

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-024340**Date Inspected:** 04-Jun-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:** Lu Hua Jie**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

OBG 14 EAST

ZPMC NWIT No: 09356

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 14East. The weld designations are as follows:

SEG3019J-261, 007, 095, 096

SEG3019G-038, 089, 203, 204

SEG3019F-089, 206, 207, 038

SEG3019H-071, 067, 068, 058

SEG3019C-106, 121, 124

SEG3019B-110, 115, 116

WELDING INSPECTION REPORT

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This QA Inspector randomly observed the following work in progress.

OBG 14 EAST

SHIELDED METAL ARC WELDING PROCESS

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 044779 performing the Shielded Metal Arc Welding process on weld 060 located at PCMK SEG3019J. 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-Tc-u4b-Fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 216086 performing the Shielded Metal Arc Welding process on weld 068 located at PCMK SEG3019J. ZPMC QC Mr. Zhu Yuan Yuan was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-22142-Tc-u4b-Fcm-1.

OBG 14 EAST

OBG 14 WEST

This QA Inspector performed a visual verification inspection with an ABF QA Inspector to verify the match drilled hole location between the splice plate and the top anchorage plate. During the verification inspection, this QA Inspector observed that ZPMC personnel did not drill all the holes at the required locations due to accessibility and drilled holes at locations that were not required to be drilled. This QA Inspector also observed ZPMC personnel drilled some holes through a weld that required to be repaired. This QA Inspector submitted the result to the QA Lead Inspector for review and disposition.

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
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Reviewed By:	Peterson,Art	QA Reviewer
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