

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-019406**Date Inspected:** 18-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

This QA Inspector randomly observed the following work in progress.

OBG 14EAST

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-B-345-SMAW-2G (2F)-Fcm-Repair-1. Critical weld repair report identified as B-CWR2737.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 043661 performing the Shielded Metal Arc Welding process on weld 123 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 070006 performing the Flux Cored Arc Welding process on weld 151 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 068501 performing the Flux Cored Arc Welding process on weld 040 located at PCMK SEG3019W. 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 002 located at PCMK SEG3019AA. 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 217805 performing the Flux Cored Arc Welding process on weld 114 located at PCMK SEG3019AT. 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 037996 performing the Shielded Metal Arc Welding process on weld 090 located at PCMK SEG3019L-1. ZPMC QC Mr. Wang Xu was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-3G (3F)-Fcm-Repair-1. Critical weld repair report identified as B-CWR2646.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 044772 performing the Shielded Metal Arc Welding process on weld 085 located at PCMK SEG3019L-1. ZPMC QC Mr. Wang Xu was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-3G (3F)-Fcm-Repair-1. Critical weld repair report identified as B-CWR2645.

During the random visual inspection of the OBG segment 14 east, this QA Inspector observed various linear indications back gouged area of the weld between EP3027 and FB3265, weld number identified as EP3027-001-108, this QA Inspector informed to ZPMC CWI, ABF QA and lead QA (CT), ABF QA performed magnetic particle inspection and removed all linear indication.

OBG 13CE

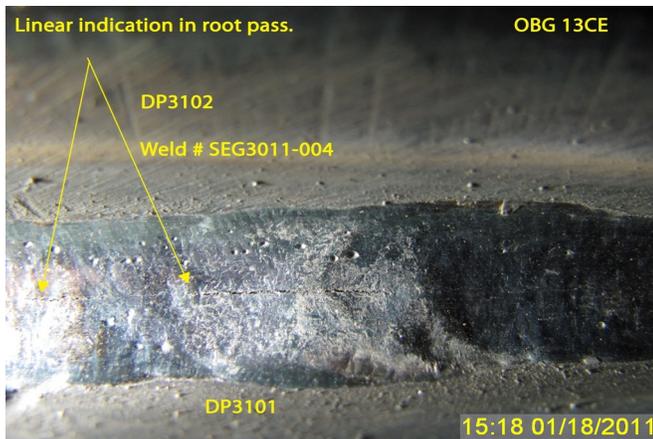
During the random visual inspection of the OBG segment 13CE, this QA Inspector observed various linear indications in the root pass of the deck panel splice weld between DP3101 and DP3102. Weld number identified as SEG3011-004The welding process identified as flux cored arc welding process (ESAB). This QA Inspector informed to ZPMC CWI, ABF QA and lead QA (CT), As per ABF QA and ZPMC CWI ZPMC will perform magnetic particle inspection and remove all linear indication before welding another pass.

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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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
