

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-008472**Date Inspected:** 14-Aug-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 & 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 6**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. BP3003 - 001 - 067~114; 117~128
2. SP3055 - 001 - 037~056; 076~096

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:

1. BP3003 - 001 - 015; 017; 029; 037 – Green Tag # 009390
2. SP3055 - 001 - 005; 065; 067; 069 – Green Tag # 009389
3. CB202C - 009 - 001

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This QA Inspector observed the following work in progress:

SAW process welding of weld joint #003 located on Cross Beam CB202C – 009. Welder is identified as 054458. ZPMC QC is identified as Huang Min. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2221 – B – L2c – S – 2.

SMAW process welding of weld joint #1A located on WD1 – A305 – 77M – 3. Welder is identified as 066457. ZPMC QC is identified as Wang Xiao Bing. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3212 – Tc – U5b – 1.

SAW process welding of weld joint #004 located on Cross Beam CB202C – 009. Welder is identified as 054458. ZPMC QC is identified as Huang Min. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2221 – B – L2c – S – 2.

SMAW process welding of weld joint #7B located on WD1 – A305 – 77M – 3. Welder is identified as 066457. ZPMC QC is identified as Wang Xiao Bing. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3212 – Tc – U5b – 1.

BAY 7

This QA Inspector observed the following work in progress:

FCAW process tack welding of weld joint #025 located on Deck Panel DP3011 – 001. Welder is identified as 250489. ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – B – U2 – F – 1.

FCAW process welding of weld joint #025 located on Edge Plate EP3010 – 001. Welder is identified as 053609. ZPMC QC is identified as Zhou Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

FCAW process tack welding of weld joint #061 located on Deck Panel DP3011 – 001. Welder is identified as 250489. ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – B – U2 – F – 1.

FCAW process welding of weld joint #023 located on Edge Plate EP3004 – 001. Welder is identified as 051246. ZPMC QC is identified as Zhou Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

BAY 8

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #001 located on Floor Beam FB204 – 037. Welder is identified as 066687. ZPMC QC is identified as Zhang Jing Xin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

SAW process welding of weld joint #002 located on Cross Beam CB202B – 013. Welder is identified as 207463.

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ZPMC QC is identified as Zhang Jing Xin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2221 – B – L2c – S – 2.

FCAW process welding of weld joint #068 located on Floor Beam FB204 – 038. Welder is identified as 066687. ZPMC QC is identified as Zhang Jing Xin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

BAY 10

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 TOWER Components. The weld designations reviewed are as follows:

SOUTH TOWER – LIFT4 – DOUBLE PLATE WITH SKIN – E

Green Tag for the component - 8401

SSD1 – FESA4 – 1B/F – 007; 009; 016; 018

SSD1 – FESA4 – 1C/F – 003; 005; 012; 013

SSD1 – FESA4 – 1D/F – 003; 005

SSD1 – FESA4 – 1E/F – 003; 005

BAY 11

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 TOWER Components. The weld designations reviewed are as follows:

WEST TOWER – LIFT 1 – D/E – CORNER INSIDE

Green Tag for the component - 8249

WSD1 – A423B/H – 2A

WSD1 – A115E/J – 24B

WEST TOWER – LIFT 1 – D/E – CORNER OUTSIDE (SUPPORT RING)

Green Tag for the component - 8249

WSD1 – A234B/H – 2B

WSD1 – A115E/J – 24A

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

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

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