

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-018842**Date Inspected:** 14-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:** Wang Jie**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:

BAY # 14

ULTRASONIC TESTING

ZPMC NWIT: 07347

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 OBG lift 14 west. The weld designations are as follows:

SEG3020AP-001; SEG3020AQ-031

ULTRASONIC TESTING

ZPMC NWIT: 07351

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 VP3004. The weld designations are as follows:

VP3004-001-018

This QA Inspector randomly observed the following work in progress.

BAY # 14

OBG14 EAST

This Quality Assurance (QA) Inspector observed ZPMC qualified welders 054013 and 044772 performing the Shielded Metal Arc Welding process on weld 009 located at PCMK SEG3019A. 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 068920 performing the Flux Cored Arc Welding process on weld 096 located at PCMK SEG3019AB. ZPMC QC Mr. Wang Xu Gang was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2132-Tc-u5-f.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 068206 performing the Flux Cored Arc Welding process on weld 094 located at PCMK SEG3019AB. ZPMC QC Mr. Wang Xu Gang was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2132-Tc-u5-f.

OBG 13 EAST

This Quality Assurance (QA) Inspector observed ZPMC personnel performing heat straightening, member identified as VP3008. Distortion appeared to be caused by welding. ZPMC Quality Control (QC) inspector identified as Mr. Wang Xu was present to monitor the heat straightening process. The heat straightening appeared to comply with heat straightening Report HSR1 (B)-9832.

This Quality Assurance (QA) Inspector observed ZPMC personnel performing heat straightening, member identified as VP3007. Distortion appeared to be caused by welding. ZPMC Quality Control (QC) inspector identified as Mr. Wang Xu was present to monitor the heat straightening process. The heat straightening appeared to comply with heat straightening Report HSR1 (B)-9831.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 037705 performing the Flux Cored Arc Welding process on weld 033 located at PCMK SEG3007F. ZPMC QC Mr. Zhong Yong Gang 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 068494 performing the Flux Cored Arc Welding process on weld 019 located at PCMK SEG3007G. ZPMC QC Mr. Zhong Yong Gang was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-Tc-u4b-f.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract

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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
