

**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-009772**Date Inspected:** 28-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 1**

FCAW process welding of weld joint # 127 located on Counter Weight CW001 – PP050. Welder is identified as 219189. ZPMC QC is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2133.

**BAY 2****Green Tags**

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

1. FB3030 – 001 – 001~006; 047~096 – Green Tag # 10721
2. FB3030 – 003 – 001~006; 047~096 – Green Tag # 10723

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint # 065 located on FB3031 – 001. Welder is identified as 062438. ZPMC QC

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

FCAW process welding of weld joint # 135 located on FB3006 – 001. Welder is identified as 045209. ZPMC QC is identified as Zhang Hai Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2133.

FCAW process welding of weld joint # 038 located on FB3031 – 001. Welder is identified as 045203. ZPMC QC is identified as Zhang Hai Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

### BAY 5

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint # 006 located on Traveler Rail 10TR3 – 035. Welder is identified as 215078. ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U5 – F.

FCAW process welding of weld joint # 005 located on Traveler Rail 10TR3 – 010. Welder is identified as 215185. ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U5 – F.

FCAW process welding of weld joint # 009 located on Traveler Rail 10TR1 – 022. Welder is identified as 204342. 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 # 014 located on Traveler Rail 10TR2 – 037. Welder is identified as 068858. ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U5 – F.

FCAW process welding of weld joint # 012 located on Traveler Rail 10TR1 – 025. Welder is identified as 217185. 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

The following NDT inspection carried out as per the ZPMC submitted Notification No. 004500

#### 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. SP3024 – 001 – 054; 056

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2. SP3009 – 001 – 058; 060 – Green Tag # 10623

Tower

This QA Inspector observed the following work in progress:

SMAW process repair welding of weld joint #1A located on Tower Strut WD1 – A305 – 53M – 2. Welder is identified as 048617. ZPMC QC is identified as Zhao Chen Sun. The welding variables recorded by QC appeared to comply with the WPS – 485 – SMAW – 2G (2F) – FCM – Repair – 1.

SMAW process repair welding of weld joint #9B located on Tower Strut WD1 – A305 – 53M – 2. Welder is identified as 048617. 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 repair welding of weld joint #7B located on Tower Strut WD1 – A305 – 53M – 2. Welder is identified as 053753. ZPMC QC is identified as Zhao Chen Sun. The welding variables recorded by QC appeared to comply with the WPS – 485 – SMAW – 2G (2F) – FCM – Repair – 1.

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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<b>Inspected By:</b>	Kumar,Sandeep	Quality Assurance Inspector
<b>Reviewed By:</b>	Hall,Steven	QA Reviewer

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