

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-005192**Date Inspected:** 06-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:	Fu Guo gang	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 Mike Blair was present during the times noted above for observations relative to the work being performed.

Bay 10-Tower

Work in progress

This QA Inspector observed the following work in process: SAW welding of weld joint located on SD1-183-28M-1-1. Welder is identified as 040460. ZPMC QC is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS-B-T-3221-Tc-U5-S-1.

This QA Inspector observed the following work in process: SAW welding of weld joint located on SD1-183-47.6M-3-1B. Welder is identified as 040489. ZPMC QC is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS-B-T-3221-Tc-U5-S-1.

Magnetic Particle Testing

The QA Inspector performed Magnetic Particle (MT) on approximately 25% of the area previously tested and accepted by ZPMC Quality Control personnel. The QA Inspector generated a Magnetic Particle report for this date.

The members are identified as

NSD1-223A/E- The weld designations are as follows: 11A, 14A, 12

NSD1-223C/E- The weld designations are as follows: 5A, 27, and 29

Ultrasonic Testing

WELDING INSPECTION REPORT

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The QA Inspector performed Ultrasonic Testing (UT) on approximately 25% of the area previously tested and accepted by ZPMC Quality Control personnel. The QA Inspector generated an Ultrasonic report for this date. The members are identified as NSD1-SA223A/E-7B, 10B.

Bay 11-Tower

Work in progress

This QA Inspector observed the following work in process: FCAW welding of weld joint 23/24 and 19/20 located on WSD1-SA294 A/G. Welders are identified as 068916, 066401, 068929, and 068206. ZPMC QC is identified as Zhang Zhi Neng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-Tc-P5-F.

This QA Inspector observed the following work in process: SAW welding of weld joint located on ND1-A468-28M-1-2A, ND1-A468-23M-1-2A, and ND1-A468-18M-1-2A. Welder is identified as 042195. ZPMC QC is identified as Zhu Zhong Hai. The welding variables recorded by QC appeared to comply with the WPS-B-T-4221-B-U3c-S-1.

Ultrasonic Testing

The QA Inspector performed Ultrasonic Testing (UT) on approximately 25% of the area previously tested and accepted by ZPMC Quality Control personnel. The QA Inspector generated an Ultrasonic report for this date. The members are identified as:

WSD1-SA388A/D-4B, 7B

WSD1-SA298 E/G-4B, 5B, 9B, 17B, 18B, 20B

WSD1-SA298 F/G-4B, 5B, 9B, 10B

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

Inspected By:	Blair, Mike	Quality Assurance Inspector
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Reviewed By:	Clifford, William	QA Reviewer
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