

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-019022**Date Inspected:** 17-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**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:

BAY # 13

ULTRASONIC TESTING

ZPMC NWIT No: 07819

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 Grillage. The weld designations are as follows:

SA7038-035, 051

BAY # 14

ULTRASONIC TESTING

ZPMC NWIT No: 07810

WELDING INSPECTION REPORT

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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 OBG 13AE. The weld designations are as follows:

SEG3007T-101~108

During the Ultrasonic testing of the weld SEG3007T-107 this Quality Assurance (QA) Inspector discovered a class "A" non conforming indication measuring approximately 8 to 10mm in length, Material thickness is approximately 18mm. The depth of the indications was approximately 9.2mm. The indication db rating was +8. The weld is Complete Joint Penetration (CJP) "T" Joint between LD3025 and bottom panel. As per lead QA ZPMC will repair this weld without issuing incident report (IR). For indication detail see the "UT" report as same date.

This QA Inspector randomly observed the following work in progress.

OBG 13EAST

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 068097 performing the Shielded Metal Arc Welding process on weld 004 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-P-2211-B-u2-Fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 068501 performing the Flux Cored Arc Welding process on weld 006 located at PCMK SEG3007V. ZPMC QC Mr. Lv Li Qing was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2133-ESAB.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 052696 performing the Flux Cored Arc Welding process on weld 253 located at PCMK SEG3007V. ZPMC QC Mr. Wang Xu was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2133-ESAB.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067079 performing the Flux Cored Arc Welding process on weld 130 located at PCMK SEG3007V. ZPMC QC Mr. Wang Xu was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2133-ESAB.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 050242 performing the Flux Cored Arc Welding process on weld 010 located at PCMK SEG3007V. ZPMC QC Mr. Wang Xu was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2132-ESAB.

OBG 14 EAST

This Quality Assurance (QA) Inspector observed erection of the FB3271 was in progress in lift 14 east.

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

WELDING INSPECTION REPORT

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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.

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