

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-009879**Date Inspected:** 26-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:** Li zhi jiang**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, D.Sukanthan was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

OBG # BAY 02

Flux Cored Arc Welding Process:

Welding of weld joint -042,043 located on PCMK FB3093-001. Welder is identified as 062438. ZPMC QC is identified as Yang Qing fang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

Welding of weld joint -018,019 located on PCMK FB3012-001. Welder is identified as 045203. ZPMC QC is identified as Yang Qing fang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

Welding of weld joint -021,022 located on PCMK FB3026-001. Welder is identified as 215676. ZPMC QC is identified as Yang Qing fang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

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OBG # BAY 03

Flux Cored Arc Welding Process:

Welding of weld joint –007,008 located on PCMK LD002-047. Welder is identified as 206623. ZPMC QC is identified as Guo yuan ting. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133.

Welding of weld joint –035,036 located on PCMK CSD3-PP101. Welder is identified as 051356. ZPMC QC is identified as Guo yuan ting. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

Welding of weld joint –005 located on PCMK LD016-037. Welder is identified as 208035. ZPMC QC is identified as Guo yuan ting. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

Welding of weld joint –035,036 located on PCMK CA080. Welder is identified as 044790. ZPMC QC is identified as Guo yuan ting. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-TC-U4b-F.

OBG BAY # 02

This QA inspector verified that the percentages for QA NDT verification have been completed to date and issued ABF green tags for the following OBG floor beam components.

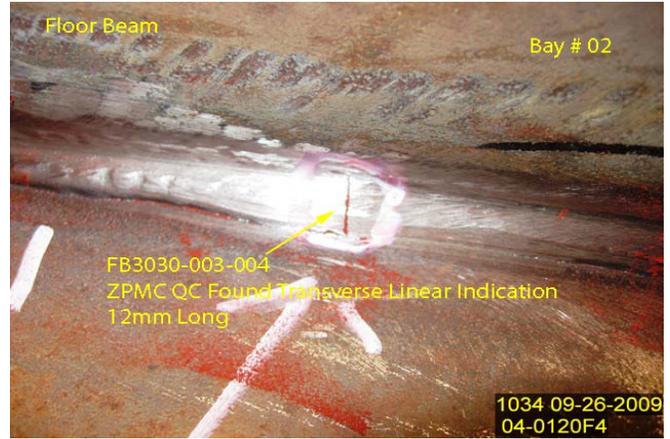
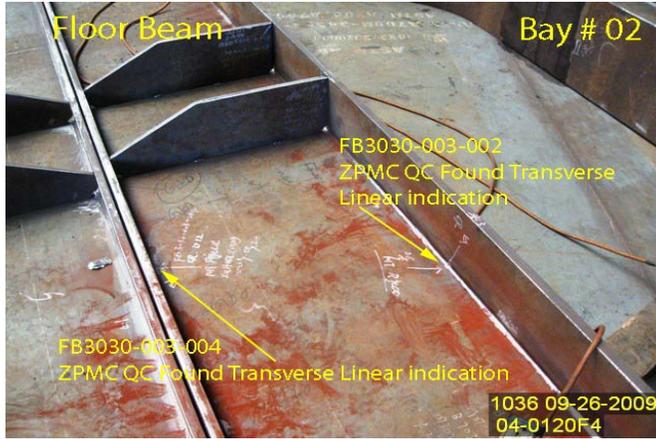
FB3033-001,	Green Tag # 10535.
FB3064-001,	Green Tag # 10542.
FB3034-001,	Green Tag # 10536.
FB3066-001,	Green Tag # 10707.
FB3008-001,	Green Tag # 10533.
FB3067-002,	Green Tag # 10709.
FB3036-001,	Green Tag # 10538.
FB3067-001,	Green Tag # 10708.

During in-process visual inspection of OBG floor beam components in Bay 2, This QA inspector observed that ZPMC QC Magnetic particle Testing(MT)Personnel identified as Mr. Xu Hua Xiang appears to have rejected two (2) transverse linear indications. The weld designation as identified on the material is FB3030-003-004,002. See attached picture.

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

WELDING INSPECTION REPORT

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Summary of Conversations:

As mention above

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 150-00422372, who represents the Office of Structural Materials for your project.

Inspected By: Sukanthan,Dhanasingh

Quality Assurance Inspector

Reviewed By: Hall,Steven

QA Reviewer