

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-018268**Date Inspected:** 05-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:

ULTRASONIC TESTING

BAY # 14

ZPMC NWIT: 07237

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 SEG3020AL. The weld designations are as follows:

SEG3020AL- 014, 022

BAY # 14

ZPMC NWIT: 07243

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

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members are identified as “K” plate. The weld designations are as follows:

KP3007-001-009, 010

GREEN TAG

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

1. KP3007-001-009, 010 -Green tag No-15179

This QA Inspector randomly observed the following work in progress.

BAY # 14

OBG 13WEST

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066746 performing the Flux Cored Arc Welding process on weld 009 located at PCMK SEG3013H. 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 201215 performing the Flux Cored Arc Welding process on weld 016 located at PCMK SEG3013H. ZPMC QC Mr. Wang Jie was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

OBG 14 WEST

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 045265 performing the Submerged Arc Welding process on weld 028 located at PCMK SEG3020AQ. ABF QA Mr. Shen Jian was monitoring this welding operation. The welding variables recorded by QA appeared to comply with WPS-B-T-2221-B-L2c-s-2.

OBG 13EAST

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 20009 performing the Flux Cored Arc Welding process on weld 046 located at PCMK SEG3007G. ZPMC QC Mr. Wang Xu was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-Tc-u5-f.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 044795 performing the Flux Cored Arc Welding process on weld 043 located at PCMK SEG3007G. ZPMC QC Mr. Wang Xu was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-Tc-u5-f.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 043661 performing the Shielded Metal Arc Welding process on weld 143 located at PCMK SEG3009J. ZPMC QC Mr. Wang Xu 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 qualified welder 200113 performing the Shielded Metal Arc Welding process on weld 092 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 048038 performing the Shielded Metal Arc Welding process on weld 104 located at PCMK SEG3007AZ. 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 068859 performing the Flux Cored Arc Welding process on weld 257 located at PCMK SEG3011C. ZPMC QC Mr. Wang Xu 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 043661 performing the Shielded Metal Arc Welding process on weld 144 located at PCMK SEG3009J. ZPMC QC Mr. Wang Xu 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 qualified welder 043661 performing the Shielded Metal Arc Welding process on weld 143 located at PCMK SEG3009J. ZPMC QC Mr. Wang Xu 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 anchorage plate AP3009 and AP3010. Distortion appeared to be caused by welding. ZPMC Quality Control (QC) 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)-9751.

OBG 14EAST

This QA Inspector observed fit-up was in progress for the longitudinal diaphragm (LD3042) and floor beam (FB3266).

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.

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