

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-021351**Date Inspected:** 09-Feb-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: 08321

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 13CE. The weld designations are as follows:

SEG3011J-239~247, 417~421, 302, 303, 422~433, 236, 238, 219

This QA Inspector randomly observed the following work in progress.

OBG 14EAST

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066418 performing the Shielded Metal

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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 066422 performing the Shielded Metal Arc Welding process on weld 010 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-345-SMAW-3G (3F)-Fcm-Repair-1. Critical weld repair report identified as B-CWR2775.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066733 performing the Flux Cored Arc Welding process on weld 153 located at PCMK SEG3019H. 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 066763 performing the Flux Cored Arc Welding process on weld 047 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 067877 performing the Flux Cored Arc Welding process on weld 025 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 067079 performing the Flux Cored Arc Welding process on weld 091 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 068097 performing the Shielded Metal Arc Welding process on weld 055 located at PCMK SEG3019L. 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.

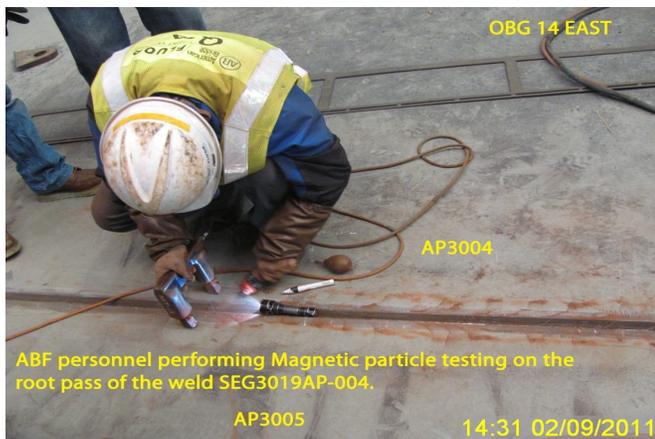
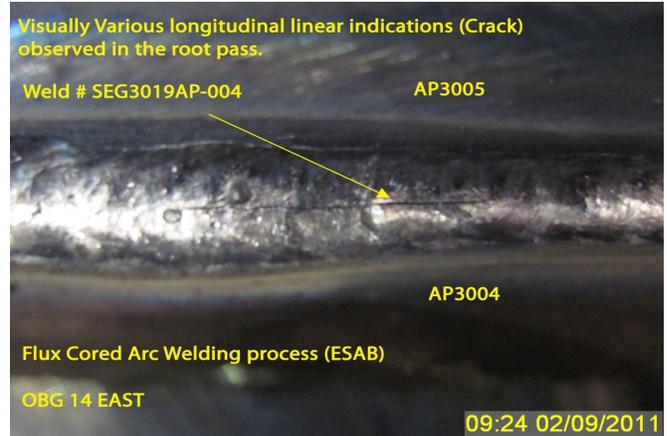
This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066179 performing the Shielded Metal Arc Welding process on weld 073 located at PCMK SEG3019L. ZPMC QC Mr. Wang Xu was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2114-Fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 052696 performing the Flux Cored Arc Welding process for the root pass on weld 004 located at PCMK SEG3019AP. This QA Inspector visually observed various longitudinal linear indications (Crack) in the root pass of this weld. ZPMC QC Mr. Wang Xu was monitoring this welding operation. This QA Inspector informed to ABF QA, ZPMC QC, and QA lead (CT) regarding this issue, as per ABF QA they will be perform magnetic particle testing on the root pass prior to welding another weld pass and removed all linear indication. This QA Inspector observed ABF personnel performed magnetic particle testing on the root pass of this weld see attached photos for additional detail.

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