

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-005147**Date Inspected:** 09-Jan-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:** Zhao Chen Sun**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:** Tower Components**Summary of Items Observed:**

On the date CALTRANS OSM Quality Assurance (QA) Inspector, Dilip Chakrabarti was present during the times noted above for observations relative to the work being performed.

Bay# 6-Tower Assembly

This QA Inspector randomly observed the following work in progress:

SMAW Process:

Welding of weld joint BB-8 located on PCMK NSD 1-SA 369. Welder is identified as 048659. ZPMC QC is identified as Zi Wang. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3312-TC-P5

Welding of weld joint BB-7 located on PCMK NSD 1-SA 369. Welder is identified as 048617. ZPMC QC is identified as Zi Wang. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3312-TC-P5

Welding of weld joint BB-13 located on PCMK WSD 1-SA 424. Welder is identified as 066028. ZPMC QC is identified as Sun Zi Wang. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3312-TC-P5

Welding of weld joint BB-14 located on PCMK WSD 1-SA 424. Welder is identified as 0066478. ZPMC QC is

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

identified Sun Zi Wang. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3312-TC-P5

Welding of weld joint AB-7 located on PCMK WSD 1-SA 424. Welder is identified as 066024. ZPMC QC is identified as Sun Zi Wang. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3313-TC-P5

Welding of weld joint AB-8 located on PCMK WSD 1-SA 424. Welder is identified as 066481. ZPMC QC is identified Sun Zi Wang. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3313-TC-P5

Welding of weld joint AB-14 located on PCMK WSD 1-SA 104. Welder is identified as 048617. ZPMC QC is identified Liu Zhi. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3313-TC-P5

FCAW Process:

Welding of weld joint 9-7A located on PCMK SSD1 DP SA3 . Welder is identified as 054060. ZPMC QC is identified as Liu Zhi. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2233-B-U3F.

Welding of weld joint 9-1A located on PCMK SSD1 DP SA3 . Welder is identified as 202842. ZPMC QC is identified as Liu Zhi. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2233-B-U3F.

Welding of weld joint 6-2B located on PCMK SSD1 DP SA3 . Welder is identified as 063069. ZPMC QC is identified as Liu Zhi. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2233-B-U3F.

Welding of weld joint 13-8 located on PCMK ESD1 DP SA3 . Welder is identified as 200149. ZPMC QC is identified as Liu Zhi. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2132-2.

OBG Assembly

Magnetic Particle Testing:

For Green Tag

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6028 MT report on this date.

The member and the weld designations are as follows:

Sl #	Section#	Weld#	Green Tag#	Location
1.	SP 772-001	001,003	003173	9DW
2.	SP 215-001	007,008	0023165	2A

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Bay# 2-OBG Assembly

Magnetic Particle Testing:
For Yellow Tag

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6028 MT report on this date. The member and the weld designations are as follows:

Sl #	Section#	Weld#	Yellow Tag#	Location
1.	FB 038-001	068,069,070,073, 074,075	002716	Lift 1 & 2

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

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 Serge Sinevod, 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By:	Chakrabarti,Dilip Kumar	Quality Assurance Inspector
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Reviewed By:	Clifford,William	QA Reviewer
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