

**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-005547**Date Inspected:** 13-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

<b>CWI Name:</b>	Wu Zhi Feng, Zhau Chen Sun	<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes No N/A	<b>Rod Oven in Use:</b>	Yes	No N/A
<b>Electrode to specification:</b>	Yes No N/A	<b>Weld Procedures Followed:</b>	Yes	No N/A
<b>Qualified Welders:</b>	Yes No N/A	<b>Verified Joint Fit-up:</b>	Yes	No N/A
<b>Approved Drawings:</b>	Yes No N/A	<b>Approved WPS:</b>	Yes	No N/A
		<b>Delayed / Cancelled:</b>	Yes	No N/A
<b>Bridge No:</b>	34-0006	<b>Component:</b>	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# 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:

Sl #	Section #	Weld #	Green Tag #	Location
1.	DP 203-005	011,012,013,014	004276	6A
2.	BP 184-001	007,008,009,010	004277	10 BE
3.	SP 737-001		013,015,016,017	004274 10 BW
4.	BP 076-001	013,015,017,018	004275	10 BE
5.	SP 549-001	049	004272	10 AE
6.	SP 501-001	014	004273	10 CW
7.	SP 593-001	036	004271	10 CE

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Bay# 6-Tower Assembly

This QA Inspector randomly observed the following work in progress:

SMAW Process:

Welding of weld joints# B/B-25 located on PCMK ESD1-DPSA3-12. Welders are identified as 037932. ZPMC QC is identified as Zhao Jie. 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-26 located on PCMK ESD1-DPSA3-12. Welders are identified as 068924. ZPMC QC is identified as Zhao Jie. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3313-TC-P5

Welding of weld joint# B/B-11 located on PCMK SSD1-DPSA3-3. Welder is identified as 048659. ZPMC QC is identified as Zhao Jie. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3312-TC-P5

Welding of weld joint# B/B-12 located on PCMK SSD1-DPSA3-3. Welder is identified as 037779. ZPMC QC is identified as Zhao Jie. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3312-TC-P5

Welding of weld joint# B/B-7 located on PCMK SSD1-DPSA3-2. Welder is identified as 067611. ZPMC QC is identified as Zhao Jie. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3312-TC-P5

Welding of weld joint# B/B-8 located on PCMK SSD1-DPSA3-2. Welder is identified as 066326. ZPMC QC is identified as Zhao Jie. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3312-TC-P5

Magnetic Particle Testing:

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.	WSD1-SA 381	B/B- 1,2,7,8,11,12,15,16	NA	NA
2.	WSD1-SA 381	A/B- 3,13,14,15,16,17,18	NA	NA
3.	WSD1-SA 404	3	NA	NA

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

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**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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<b>Inspected By:</b>	Chakrabarti,Dilip Kumar	Quality Assurance Inspector
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<b>Reviewed By:</b>	Clifford,William	QA Reviewer
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