

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-008618**Date Inspected:** 10-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wu Zhi Chen**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**Summary of Items Observed:**

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

TRIAL ASSEMBLY YARD

OBG segment 1AE

Magnetic Particle Inspection

This Q.A Inspector performed Magnetic Particle Testing of approximately 15% of the area previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated a (MT) report for this date. The members are identified as the OBG segment 1AE the welds Designation are as follows.

SEG004D-27, 28, 51, 52

LD025-001-62, 63, 36, 37, 32, 33, 58, 59, 26, 27, 52, 53

LD026-001-26, 27, 52, 53, 32, 33, 64, 65, 45, 46, 71, 72

FB085-001-28, 29

FB086-001-28, 29

This QA Inspector randomly observed the following work in progress.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

OBG SEGMENT-1AAW-1AW&1AAE-1AE

FCAW welding process of weld joint 553 located on PCMK SEG1E. Welder is identified as 053609 ZPMC QC is identified as Chen Bo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U3-F.

FCAW welding process of weld joint 560 located on PCMK SEG1E. Welder is identified as 048801 ZPMC QC is identified as Chen Bo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U3-F.

FCAW welding process of weld joint 579 located on PCMK SEG2E. Welder is identified as 220066ZPMC QC is identified as Chen Bo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U3-F.

FCAW welding process of weld joint 562 located on PCMK SEG2E. Welder is identified as 062708 ZPMC QC is identified as Chen Bo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U3-F.

FCAW welding process of weld joint 050 located on PCMK SEG004B. Welder is identified as 050316 ZPMC QC is identified as Chen Bo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U3-F.

FCAW welding process of weld joint 050 located on PCMK SEG004C. Welder is identified as 045280 ZPMC QC is identified as Chen Bo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U3-F.

Unless otherwise noted, all work observed on this dated 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 + (86) 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Utekar,Shrikant	Quality Assurance Inspector
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Reviewed By:	Clifford,William	QA Reviewer
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