

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-005545**Date Inspected:** 11-Feb-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:	Wu Zhi Feng, Zhau 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:	OBG 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# 7-OBG Assembly

This QA Inspector randomly observed the following work in progress:

FCAW Process:

Welding of weld joints# 024,025,028,029,032 & 033 located on PCMK SP 501-001. Welders are identified as 066687,051246 & 205385. ZPMC QC is identified as Wang Tai. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2132-3

Bay# 6-OBG Assembly

This QA Inspector randomly observed the following work in progress:

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:

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Sl # Section # Weld # Green Tag # Location

1. SP 498-001 022 004283 10 AW
2. SP 673-001 012 004286 9 DW
3. SP 692-001 012 004287 9 DE
4. SP 670-001 020 004285 9 BW
5. SP 689-001 020 004284 9 BE
6. SP 550-001 022 004153 10 AE
7. SP 736-001 026 004156 10 AW
8. SP 776-001 025 004157 10 AW
9. SP 590-001 027 004154 10 AE
10. SP 630-001 032 004155 10 AE

Bay# 6-Tower Assembly

This QA Inspector randomly observed the following work in progress:

SMAW Process:

Welding of weld joints# B/B-24 located on PCMK SSD1-DPSA3-2. Welders are identified as 037932.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 joints# B/B-25 located on PCMK SSD1-DPSA3-2. Welders are identified as 066326.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 joints# B/B-22 & 26 located on PCMK SSD1-DPSA3-2. Welders are identified as 067611. 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 joints# B/B-21 & 23 located on PCMK SSD1-DPSA3-2. Welder is identified as 068924. 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

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 Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

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