

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-019149**Date Inspected:** 04-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: 08042

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:

SEG3007Y-339

This QA Inspector randomly observed the following work in progress.

OBG 13EAST

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 068924 performing the Shielded Metal Arc Welding process on weld 046 located at PCMK SEG3007L. ZPMC QC Mr. Lv Li Qing was monitoring this

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

welding operation. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-3G (3F)-Fcm-Repair-1. Weld repair report identified as B-WR18557.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 037996 performing the Shielded Metal Arc Welding process on weld 069 located at PCMK SEG3007E. 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 qualified welder 070006 performing the Shielded Metal Arc Welding process on weld 060 located at PCMK SEG3007E. 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 qualified welder 068097 performing the Shielded Metal Arc Welding process on weld 268 located at PCMK SEG3009C. ZPMC QC Mr. Zhong Yang Gang was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2112-Fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067571 performing the Shielded Metal Arc Welding process on weld 231 located at PCMK SEG3011E. ZPMC QC Mr. Zhong Yang Gang was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2114-Fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066255 performing the Shielded Metal Arc Welding process on weld 002 located at PCMK SEG3009V. ZPMC QC Mr. Zong 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. Weld repair report identified as B-WR19750.

OBG 14EAST

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 070432 performing the Shielded Metal Arc Welding process on weld 037 located at PCMK SEG3019BB. ZPMC QC Mr. Wang Xu 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 037998 performing the Shielded Metal Arc Welding process on weld 081 located at PCMK SEG3019BB. ZPMC QC Mr. Wang Xu 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 058102 performing the Shielded Metal Arc Welding process on weld 103 located at PCMK SEG3019BB. ZPMC QC Mr. Wang Xu was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2212-Tc-u4b-Fcm-1.

WELDING INSPECTION REPORT

(Continued Page 3 of 4)

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067656 performing the Shielded Metal Arc Welding process on weld 125 located at PCMK SEG3019BB. ZPMC QC Mr. Wang Xu 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 069683 performing the Shielded Metal Arc Welding process on weld 002 located at PCMK SEG3019AL. 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 037722 performing the Shielded Metal Arc Welding process on weld 003 located at PCMK SEG3019AL. 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 068501 performing the Flux Cored Arc Welding process on weld 037 located at PCMK SEG3019M. 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.

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.

Inspected By: Utekar, Shrikant

Quality Assurance Inspector

WELDING INSPECTION REPORT

(Continued Page 4 of 4)

Reviewed By: Patterson,Rodney

QA Reviewer