

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-016924**Date Inspected:** 27-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:

This QA Inspector randomly observed the following work in progress.

BAY # 14

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 044795 performing the Flux Cored Arc Welding process on weld 002 located at PCMK VP3006A. 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 044774 performing the Flux Cored Arc Welding process on weld 012 located at PCMK VP3017A-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 066763 performing the Flux Cored Arc Welding process on weld 013 located at PCMK VP3016A-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 069089 performing the Flux Cored Arc

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Welding process on weld 007 located at PCMK VP3016A-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 067520 performing the Flux Cored Arc Welding process on weld 025 located at PCMK VP3007A. 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 066746 performing the Flux Cored Arc Welding process for buttering on the BP 3070A. ZPMC QC Mr. Wang Jie was monitoring this welding operation.

The welding variables recorded by QC appeared to comply with WPS-345-FCAW-1G (1F)-Fcm-Repair. Critical weld repair report identified as B-CWR1911.

This QA Inspector observed ZPMC personnel performing Magnetic Particle inspection on bottom plate temporary attachment removed areas of OBG segment 13AW.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 045270 performing the Submerged Arc Welding process on weld 004 located at PCMK SEG3014. ABF QA Mr. Lv Yun was monitoring this welding operation. The welding variables recorded by QA appeared to comply with WPS-B-T-2221-B-L2c-s-2.

INCIDENT

This Caltrans QA Inspector observed ZPMC personnel performing hot bending on the top anchorage plate stiffener identified as X5017A. The material was heated to a bright red condition and the temperature is above 1100°C. This QA Inspector observed the 1100°C Tempstick was melted when struck against the red base metal. This stiffener in OBG Fabrication bay # 14. Incident report was issued for this issue. See attached photographs for additional detail.

BAY # 16

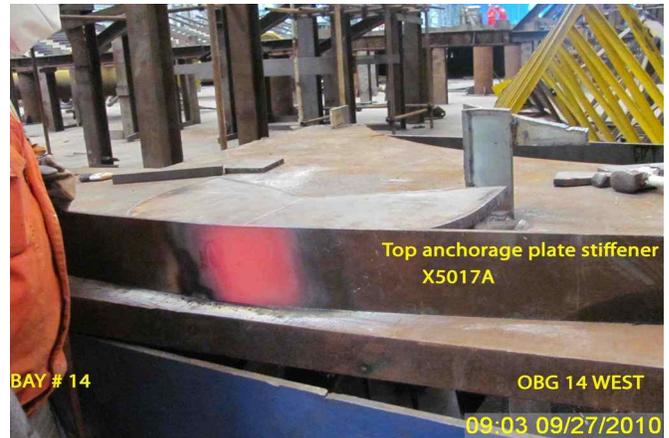
This Quality Assurance (QA) Inspector observed ZPMC qualified welder 045143 performing the Flux Cored Arc Welding process on weld 037 located at PCMK LD3035. ABF QA Mr. Li Shi You was monitoring this welding operation. The welding variables recorded by QA appeared to comply with WPS-B-T-2233-Tc-u5-f.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 045280 performing the Flux Cored Arc Welding process on weld 053 located at PCMK LD3033. ABF QA Mr. Li Shi You was monitoring this welding operation. The welding variables recorded by QA appeared to comply with WPS-B-T-2233-Tc-u5-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

Reviewed By: Peterson,Art

QA Reviewer