

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-004442**Date Inspected:** 31-Oct-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Peng Wei Jun**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 Office of Structure Materials (OSM) Quality Assurance Inspector (QA) Raymond Lara was present at jobsite in Zhenhua Port Machinery Company facility on Changxing island, China for the purpose of observing and monitoring the fabrication of the OBG.

DP472-001

The Quality Assurance Inspector observed ZPMC welder 059416, utilizing the gas metal arc welding process on a partial penetration weld joint on DP472-001. The Quality Assurance Inspector observed ZPMC Quality Control Personnel record parameters and verify preheat temperatures. The welding parameters observed by the Quality Assurance Inspector appeared to be within welding procedure specification WPS-B-T-2342 (U rib)-4.

The Quality Assurance Inspector observed ZPMC welder 059378, utilizing the gas metal arc welding process on a partial penetration weld joint on DP472-001. The Quality Assurance Inspector observed ZPMC Quality Control Personnel record parameters and verify preheat temperatures. The welding parameters observed by the Quality Assurance Inspector appeared to be within welding procedure specification WPS-B-T-2342 (U rib)-4.

BAY 3

SP 157-001

The Quality Assurance Inspector observed ZPMC welders 050246 and 053742, utilizing the flux core arc welding process on a fillet weld on SP157-001. The Quality Assurance Inspector observed ZPMC Quality Control Personnel record parameters and verify preheat temperatures. The welding parameters observed by the Quality Assurance Inspector appeared to be within welding procedure specification WPS-B-T-2132-3.

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The Quality Assurance Inspector observed ZPMC personnel performing fit up and tack welding operations on side plates SP343-001.

BAY 4

Magnetic Particle Test

The Quality Assurance Inspector performed 10% random magnetic particle testing verification and green tagging operations on side plates; SP617-001, SP538-001, SP369-0001, and SP369-001. The Quality Assurance Inspector green tagged SP617-001, SP538-001, SP369-0001, and SP369-001. See Caltrans report TL-6028 Magnetic Particle Test Report, dated October 31, 2008 for additional information.

Magnetic Particle Test

The Quality Assurance Inspector performed 25% random magnetic particle testing verification and green tagging operations on diaphragm plate to flange SSD1-SA360-15, ESD1-SA419-1. See Caltrans report TL-6028 Magnetic Particle Test Report, dated October 31, 2008 for additional information.

Summary of Conversations:

No relevant conversations on this date.

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 Peter Dautermann 150 0219 9593, who represents the Office of Structural Materials for your project.

Inspected By:	Lara, Raymond	Quality Assurance Inspector
Reviewed By:	Wright, Mark	QA Reviewer
