

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:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-007587**Date Inspected:** 30-Jun-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: Xu Xian Ping
Inspected CWI report: Yes No N/A
Electrode to specification: Yes No N/A
Qualified Welders: Yes No N/A
Approved Drawings: Yes No N/A

CWI Present: Yes No
Rod Oven in Use: Yes No N/A
Weld Procedures Followed: Yes No N/A
Verified Joint Fit-up: Yes No N/A
Approved WPS: Yes No N/A
Delayed / Cancelled: Yes No N/A

Bridge No: 34-0006**Component:** OBG and TOWER Components**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 1

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #002 located on Counter Weight CW001B – PP54. Welder is identified as 251246. ZPMC QC is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

SAW process welding of weld joint #003 located on Cross Beam CB201C – 007. Welder is identified as 207345. ZPMC QC is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2221 – B – L2c – S – 2.

BAY 2

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #012 located on Longitudinal Diaphragm LD004-047. Welder is identified as 206358. ZPMC QC is identified as Wang Liang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – Tc – P4 – F.

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FCAW process welding of weld joint #006 located on Longitudinal Diaphragm LD009-007. Welder is identified as 215676. ZPMC QC is identified as Wang Liang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

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 member is identified as OBG Component. The weld designations reviewed are as follows:

7. FB003 – 172 – 032; 044
8. SSD17 – PP093 – 006
9. FB003 – 167 – 008; 020
10. SSD18 – PP088 – 006
11. FB003 – 168 – 008; 032
12. SSD18 – PP094 – 006

BAY 3

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:

1. CB202C – 010 – 001; 002
2. CB202E – 010 – 001; 002; 003

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #003 located on Floor Beam FB009-033. Welder is identified as 204338. ZPMC QC is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

FCAW process welding of weld joint #021 located on Floor Beam FB028-011. Welder is identified as 066746. ZPMC QC is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2233 – B – U2 - F.

BAY 5

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 member is identified as OBG Component. The weld designations reviewed are as follows:

1. BK001 – 018 – 001; 003; 046 – Green Tag # 008526
2. BK001 – 017 – 001; 003; 046 – Green Tag # 008527
3. BK001 – 016 – 001; 003; 046 – Green Tag # 008528
4. BK001 – 015 – 001; 003; 046 – Green Tag # 008529

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5. BK001 – 013 – 001; 003; 046 – Green Tag # 008530
6. BK001 – 012 – 001; 003; 046 – Green Tag # 008531
7. TR1C – PP018 – 005; 006 – Green Tag # 008532
8. TR1D – PP015 – 007; 008 – Green Tag # 008532

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:

1. TR1E – PP014 – 010
2. TR1C – PP018 – 005; 006
3. TR1D – PP015 – 008

BAY 6

This QA Inspector observed the following work in progress:

SAW process welding of weld joint #001 – 1A located on ND1 – SA658 – 77M. Welder is identified as 054458. ZPMC QC is identified as Wang Xiao Bing. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3221 – TC – U5 – S – 1.

SMAW process welding of weld joint #16 located on NSD1 – DPSA4 – 03B/B. Welder is identified as 066456. ZPMC QC is identified as Zhang Bao Bo. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3312 – Tc – P5.

SMAW process welding of weld joint #01 – 1B located on NSD1 – SA658 – 53M. Welder is identified as 037780. ZPMC QC is identified as Wang Xiao Bing. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3211 – Tc – U5b – 1.

SMAW process welding of weld joint #17 located on NSD1 – DPSA4 – 03B/B. Welder is identified as 037779. ZPMC QC is identified as Zhang Bao Bo. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3312 – Tc – P5.

SMAW process welding of weld joint #15 – 1B located on NSD1 – SA658 – 65M. Welder is identified as 067588. ZPMC QC is identified as Wang Xiao Bing. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3211 – Tc – U5b – 1.

SAW process welding of weld joint #009 – 1A located on ND1 – SA658 – 77M. Welder is identified as 046830. ZPMC QC is identified as Wang Xiao Bing. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3221 – TC – U5 – S – 1.

SMAW process welding of weld joint #15 – 1B located on NSD1 – SA658 – 65M. Welder is identified as 069894. ZPMC QC is identified as Wang Xiao Bing. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3211 – Tc – U5b – 1.

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FCAW process welding of weld joint #002 located on Cross Beam CB0202F – 009. Welder is identified as 048625. ZPMC QC is identified as Huang Min. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – B – U2 – F – 1.

BAY 7

This QA Inspector observed the following work in progress:

SMAW process welding of weld joint #061 located on SP3014 – 001. Welder is identified as 250833. ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2112.

SMAW process welding of weld joint #041 located on SP3014 – 001. Welder is identified as 051019. ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2112 (FCM) – 1.

FCAW process welding of weld joint #013 located on SP3018 – 001. Welder is identified as 054459. ZPMC QC (CWI) is identified as Xu Xian Ping. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

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.

Inspected By:	Kumar,Sandeep	Quality Assurance Inspector
Reviewed By:	Prue,Erik	QA Reviewer
