

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-009975**Date Inspected:** 04-Nov-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

The following NDT inspection carried out as per the ZPMC submitted Notification No. 004548

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. CW001A – PP078 – 001 – Green Tag # 10799
 - a. CW001 – PP078 –131; 132
2. CW001A – PP052 – 001 – Green Tag # 10798
 - a. CW001 – PP052 –131; 132

BAY 2

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Green Tags

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

1. FB3038 – 001 – 001~016; 019~026; 031~036 – Green Tag # 11184
2. FB3042 – 001 – 001~016; 019~023; 026; 031~033; 036; 039 – Green Tag # 11186

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint # 043 located on FB3052 – 001. Welder is identified as 045209. ZPMC QC is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – B – U2 – F.

FCAW process welding of weld joint # 007 located on SEG3004C – PP110. Welder is identified as 045227. ZPMC QC is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2233 – B – U2 – F.

BAY 5

The following NDT inspection carried out as per the ZPMC submitted Notification No. 004542

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. 11TR3 – 001 – 004
2. 11TR3 – 006 – 003
3. 11TR3 – 007 – 004
4. 11TR3 – 008 – 004
5. 11TR3 – 009 – 003
6. 11TR4 – 001 – 004
7. 10TR3 – 022 – 001
8. 11TR1 – 013 – 001
9. 11TR1 – 016 – 002
10. 11TR1 – 023 – 001
11. 11TR1 – 024 – 002
12. 11TR1 – 025 – 002
13. 11TR1 – 026 – 002
14. 11TR1 – 030 – 001

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. 11TR3 – 004 – 003
2. 11TR3 – 020 – 004
3. 11TR3 – 021 – 003

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4. 11TR3 – 022 – 004
5. 11TR3 – 023 – 003
6. 11TR3 – 025 – 004
7. 10TR3 – 022 – 001
8. 11TR1 – 013 – 001
9. 11TR1 – 016 – 002
10. 11TR1 – 023 – 001
11. 11TR1 – 024 – 002
12. 11TR1 – 025 – 002
13. 11TR1 – 026 – 002
14. 11TR1 – 030 – 001

The following NDT inspection carried out as per the ZPMC submitted Notification No. 004544

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. 11TR1 – 005 – 003
2. 11TR1 – 006 – 003
3. 11TR1 – 007 – 003
4. 11TR1 – 009 – 004
5. 11TR1 – 011 – 004
6. 11TR1 – 016 – 003
7. 10TR1 – 017 – 004
8. 11TR2 – 006 – 004
9. 11TR2 – 007 – 004

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. 11TR3 – 004 – 003
2. 11TR3 – 020 – 004
3. 11TR3 – 021 – 003
4. 11TR3 – 022 – 004
5. 11TR3 – 023 – 003
6. 11TR3 – 025 – 004
7. 10TR3 – 022 – 001
8. 11TR1 – 013 – 001
9. 11TR1 – 016 – 002

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint # 014 located on Traveler Rail 11TR3 – 011. Welder is identified as 217185.

ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with

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the WPS – B – T – 2232 – Tc – U5 – F.

FCAW process welding of weld joint # 005 located on Traveler Rail 11TR3 – 005. Welder is identified as 205390.

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 # 014 located on Traveler Rail 10TR3 – 034. Welder is identified as 250353.

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.

BAY 6

Tower

This QA Inspector observed the following work in progress:

SMAW process repair welding of weld joint #10B located on Tower Strut WD1 – A305 – 77M – 3. 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 #7A located on Tower Strut WD1 – A305 – 65M – 3. 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.

SMAW process repair welding of weld joint #10A located on Tower Strut WD1 – A305 – 53M – 4. 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 – 345 – SMAW – 2G (2F) – FCM – Repair.

SMAW process repair welding of weld joint #2A located on Tower Strut WD1 – A305 – 53M – 3. 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.

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:	Hall,Steven	QA Reviewer
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