

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-016733**Date Inspected:** 12-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 10AW-10BW

ABF Request No: 09112010-1

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 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 10AW and 10BW. The weld designations were as follows:

OBW10-003 (OBG 10AW-10BW, DP)

OBG SEGMENT 10AW

ABF Report No: UT-10W-033R1

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This QA Inspector performed verification Ultrasonic Testing 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 welds between edge panel and side panel of OBG segment 10AW at intersection of OBG segment 10BW on counter weight side. The weld designations were as follows:

CA071-005 (OBG 10AW, SP to EP, C.W side @ 10BW)

OBG SEGMENT 10AW

ABF Report No: UT-10W-030R1

This QA Inspector performed verification Ultrasonic Testing 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 welds between edge panel and deck panel of OBG segment 10AW at intersection of OBG segment 10BW on counter weight side. The weld designations were as follows:

CA071-006 (OBG 10AW, DP to EP, C.W side @ 10BW)

OBG SEGMENT 10BW

ABF Report No: UT-10W-033R1

This QA Inspector performed verification Ultrasonic Testing 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 welds between edge panel and side panel of OBG segment 10BW at intersection of OBG segment 10AW on counter weight side. The weld designations were as follows:

CA073-001 (OBG 10BW, SP to EP, C.W side @ 10AW)

OBG SEGMENT 10BW

ABF Report No: UT-10W-030R1

This QA Inspector performed verification Ultrasonic Testing 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 welds between edge panel and deck panel of OBG segment 10BW at intersection of OBG segment 10AW on counter weight side. The weld designations were as follows:

CA073-002 (OBG 10BW, SP to EP, C.W side @ 10AW)

This QA Inspector randomly observed the following work in progress.

OBG LIFT # 10EAST

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 044504 performing the Shielded Metal Arc Welding process on weld 035 located at PCMK SEG060*. ZPMC QC Mr. Liu Zhu Jie was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G

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(4F)-Fcm-Repair-1. Weld repair report identified as B-WR14951.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 040320 performing the Shielded Metal Arc Welding process on weld 001 located at PCMK CA072. ZPMC QC Mr. Wang Li Yang was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G (4F)-Fcm-Repair-1. Critical weld repair report identified as B-CWR1901.

This Quality Assurance (QA) Inspector marked the radiography location for the deck, edges and bottom panel splice weld between OBG segment 10AE and 10BE.

OBG SEGMENT 10AW-10BW

This Quality Assurance (QA) Inspector marked the radiography location for the deck panel splice weld between OBG segment 10AW and 10BW.

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.

Inspected By:	Utekar,Shrikant	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer
