

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-006244**Date Inspected:** 07-Apr-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:** Liu 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 components**Summary of Items Observed:**

On the date CALTRANS OSM Quality Assurance (QA) Inspector, Dilip Chakrabarti was present during the times noted above for observations relative to the work being performed.

Bay# 6-OBG Assembly

This QA Inspector randomly observed the following work in progress:

Magnetic Particle Testing:

For Green Tag:

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6028 MT report on this date.

The member and the weld designations are as follows:

Sl #	Section #	Weld #	Green Tag #	Location
1.	SP 780-001	013,014,015,017	006045	11AW
2.	BP 201-008	001,002	006037	7 D
3.	SP 559-001	049	006039	11DE
4.	SP 203-008	004,006,008	006038	7 D
5.	SP 207-007	02,03R,04,06,08R	006028	7 B
6.	SP 504-001	049	006031	11 BW
7.	SP 556-001	036	006032	11 BE

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8. SP 556-001 014 006030 11 BE

9. SP 636-001 038 006029 11 BE

Ultrasonic Testing:

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6027 UT report on this date.

The member and the weld designations are as follows:

Sl # Section # Weld # Green Tag # Location

1. SP 207-007 30,31,34,51,52 006028 7 B

Bay# 6-Tower Assembly

This QA Inspector randomly observed the following work in progress:

FCAW Process:

Welding of weld joints# 6A&3B located on PCMK WSD1 DPSA4-15. Welder is identified as 053609. ZPMC QC is identified as Yang Ming Ming. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2233-B-U3-F.

Welding of weld joints# 8B&3B located on PCMK ESD1 DPSA4-15. Welder is identified as 019006. ZPMC QC is identified as Yang Ming Ming. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2233-B-U3-F.

Bay # 7-OBG Assembly:

This QA Inspector randomly observed the following work in progress:

FCAW Process:

Welding of weld joints# 1&2 located on PCMK SP 204-008. Welder is identified as 054459. ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2132- 3.

Welding of weld joints# 5&6 located on PCMK SP204-008. Welder is identified as 205774. ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2132- 3.

Welding of weld joints# 9&10 located on PCMK SP204-008. Welder is identified as 062447. ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2132- 3.

Bay# 5-OBG Assembly

This QA Inspector randomly observed the following work in progress:

Magnetic Particle Testing:

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For Green Tag:

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6028 MT report on this date.

The member and the weld designations are as follows:

SI # Section # Weld # Green Tag # Location

1. CB 202E-006 002A/B, 003A/B NA NA

Ultrasonic Testing:

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6027 UT report on this date.

The member and the weld designations are as follows:

SI # Section # Weld # Green Tag # Location

1. CB 202E-006 001,002,003 NA NA

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

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 Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Chakrabarti,Dilip Kumar	Quality Assurance Inspector
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Reviewed By:	Clifford,William	QA Reviewer
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