

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-019714**Date Inspected:** 25-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: 08284

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:

SEG3007B-251, 249, 247, 245, 243, 241, 239, 237, 235, 233, 231, 229

SEG3007F-093, 091, 090, 089, 088, 087, 086, 085, 084

This QA Inspector randomly observed the following work in progress.

OBG 14EAST

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 043661 performing the Shielded Metal

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Arc Welding process on weld 079 located at PCMK SEG3019BB. ZPMC QC Mr. Xie Ming Feng 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 066882 performing the Flux Cored Arc Welding process on weld 092 located at PCMK SEG3019S. ZPMC QC Mr. Xie Ming Feng 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 195 located at PCMK SEG3019J. ZPMC QC Mr. Xie Ming Feng was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2113-ESAB.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 070006 performing the Shielded Metal Arc Welding process on weld 192 located at PCMK SEG3019E-2. ZPMC QC Mr. Xie Ming Feng 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 066442 performing the Shielded Metal Arc Welding process on weld 058 located at PCMK SEG3019H. ZPMC QC Mr. Xie Ming Feng was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2213-B-u2-Fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 070007 performing the Shielded Metal Arc Welding process on weld 007 located at PCMK SEG3019H. ZPMC QC Mr. Xie Ming Feng was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2213-B-u2-Fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 068501 performing the Flux Cored Arc Welding process on weld 284 located at PCMK SEG3019L. ZPMC QC Mr. Xie Ming Feng 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 044772 performing the Shielded Metal Arc Welding process on weld 038 located at PCMK SEG3019F. ZPMC QC Mr. Xie Ming Feng was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2212-B-u2-Fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 044830 performing the Flux Cored Arc Welding process on weld 179 located at PCMK SEG3019D-1. ZPMC QC Mr. Xie Ming Feng was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-345-FCAW-3G (3F)-ESAB-Repair-Fcm. Critical weld repair report identified as B-CWR2745.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066443 performing the Shielded Metal Arc Welding process on weld 025 located at PCMK SEG3019AA. ZPMC QC Mr. Xie Ming Feng was monitoring this welding operation. The welding variables recorded by QC appeared to comply with

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

WPS-345-SMAW-2G (2F)-Fcm-Repair-1. Weld repair report identified as B-WR19728.

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
