

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-018263**Date Inspected:** 30-Oct-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:

ULTRASONIC TESTING

BAY # 14

ZPMC NWIT: 07169

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 SEG3019AZ. The weld designations are as follows:

SEG3019AZ-013, 014, 016, 021, 019, 018, 011, 006, 001

This QA Inspector randomly observed the following work in progress.

BAY # 14

OBG 13EAST

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 044772 performing the Shielded Metal Arc Welding process on weld 057 located at PCMK SEG3009S. ZPMC QC Mr. Wang Xu was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-Tc-u4b-fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 044795 performing the Flux Cored Arc Welding process on weld 020 located at PCMK SEG3009S. ZPMC QC Mr. Lv Li Qing was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-Tc-u4b-f.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 044774 performing the Flux Cored Arc Welding process on weld 029 located at PCMK SEG3009S. ZPMC QC Mr. Lv Li Qing was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-Tc-u4b-f.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 020009 performing the Flux Cored Arc Welding process on weld 031 located at PCMK SEG3009S. ZPMC QC Mr. Lv Li Qing was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-Tc-u4b-f.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 051356 performing the Shielded Metal Arc Welding process on weld 043 located at PCMK SEG3011K. ZPMC QC Mr. Wang Xu was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2113-Fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 201087 performing the Shielded Metal Arc Welding process on weld 038 located at PCMK SEG3011K. ZPMC QC Mr. Wang Xu was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2113-Fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066439 performing the Flux Cored Arc Welding process on weld 0256 located at PCMK SEG3009L. ZPMC QC Mr. Wang Xu was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2232Tc-u4b-f.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 06613 performing the Flux Cored Arc Welding process on weld 0255 located at PCMK SEG3009L. ZPMC QC Mr. Wang Xu was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2232Tc-u4b-f.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066439 performing the Flux Cored Arc Welding process on weld 0256 located at PCMK SEG3009L. ZPMC QC Mr. Wang Xu was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2232Tc-u4b-f.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 050969 performing the Shielded Metal Arc Welding process on weld 078 located at PCMK SEG3011H. ZPMC QC Mr. Wang Xu was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2113-Tc-u4b-fcm.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066416 performing the Shielded Metal Arc Welding process on weld 081 located at PCMK SEG3011F. ZPMC QC Mr. Wang Xu was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2113-Tc-u4b-fcm.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 068924 performing the Flux Cored Arc Welding process on weld 016 located at PCMK SEG3011B. ZPMC QC Mr. Wang Xu was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2133.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 068916 performing the Flux Cored Arc Welding process on weld 017 located at PCMK SEG3011B. ZPMC QC Mr. Wang Xu was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2133.

BAY # 13

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 043661 performing the Flux Cored Arc Welding process on weld 032 located at PCMK SEG3007J. ZPMC QC Mr. Lv Li Qing was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2211-B-u3b.

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
