

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-023105**Date Inspected:** 12-Apr-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:** Gang Wei**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:

TRIAL ASSEMBLY YARD

ULTRASONIC TESTING

ABF Report No: UT-13E-019

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a separate data sheet that Caltrans QA generates after performing a joint inspection with ABF ultrasonic testing personnel. The location of the inspection was identified as the weld between side plate and bottom plate of OBG segment 13AE. The weld designations were as follows:

SEG3007AC-013~019

BAY # 14

This QA Inspector randomly observed the following work in progress.

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OBG 14EAST

SHIELDED METAL ARC WELDING PROCESS.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 044779 performing the Shielded Metal Arc Welding process on weld 003 located at PCMK SEG3019M. ZPMC QC Mr. Zhu Yuan Yuan 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 067571 performing the Shielded Metal Arc Welding process on weld 004 located at PCMK SEG3019*. ZPMC QC Mr. Zhu Yuan Yuan was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-B-u2-Fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066418 performing the Shielded Metal Arc Welding process on weld 365 located at PCMK DP3167-001. ZPMC QC Mr. Zhu Yuan Yuan was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2213-Tc-u4b-Fcm-1.

FLUX CORED ARC WELDING PROCESS.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067079 performing the Flux Cored Arc Welding process on weld 103 located at PCMK SEG3019Q-1. ZPMC QC Mr. Zhu Yuan Yuan 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 066163 performing the Flux Cored Arc Welding process on weld 044 located at PCMK SEG3019L. ZPMC QC Mr. Zhu Yuan Yuan 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 010 located at PCMK SEG3019D-1. ZPMC QC Mr. Zhu Yuan Yuan was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066733 performing the Flux Cored Arc Welding process on weld 013 located at PCMK SEG3019F. ZPMC QC Mr. Zhu Yuan Yuan was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-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

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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:	Peterson,Art	QA Reviewer
