DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-009977
Date Inspected: 30-Nov-2009

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 645
OSM Departure Time: 1845
Location: Shanghai, China

CWI Name: Xu Xian Ping

	Yes	No	N/A
Inspected CWI report:	☐	☑	☐
Electrode to specification:	☑	☐	☐
Qualified Welders:	☑	☐	☐
Approved Drawings:	☑	☐	☐

	Yes	No	N/A
CWI Present:	☑	☐	
Rod Oven in Use:	☑	☐	☐
Weld Procedures Followed:	☑	☐	☐
Verified Joint Fit-up:	☑	☐	☐
Approved WPS:	☑	☐	☐
Delayed / Cancelled:	☐	☑	☐

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

This QA Inspector observed the following work in progress:
FCAW process tack welding of weld joint # 004 located on Counter Weight CW002A – PP096. Welder is identified as 219189. ZPMC QC is identified as Xiang Feng Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2133.

BAY 2

The following NDT inspection carried out as per the ZPMC submitted Notification No. 004514
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. FB3002 – 001 – 001; 004; 019; 033; 041

This QA Inspector observed the following work in progress:
FCAW process welding of weld joint # 022 located on FB3039 – 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 # 076 located on FB3039 – 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 – 2232 – B – U2 – F.

FCAW process welding of weld joint # 090 located on FB3039 – 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 – 2132 – 3.

BAY 5

This QA Inspector observed the following work in progress:
FCAW process welding of weld joint # 010 located on Traveler Rail 10TR3 – 037. 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.

FCAW process welding of weld joint # 014 located on Traveler Rail 10TR2 – 001. 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 # 008 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 the WPS – B – T – 2132.

FCAW process welding of weld joint # 006 located on Traveler Rail 10TR1 – 024. 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.

BAY 6

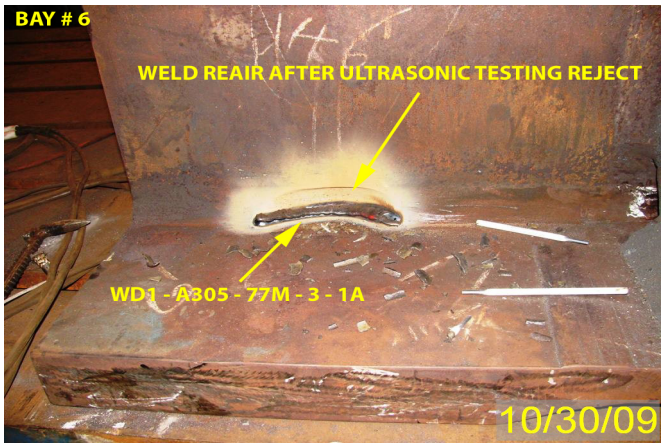
Tower

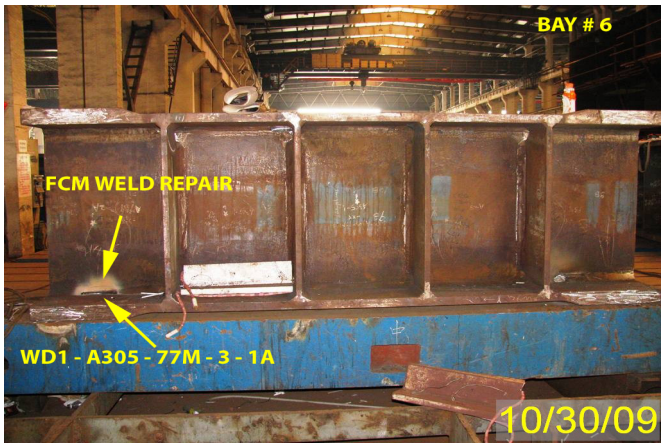
This QA Inspector observed the following work in progress:
SMAW process repair welding of weld joint #7B located on Tower Strut WD1 – A305 – 53M – 4. Welder is identified as 048617. ZPMC QC is identified as Zhao Chen Sun. The welding variables recorded by QC appeared to comply with the WPS – 485 – SMAW – 2G (2F) – FCM – Repair – 1.

SMAW process repair welding of weld joint #1A located on Tower Strut WD1 – A305 – 77M – 3. 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 – 485 – SMAW – 2G (2F) – FCM – Repair – 1.
See attached photos:-

SMAW process repair welding of weld joint #9A located on Tower Strut WD1 – A305 – 77M – 3. 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.

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