

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-011567**Date Inspected:** 21-Jan-2010**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:** Liu Fawen**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:** Orthotropic Box Girder (OBG) Components**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

BAY 2

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 005099

Magnetic Particle Testing (MT)

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. LD3020 – 001 – 032; 033; 045; 046; 057; 069

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW):

Repair welding of a weld joint # 013 according to weld repair report #B-WR9993 located on Traveler Rail 10TR2 – 013. Welder is identified as 062708. ZPMC Quality Control (QC) Inspector is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the WPS – 345 – FCAW – 2G (2F) – Repair – 1.

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Repair welding of a weld joint # 014 according to weld repair report #B-WR9994 located on Traveler Rail 10TR2 – 013. Welder is identified as 045227. ZPMC Quality Control (QC) Inspector is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the WPS – 345 – FCAW – 2G (2F) – Repair – 1.

BAY 3

Green Tags

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

1. LD3010 – 001 – Green Tag # 11902
2. LD3012 – 001 – Green Tag # 11904
3. LD3011 – 001 – Green Tag # 11903

BAY 5

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW):

Repair welding of a weld joint # 013 according to weld repair report #B-WR10037 located on Traveler Rail 10TR2 – 013. Welder is identified as 217185. ZPMC Quality Control (QC) Inspector is identified as Shen Jian Guo. The welding variables recorded by QC appeared to comply with the WPS – 345 – FCAW – 2G (2F) – Repair – 1.

Repair welding of a weld joint # 014 according to weld repair report #B-WR10012 located on Traveler Rail 10TR2 – 018. Welder is identified as 204342. ZPMC Quality Control (QC) Inspector is identified as Shen Jian Guo. The welding variables recorded by QC appeared to comply with the WPS – 345 – FCAW – 2G (2F) – Repair – 1.

Repair welding of a weld joint # 013 according to weld repair report #B-WR10023 located on Traveler Rail 11TR2 – 009. Welder is identified as 215250. ZPMC Quality Control (QC) Inspector is identified as Shen Jian Guo. The welding variables recorded by QC appeared to comply with the WPS – 345 – FCAW – 2G (2F) – Repair – 1.

BAY 6

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW):

Weld joint # 002 located on U-rib connection plate USPL1 – 286. Welder is identified as 070008. ZPMC Quality Control (QC) Inspector is identified as Huang Min. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – Tc – U4b – F.

Weld joint # 001 located on U-rib connection plate USPL1 – 289. Welder is identified as 070008. ZPMC Quality Control (QC) Inspector is identified as Huang Min. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – Tc – U4b – F.

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BAY 11

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 005106

Visual Inspection Testing (VT)

This QA inspector performed VT of the area previously tested and accepted by ZPMC Quality Control personnel. The member is identified as Tower Component. The identified component reviewed as follows:

Lift 4 East Tower D/E Corner

1. ESTL4 – 21/1 – 1B

Magnetic Particle Testig (MT)

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

Lift 4 East Tower D/E Corner

1. ESTL4 – 21/1 – 1B

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
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Reviewed By:	Hall,Steven	QA Reviewer
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