

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-018262**Date Inspected:** 02-Nov-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:** Geng Wei**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.

ULTRASONIC TESTING

BAY # 14

ZPMC NWIT: 07204

This QA Inspector performed Ultrasonic Testing (UT) 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 SEG3014*. The weld designations are as follows:

SEG3014*- 002

BAY # 14

ZPMC NWIT: 07205

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This QA Inspector performed Ultrasonic Testing (UT) 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 SEG3019AL. The weld designations are as follows:

SEG3019AL- 005, 292

GREEN TAG

This QA Inspector issued the following green tag for OBG components after completing the NDT requirements are:

1. KP3004-001-001, 002 -Green tag No-15175

This QA Inspector randomly observed the following work in progress.

BAY # 14

OBG 14WEST

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 045270 performing the Submerged Arc Welding process on weld 004 located at PCMK SEG3020AP. ABF QA Mr. Shao Jian Yuan was monitoring this welding operation. The welding variables recorded by QA appeared to comply with WPS-B-T-2221-B-12c-s-2

OBG 13EAST

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 068924 performing the Flux Cored Arc Welding process on weld 121 located at PCMK SEG3011M. ZPMC QC Mr. Li Ping 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 067993 performing the Flux Cored Arc Welding process on weld 118 located at PCMK SEG3011M. ZPMC QC Mr. Li Ping 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 068916 performing the Flux Cored Arc Welding process on weld 120 located at PCMK SEG3011M. ZPMC QC Mr. Li Ping 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 068924 performing the Flux Cored Arc Welding process on weld 216 located at PCMK SEG3011G. ZPMC QC Mr. Li Ping was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2233-Tc-u4b-f.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 068920 performing the Flux Cored Arc Welding process on weld 073 located at PCMK SA3012-001. ZPMC QC Mr. Wang Xu 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 048047 performing the Shielded Metal Arc Welding process on weld 112 located at PCMK SEG3007H. ZPMC QC Mr. Wang Xu was monitoring this

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welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2313-Tc-p5-fcm.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 051359 performing the Shielded Metal Arc Welding process on weld 117 located at PCMK SEG3007AY. ZPMC QC Mr. Wang Xu was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2313-Tc-p5-fcm.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 049339 performing the Shielded Metal Arc Welding process on weld 090 located at PCMK SEG3007AN. ZPMC QC Mr. Wang Xu was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2313-Tc-p5-fcm.

This Quality Assurance (QA) Inspector observed ZPMC personnel performing ultrasonic testing on the weld between AP3005 and AP3006. Weld number identified as SEG3019AP-005.

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:	Patterson,Rodney	QA Reviewer
