

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-010135**Date Inspected:** 13-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:** Chen Xi**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.

OBG # BAY 1

This QA inspector received ZPMC Non Destructive Testing (NDT) notification 004621 to perform Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated a Magnetic Particle Test report for this date. The member is identified as Counter weight. The weld tested is identified as follows:

(CW001B-PP048-004,007,008,010,016,019,020,023)

(CW002B-PP084-004,007,016,019,020,023,008,011)

(CW002A-PP084-003,009)

(CW002B-PP086-004,007,016,019,020,023,008,011)

(CW002A-PP086-003,009)

This QA inspector received ZPMC Non Destructive Testing (NDT) notification 004628 to perform Ultrasonic test (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an Ultrasonic Test report for this date. The member is identified as Cross beam Counter weight. The weld tested is identified as follows:

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

(CW001B-PP048-001,002,003)

(CW002B-PP084-001,002,003)

(CW002B-PP086-001,002,003)

(CW002B-PP092-001,002,003)

This QA Inspector randomly observed the following work in progress:

OBG # BAY 2

Flux Cored Arc Welding Process:

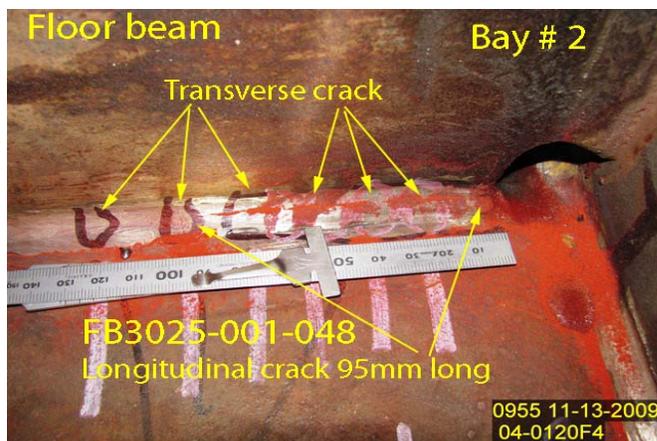
Welding of weld joint -007 located on PCMK SEG3004R-PP109. Welder is identified as 045227. ZPMC QC is identified as Zhan hai feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-TC-U4b-F.

Welding of weld joint -001,002 located on PCMK LD006-006. Welder is identified as 045203. ZPMC QC is identified as Zhan hai feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

Welding of weld joint -001,002 located on PCMK LD010-012. Welder is identified as 062438. ZPMC QC is identified as Zhan hai feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

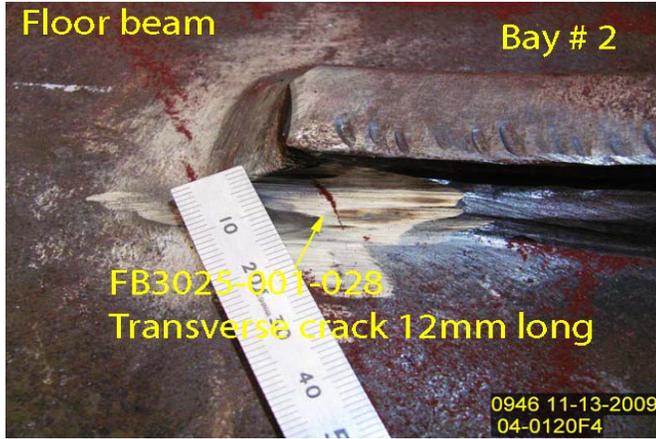
During in-process visual inspection of OBG floor beam components in Bay 2, This QA inspector observed that ZPMC MT Technician Magnetic particle Testing (MT) Personnel identified as Mr. Su Wei appears to have rejected Fourteen (14) Transverse Crack and one(1)longitudinal Crack indications. The weld designation as identified on the material is FB3025-001-048,028. See attached picture.

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



WELDING INSPECTION REPORT

(Continued Page 3 of 3)



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