

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-005478**Date Inspected:** 19-Feb-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Huang Li, Chen Shouhua**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:** TOWER COMPONENT**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance(QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

In process Inspection

Bay #011

This QA Inspector randomly observed ZPMC welding personnel performing groove welding of weld joint WSD1-SA209D/D-25/26 of lift -2 west side skin D for filler passes. The personnel were observed welding in the horizontal position utilizing a FCAW process. Welders are identified as 067103,066477,067501&066164. The welding variables recorded by QC appeared to comply with the WPS- B – T – 2332-TC-P5 – F.

This QA Inspector randomly observed ZPMC welding personnel performing groove welding of weld joint ESD1-FCSA3-2B/C-2B,6,8B(PJP and CJP joint) for filler passes. The personnel were observed welding in the 1G position utilizing a SAW process. Welders are identified as 042195&062046. The welding variables recorded by QC appeared to comply with the WPS- B – T – 2221-B-U3C-S2 AND WPS-B-T-2321-B-P3-S2.

This QA Inspector randomly observed ZPMC welding personnel performing groove welding of weld joint ESD1-FCSA3-2A/C-5A and ESD1-FCSA3-2B/C-1&3A (PJP and CJP joint) for filler passes. The personnel were observed welding in the 1G position utilizing a SAW process. Welders are identified as 040634 &040741. The welding variables recorded by QC appeared to comply with the WPS- B – T – 2221-B-U3C-S2 AND

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WPS-B-T-2321-B-P3-S2.

This QA Inspector randomly observed ZPMC welding personnel performing groove welding of weld joint NSD1-SA163A/D-17/18 of lift -2 north side skin B to B1 for filler passes. The personnel were observed welding in the horizontal position utilizing a FCAW process. Welders are identified as 066751&052075. The welding variables recorded by QC appeared to comply with the WPS- B – T – 2332-TC-P5 – F.

Bay #7

Ultrasonic Testing

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as ESD1-FDSA3-2B/C-8A/B,12A/B,14A/B
SSD1-FASA3-1A/E-4A/B
ND1-A468-43M-2-7A/B,12A/B,21A/B&22A/B

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

Summary of Conversations:

No relevant conversations

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 Serge Sinevod 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By:	Bera,Subhasis	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
