

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:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016854**Date Inspected:** 22-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:** Lv Li Qing**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 10BW-10CW

ABF Request No: 09212010-1

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 side panel splice weld between OBG segments 10BW and 10CW on counter weight side. The weld designations were as follows:

OBW10C-001, 002 (OBG 10BW-10CW, SP, CW side)

OBG SEGMENT 10BW

ABF Request No: 09212010-1

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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 deck panel and edge panel of OBG segment 10BW at intersection of OBG segment 10CW on counter weight side. The weld designations were as follows:

CA073-006 (OBG 10BW, DP to EP, CW side @ 10CW)

OBG SEGMENT 10CW

ABF Request No: 09212010-1

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 deck panel and edge panel of OBG segment 10CW at intersection of OBG segment 10BW on counter weight side. The weld designations were as follows:

CA077-002 (OBG 10CW, DP to EP, CW side @ 10BW)

OBG SEGMENT 10CW

ABF Report No: UT-10W-044R1

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 side panel and edge panel of OBG segment 10CW at intersection of OBG segment 10BW on counter weight side. The weld designations were as follows:

CA077-001 (OBG 10CW, SP to EP, CW side @ 10BW)

OBG SEGMENT 10BW

ABF Report No: UT-10W-044R1

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 side panel and edge panel of OBG segment 10BW at intersection of OBG segment 10CW on counter weight side. The weld designations were as follows:

CA073-005 (OBG 10BW, SP to EP, CW side @ 10CW)

MAGNETIC PARTICLE TESTING

OBG SEGMENT 10BW

ABF Request No: 09212010-1

This QA Inspector witnessed ABF personal performing Magnetic Particle Testing the hold back welds between deck panel and edge panel of OBG segment 10BW at intersection of OBG segment 10CW on counter weight side.

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Inspection was carried out on repair areas only. The weld identification numbers were.

CA073-006 (OBG 10BW, DP to EP, CW side @ 10CW)

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

OBG SEGMENT 10CW

ABF Request No: 09212010-1

This QA Inspector witnessed ABF personal performing Magnetic Particle Testing the hold back welds between deck panel and edge panel of OBG segment 10CW at intersection of OBG segment 10BW on counter weight side. Inspection was carried out on repair areas only. The weld identification numbers were.

CA077-002 (OBG 10CW, DP to EP, CW side @ 10BW)

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

This QA Inspector randomly observed the following work in progress.

BAY # 14

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 044774 performing the Flux Cored Arc Welding process on weld 003 located at PCMK SEG3007. ZPMC QC Mr. Lv Li Qing was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2231-B-u2-f.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067079 performing the Flux Cored Arc Welding process on weld 012 located at PCMK VP3007-001. ZPMC QC Mr. Lv Li Qing was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-Tc-u4b-f.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 044824 performing the Flux Cored Arc Welding process on weld 011 located at PCMK VP3007-001. ZPMC QC Mr. Lv Li Qing was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-Tc-u4b-f.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066439 performing the Flux Cored Arc Welding process on weld 019 located at PCMK VP3004-001. ZPMC QC Mr. Lv Li Qing was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-Tc-u4b-f.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 044795 performing the Flux Cored Arc Welding process on weld 008 located at PCMK VP3005-001. ZPMC QC Mr. Lv Li Qing was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-Tc-u4b-f.

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

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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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