

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-009482**Date Inspected:** 10-Oct-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 2

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint # 014 located on Floor Beam FB6502 – 001. Welder is identified as 062438.

ZPMC QC is identified as Zhang Hai Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

FCAW process welding of weld joint # 022 located on Floor Beam FB3100 – 001. Welder is identified as 062438.

ZPMC QC is identified as Zhang Hai Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

FCAW process welding of weld joint # 039 located on Floor Beam FB6502 – 001. Welder is identified as 062438.

ZPMC QC is identified as Zhang Hai Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U4b – F.

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

BAY 3

Green Tags

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

1. CSD6 – PP096 – 095~100 – Green Tag # 10017
2. CSD6 – PP097 – 095~100 – Green Tag # 10018
3. CSD6 – PP095 – 095~100 – Green Tag # 10016
4. CSD6 – PP101 – 095~100 – Green Tag # 10019
5. CSD6 – PP102 – 095~100 – Green Tag # 10020

BAY 5

The following NDT inspection carried out as per the ZPMC submitted Notification No. 004377

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. CB202E – 016 – 001; 002; 003
2. CB202D – 016 – 001; 002

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. CB202E – 016 – 002; 003
2. CB202D – 016 – 002
3. 10TR3 – 006 – 001
4. 10TR3 – 008 – 001
5. 10TR3 – 010 – 001
6. 10TR3 – 011 – 001
7. 10TR3 – 023 – 001
8. 10TR3 – 024 – 001
9. 10TR3 – 025 – 001
10. 10TR3 – 026 – 001
11. 10TR3 – 027 – 001
12. 10TR3 – 028 – 001
13. 10TR3 – 029 – 001
14. 10TR3 – 030 – 001

WELDING INSPECTION REPORT

(Continued Page 3 of 4)

15. 10TR3 – 031 – 001
16. 10TR3 – 032 – 001
17. 10TR3 – 033 – 001
18. 11TR3 – 006 – 001
19. 11TR3 – 007 – 001
20. 11TR3 – 008 – 001
21. 11TR3 – 009 – 001

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint # 008 located on Traveler Rail 10TR3 – 014. Welder is identified as 215689.

ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

FCAW process welding of weld joint # 012 located on Traveler Rail 10TR3 – 014. Welder is identified as 217805.

ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

FCAW process welding of weld joint # 008 located on Traveler Rail 11TR3 – 008. Welder is identified as 215689.

ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

FCAW process welding of weld joint # 012 located on Traveler Rail 11TR3 – 008. Welder is identified as 217805.

ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

BAY 6

Tower

The following NDT inspection carried out as per the ZPMC submitted Notification No. 004378

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 member is identified as TOWER Component. The weld designations reviewed are as follows:

NORTH TOWER LIFT 1 – 127 M DIAPHRAGM – GREEN TAG # 009254

NSD1 – DPSA4 – 3A/B – 3 ~ 8

NSD1 – DPSA4 – 3B/B – 1; 2; 8~11; 14; 15; 18; 19; 26; 27

NSD1 –SA4 – 14 – 3 ~ 8

This QA Inspector observed the following work in progress:

WELDING INSPECTION REPORT

(Continued Page 4 of 4)

SMAW process welding of weld joint #9B located on Tower Strut WD1 – A305 – 53M – 1. Welder is identified as 067707. ZPMC QC is identified as Zhao Chen Sun. The welding variables recorded by QC appeared to comply with the WPS – 345 – SMAW – 2G (2F) – FCM – Repair.

SMAW process welding of weld joint #9A located on Tower Strut WD1 – A305 – 53M – 1. Welder is identified as 067707. ZPMC QC is identified as Zhao Chen Sun. The welding variables recorded by QC appeared to comply with the WPS – 345 – SMAW – 2G (2F) – FCM – Repair.

Cross Beam – 8

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #005 located on Cross Beam CB202A – 008. 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 – 2232 – Tc – U4b – F.

FCAW process welding of weld joint #017 located on Cross Beam CB202A – 008. Welder is identified as 053742. ZPMC QC is identified as Zhou Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U4b – F.

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.

Inspected By:	Kumar,Sandeep	Quality Assurance Inspector
Reviewed By:	Hall,Steven	QA Reviewer
