

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-019248**Date Inspected:** 15-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

MAGNETIC PARTICLE TESTING

ZPMC NWIT No: 08175

This QA Inspector performed Magnetic Particle Testing (MT) of approximately 15% of the length previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an (MT) report on this date. The members are identified as OBG 13AE. The weld designations are as follows:

SEG3007T-085, 086, 087, 095, 096; SEG3007D-204, 205; SEG3007T-108A, 107A; SEG3007AC-020, 021, 022, 023, 024; SEG3007B-042, 036, 018, 012; SEG3007C-006, 012, 030, 036; SEG3007B-120; SEG3007D-161, 162; SEG3007B-080; SEG3007C-194, 229; SEG3007E-201, 203; SEG3007D-171, 172

This QA Inspector randomly observed the following work in progress.

OBG 14EAST

WELDING INSPECTION REPORT

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This Quality Assurance (QA) Inspector observed ZPMC qualified welder 201087 performing the Shielded Metal Arc Welding process on weld 191 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-345-SMAW-2G (2F)-Fcm-Repair-1. Critical weld repair report identified as B-CWR2737.

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. Wang Xu was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G (2F)-Fcm-Repair-1. Critical weld repair report identified as B-CWR2737.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 070007 performing the Shielded Metal Arc Welding process on weld 059 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-345-SMAW-2G (2F)-Fcm-Repair-1. Critical weld repair report identified as B-CWR2737.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 044772 performing the Shielded Metal Arc Welding process on weld 001 located at PCMK SEG3019K-1. ZPMC QC Mr. Wang Xu was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G (2F)-Fcm-Repair-1. Critical weld repair report identified as B-CWR2737.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 068501 performing the Flux Cored Arc Welding process on weld 158 located at PCMK SEG3019E-2. ZPMC QC Mr. Wang Xu was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2231-ESAB

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067764 performing the Shielded Metal Arc Welding process on weld 031 located at PCMK SEG3019Z. ZPMC QC Mr. Wang Xu 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 044830 performing the Flux Cored Arc Welding process on weld 165 located at PCMK SEG3019E-2. ZPMC QC Mr. Wang Xu was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2231-ESAB.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 21805 performing the Flux Cored Arc Welding process on weld 100 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-T-2233-ESAB.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066471 performing the Flux Cored Arc Welding process on weld 190 located at PCMK SEG3019Q-2. ZPMC QC Mr. Wang Xu 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 066471 performing the Flux Cored Arc Welding process on weld 188 located at PCMK SEG3019Q-2. 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.

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This QA Inspector observed ZPMC personnel performing Ultrasonic testing for repair areas of the weld between SA3324 and LD3040. Weld number identified as SEG3019K-1-002.

OBG 13CE

This Quality Assurance (QA) Inspector observed ZPMC personnel performing heat straightening, member identified as side plate (DP3104). Distortion appeared to be caused by welding. ZPMC Quality Control (QC) inspector identified as Mr. Lv Li Qing was present to monitor the heat straightening process. The heat straightening appeared to comply with heat straightening Report HSR1 (B)-451.

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
Reviewed By:	Patterson,Rodney	QA Reviewer
