

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-018264**Date Inspected:** 01-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:** 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: 07190

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 "K" plate. The weld designations are as follows:

KP3004A-001, 002

This QA Inspector randomly observed the following work in progress.

BAY # 14

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 200113 performing the Shielded Metal

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

Arc Welding process on weld 002 located at PCMK CA3013A. ZPMC QC Mr. Wang Xu was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G (2F) Repair. Weld repair report identified as B-WR16247.

OBG 13EAST

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 037873 performing the Flux Cored Arc Welding process on weld 126 located at PCMK SEG3011C. 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 066416 performing the Shielded Metal Arc Welding process on weld 150 located at PCMK SEG3011C. ZPMC QC Mr. Lv Li Qing was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2213-Tc-u4c.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 068859 performing the Flux Cored Arc Welding process on weld 278 located at PCMK SEG3011N. 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 068206 performing the Flux Cored Arc Welding process on weld 275 located at PCMK SEG3011N. 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 037705 performing the Flux Cored Arc Welding process on weld 280 located at PCMK SEG3011N. 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 067993 performing the Flux Cored Arc Welding process on weld 117 located at PCMK SEG3011M. 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 068924 performing the Flux Cored Arc Welding process on weld 122 located at PCMK SEG3011M. 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 068916 performing the Flux Cored Arc Welding process on weld 119 located at PCMK SEG3011M. 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 067656 performing the Shielded Metal Arc Welding process on weld 151 located at PCMK SEG3011K. ZPMC QC Mr. Lv Li Qing was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2213-Tc-u4b-fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC personnel performing heat straightening, member identified as vertical plate VP3005. Distortion appeared to be caused by welding. ZPMC Quality Control (QC)

WELDING INSPECTION REPORT

(Continued Page 3 of 4)

inspector identified as Mr. Zhang Lin was present to monitor the heat straightening process. The heat straightening appeared to comply with heat straightening Report HSR1 (B)-9662.

This Quality Assurance (QA) Inspector observed ZPMC personnel performing ultrasonic testing on the weld between longitudinal diaphragm and bottom panel. Weld number identified as SEG3009K-118.

OBG 13WEST

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066746 performing the Flux Cored Arc Welding process on weld 044 located at PCMK SEG3015D. ZPMC QC Mr. Wang Jie 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 067888 performing the Flux Cored Arc Welding process on weld 075 located at PCMK SEG3015K. ZPMC QC Mr. Wang Jie 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 066149 performing the Shielded Metal Arc Welding process on weld 014 located at PCMK SEG3015B. ABF QA Mr. Shao Jian Yuan was monitoring this welding operation. The welding variables recorded by QA appeared to comply with WPS-B-P-2113-Fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 045270 performing the Submerged Arc Welding process on weld 026 located at PCMK SEG3015D. 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-L2c-s-2.

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.

WELDING INSPECTION REPORT

(Continued Page 4 of 4)

Inspected By:	Utekar,Shrikant	Quality Assurance Inspector
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Reviewed By:	Patterson,Rodney	QA Reviewer
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