

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:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016572**Date Inspected:** 05-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

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. Inspection was carried out on repair areas only. The weld designations were as follows:

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

TRIAL ASSEMBLY YARD

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This QA Inspector randomly observed the following work in progress.

OBG LIFT # 10 EAST

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 040367 performing the Flux Cored Arc Welding process on weld 045 located at PCMK BP183-001. ZPMC QC Mr. Li Hua Jie 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 044504 performing the Shielded Metal Arc Welding process on weld 035 located at PCMK DP701-001. ZPMC QC Mr. Li Hua Jie was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-3213-B-u3b.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 044515 performing the Shielded Metal Arc Welding process on weld 037 located at PCMK DP714-001. ZPMC QC Mr. Li Hua Jie was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-3213-B-u3b.

OBG LIFT # 10 WEST

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 053486 performing the Flux Cored Arc Welding process on weld 030 located at PCMK SP111-001. ZPMC QC Mr. Wang Zhu 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 202384 performing the Flux Cored Arc Welding process on weld 040 located at PCMK SP499-001. ZPMC QC Mr. Wang Zhu 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 067656 performing the Shielded Metal Arc Welding process on weld 063 located at PCMK SP111-001. ZPMC QC Mr. Wang Zhu was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2213-B-u2-fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067752 performing the Shielded Metal Arc Welding process on weld 044 located at PCMK SP165-001. 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.

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

WELDING INSPECTION REPORT

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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
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Reviewed By:	Peterson,Art	QA Reviewer
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