

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-009143**Date Inspected:** 12-Sep-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:** Chen Xi**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 Components**Summary of Items Observed:**

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

This QA inspector witnessed Magnetic particle testing on CB-007 welds performed by ZPMC QC. ZPMC QC found total nine (9) linear indications in 10% magnetic particle testing. The defective welds are listed below. ZPMC QC increase inspection percentage up to 100%. For further information, please see attached pictures.

CB201G-013-088, 084, 087, 085, 108 and CB201G-014-049, 051, 052, 050

This QA inspector observed the following work in progress:

Bay#2

Joint fit up verified by SMAW welding of weld joint FB3022-001-044, 006, 011 located on FB3022-001. Welder is identified as 045251 (2F). ZPMC QC-CWI is identified as Zhang Hai Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint FB3082-003-039, 038, 030, 031 located on FB3082-003. Welder is identified as 062438 (2F). ZPMC QC-CWI is identified as Zhang Hai Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint FB3082-002-045, 044 located on FB3082-002. Welder is identified as 045203 (2F). ZPMC QC-CWI is identified as Zhang Hai Feng. The welding variables recorded by QC appeared to comply with

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the Applicable WPS.

Bay#1

FCAW welding of weld joint CB202B-015-004 located on CB-015. Welder is identified as 216872 (1G). ZPMC QC-CWI is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Unless otherwise noted, all observed on this date appeared to generally comply with applicable contract documents.



Item	Description	WBS	Dwg No.	Status
1				

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 150-0042-2372, who represents the Office of Structural Materials for your project.

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Inspected By:	Patel,Hiranch	Quality Assurance Inspector
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Reviewed By:	Prue,Erik	QA Reviewer
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