

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-019146**Date Inspected:** 01-Jan-2011**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:

BAY # 14

ULTRASONIC TESTING

ZPMC NWIT No: 08007

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 14 East. The weld designations are as follows:

SEG3019A-019~025

This QA Inspector randomly observed the following work in progress.

OBG 13EAST

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 052696 performing the Flux Cored Arc

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Welding process on weld 149 located at PCMK SEG3019K. ZPMC QC Mr. Zong Yang Gang was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 068097 performing the Shielded Metal Arc Welding process on weld 196 located at PCMK SEG3009G. ZPMC QC Mr. Zong Yang Gang was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-B-u2-Fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066401 performing the Flux Cored Arc Welding process on weld 222 located at PCMK SEG3011G. ZPMC QC Mr. Zhong Yang Gang was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066258 performing the Shielded Metal Arc Welding process on weld 002 located at PCMK SEG3011U. ZPMC QC Mr. Zhong Yang Gang was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G (2F)-Fcm-Repair-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067571 performing the Shielded Metal Arc Welding process on weld 288 located at PCMK SEG3009E. ZPMC QC Mr. Zong Yang Gang was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-B-u2-Fcm-1.

OBG 14 EAST

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 048047 performing the Shielded Metal Arc Welding process on weld 169 located at PCMK SEG3019BB. ZPMC QC Mr. Zhong Guo Hui was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2212-Tc-u4b-Fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066422 performing the Shielded Metal Arc Welding process on weld 147 located at PCMK SEG3019BB. ZPMC QC Mr. Zhong Guo Hui was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2212-Tc-u4b-Fcm-1.

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.

Inspected By: Utekar,Shrikant Quality Assurance Inspector

Reviewed By: Patterson,Rodney QA Reviewer