

**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-008731**Date Inspected:** 16-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**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 & 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 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. LD002 – 039 – 011
2. CB202A – 010 – 008; 019
3. SP203 – 010 – 024; 031
4. SP206 – 010 – 020; 035
5. CB202G – 025 – 141; 142; 159; 160; 169; 170
6. CB202G – 026 – 141; 142; 159; 160; 169; 170
7. CB202G – 027 – 141; 142; 159; 160; 169; 170
8. CB202G – 028 – 141; 142; 159; 160; 169; 170
9. FB003 – 195 – 032; 044

**Ultrasonic Testing**

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC

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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. SSD20 – PP103 – 137
2. FB003 – 195 – 032; 044

## Green Tags

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

1. LD002 – 039 – 011 – Green Tag # 010129
2. SSD20/20A-PP103-{FB003 – 195; FB006 – 193; FB013 – 040} – Green Tag # 009983
3. SSD14/14A-PP103-{FB003 – 186; FB006 – 203; FB004 – 043} – Green Tag # 007982

## BAY 5

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #012 located on Traveler Rail TR2F – PP11. Welder is identified as 204342.

ZPMC QC is identified as Xu Hong Min. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – Tc – U4c – F – 1.

FCAW process welding of weld joint #004 located on Traveler Rail TR4B – PP09. Welder is identified as 204342.

ZPMC QC is identified as Xu Hong Min. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2233 – Tc – U4c – F.

## 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. CB202C – 009 – 001

This QA Inspector observed the following work in progress:

SMAW process welding of weld joint #7A located on WD1 – A305 – 65M – 3. 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 – 3212 – Tc – U5b – 1.

SMAW process welding of weld joint #9A located on WD1 – A305 – 65M – 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 – 2112 – Tc – U5b – 1.

SMAW process welding of weld joint #1B located on WD1 – A305 – 65M – 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

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## WELDING INSPECTION REPORT

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This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #001 located on Edge Plate EP3008 – 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 welding of weld joint #004 located on Edge Plate EP3002 – 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.

FCAW process welding of weld joint #005 located on Edge Plate EP3003 – 001. Welder is identified as 22239. 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 welding of weld joint #004 located on Edge Plate EP3008 – 001. Welder is identified as 209554. 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 welding of weld joint #012 located on Edge Plate EP3003 – 001. Welder is identified as 205774. 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 #002 located on Cross Beam CB202C – 012. Welder is identified as 069118. ZPMC QC is identified as Zhang Jing Xin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – B – U2 – F.

SAW process welding of weld joint #003 located on Cross Beam CB202C – 013. Welder is identified as 207463. 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.

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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**Inspected By:** Kumar,Sandeep

Quality Assurance Inspector

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**Reviewed By:** Prue,Erik

QA Reviewer