonic Testing of approximately 10% of the length previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated an (UT) report on this date. The members are identified as the "T" and "I" rib butt weld. The weld designations are as follows:

DP700-001-019; EP165-001-014; DP713-001-019; SP709-001-033; SP321-001-061, 063; SP348-001-054; SP375-001-044; BP127-001-020, 022; BP181-001-022, 026; SP627-002-044, 045; SP547-002-050, 051; EP148-002-028; SP692-002-058; SP587-002-047; BP073-001-024

This QA Inspector randomly observed the following work in progress.

OBG LIFT 9 WEST

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 041713 performing Shielded Metal Arc Welding process for weld 043 located on PCMK SP733-001. ZPMC QC Mr. Shi Lei was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-B-u2-fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066239 performing Flux Cored Arc Welding process for weld 010 located on PCMK OBW9C. ZPMC QC Mr. Shi Lei was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2233T.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 53486 performing Flux Cored Arc Welding process for weld 022 located on PCMK SP658-001. ZPMC QC Mr. Shi Lei was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067764 performing Shielded Metal Arc Welding process for weld 001 located on PCMK OBW9C. ZPMC QC Mr. Li Yang was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-B-u4b-fcm-1.

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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

No significant conversations were reported on this date.

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: Peterson,Art

QA Reviewer