

**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:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016534**Date Inspected:** 02-Sep-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(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 10AE

ABF Report No: UT-10E-022R1

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 hold back weld between deck panel and edge panel of OBG segment 10AE on cross beam side at the intersection of OBG 9EE. The weld designations were as follows:

CA060\*-040 (OBG 10AE, DP to EP, CB side @ 9EE)

## OBG SEGMENT 9DW-9EW

ABF Report No: UT-9W-086R5

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# WELDING INSPECTION REPORT

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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 deck panel splice weld between OBG segment 9DW and 9EW. The weld designations were as follows:

OBW9A-009 (OBG 9DW-9EW, DP)

## ULTRASONIC TESTING

### OBG SEGMENT 9DW

ZPMC NWIT: 06559

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 OBG segment 9DW. The weld designations are as follows:

SEG055D-065, 155, 019, 083, 074

## TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress.

### OBG LIFT # 10 WEST

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 041713 performing the Shielded Metal Arc Welding process on weld 005 located at PCMK OBW10A-005. ZPMC QC Mr. Wang Zhu 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 202384 performing the Flux Cored Arc Welding process on weld 001 located at PCMK OBW10C. ZPMC QC Mr. Wang Zhu 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 040609 performing the Flux Cored Arc Welding process on weld 002 located at PCMK OBW10C. ZPMC QC Mr. Wang Zhu 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 057333 performing the Shielded Metal Arc Welding process on weld 036 located at PCMK SP777-001-. ZPMC QC Mr. Wang Zhu was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-B-u2-fcm-1.

### OBG SEGMENT 9DW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 045196 performing the Shielded Metal Arc Welding process on weld 020 located at PCMK OBW9K. ZPMC QC Mr. Lu Li Qing was monitoring this welding operation. The welding variables recorded by QC appeared to comply with

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WPS-B-P-2214-Tc-u4b-fcm-1.

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

**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.

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| <b>Inspected By:</b> | Utekar,Shrikant | Quality Assurance Inspector |
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| <b>Reviewed By:</b> | Peterson,Art | QA Reviewer |
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