

**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-006488**Date Inspected:** 25-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:** Huang Wen pang**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 COMPONENT**Summary of Items Observed:**

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

Bay 03

## 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 OBG Components. The weld designations reviewed are as follows:

FB016 – 047 – 026

FB016 – 044 – 026

FB016 – 046 – 026

SSD14 – PP077 – 137

FB003 – 157 – 08; 20

SSD16A – PP074 – 131

FB003 – 142 – 32; 44

## Magnetic Particle Testing

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows:

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FB003 – 157 – 35; 36; 47; 48  
FB003 – 142 – 11; 12; 23; 24  
CW001B – PP044 – 004 ~ 023  
CW001B – PP032 – 004 ~ 023

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint 126 located on FB027 - 007. Welder is identified as 044790. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – u4b – F.

FCAW process welding of weld joint 100 located on CSD03 – PP070. Welder is identified as 204338. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

Bay 02

### Green Tags

The following green tags issued for OBG components after completing the NDT requirements are:

CA031 – 015 ~ 020 – Green Tag # 006873  
CA031 – 027 ~ 032 – Green Tag # 006870  
CA031 – 039 ~ 044 – Green Tag # 006871  
CA031 – 051 ~ 056 – Green Tag # 006872  
CA032 – 015 ~ 020 – Green Tag # 006873  
CA032 – 027 ~ 032 – Green Tag # 006874  
CA032 – 039 ~ 044 – Green Tag # 006875  
CA032 – 051 ~ 056 – Green Tag # 006876  
CA035 – 019 ~ 024 – Green Tag # 007248  
CA035 – 031 ~ 036 – Green Tag # 007249  
CA035 – 067 ~ 072 – Green Tag # 007252  
CA035 – 079 ~ 084 – Green Tag # 007253  
CA037 – 019 ~ 024 – Green Tag # 007254  
CA037 – 031 ~ 036 – Green Tag # 007255  
CA037 – 043 ~ 048 – Green Tag # 007256  
CA037 – 055 ~ 060 – Green Tag # 007257  
CA037 – 079 ~ 084 – Green Tag # 007259  
CA038 – 019 ~ 024 – Green Tag # 007260  
CA038 – 031 ~ 036 – Green Tag # 007261  
CA038 – 043 ~ 048 – Green Tag # 007262  
CA038 – 055 ~ 060 – Green Tag # 007263  
CA038 – 067 ~ 072 – Green Tag # 007264  
CA038 – 079 ~ 084 – Green Tag # 007265  
CA041 – 019 ~ 024 – Green Tag # 007266  
CA041 – 031 ~ 036 – Green Tag # 007267  
CA041 – 043 ~ 048 – Green Tag # 007268  
CA041 – 055 ~ 060 – Green Tag # 007269  
CA043 – 019 ~ 024 – Green Tag # 007272  
CA043 – 031 ~ 036 – Green Tag # 007273

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CA043 – 043 ~ 048 – Green Tag # 007274  
CA043 – 055 ~ 060 – Green Tag # 007275  
CA043 – 067 ~ 072 – Green Tag # 007276  
CA043 – 079 ~ 084 – Green Tag # 007277  
CA044 – 019 ~ 024 – Green Tag # 007278  
CA044 – 031 ~ 036 – Green Tag # 007279  
CA044 – 043 ~ 048 – Green Tag # 007280  
CA044 – 055 ~ 060 – Green Tag # 007281  
CA044 – 067 ~ 072 – Green Tag # 007282  
CA044 – 079 ~ 084 – Green Tag # 007283  
SSD14/14A – PP077 – Green Tag # 006644  
FB003 – 157 – Green Tag # 006644  
FB006 – 144 – Green Tag # 006644  
FB004 – 030 – Green Tag # 006644  
SSD16/16A – PP074 – Green Tag # 006645  
FB003 – 142 – Green Tag # 006645  
FB006 – 158 – Green Tag # 006645  
FB014 – 030 – Green Tag # 006645

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 Eric Tsang - 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Kumar,Sandeep	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

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