

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-005674**Date Inspected:** 19-Feb-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Liang**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 and Tower Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector George Goulet was present during the times noted above for observations relative to the work being performed.

Bay 10

This QA Inspector randomly observed the following work in progress in Bay 10:

FCAW welding of weld joints NSD1-SA163A/D-17, 18, 19, 20 located on PCMK north tower, lift 2, skin B to stiffener B2 using both the southwest and southeast gantries. Welders were identified respectively as 067499, 037907, 068864, 070046. ZPMC QC was identified as Liu Liang (QC). The welding variables recorded by QC appeared to comply with WPS: B-T-2332-Tc-P5-F. Also observed at this location and appearing to be monitoring the welding was ABF Representative Jiang Zi Wen.

Bay 11

This QA inspector proceeded to Bay 11 in response to a ZPMC notification of witness inspection to perform MT inspection as follows:

This QA Inspector performed MT of approximately 15% the total linear distance of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an MT report for this date. The member is identified as ND1-A476-47.6M-1. The weld designations reviewed as marked on the part are as follows: 8A, 9B. QA Inspector also notated MT review on the member.

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This QA Inspector performed MT of approximately 15% the total linear distance of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an MT report for this date. The member is identified as ND1-468-33M-1. The weld designations reviewed as marked on the part are as follows: 7A, 22B. QA Inspector also notated MT review on the member.

This QA Inspector performed MT of approximately 15% the total linear distance of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an MT report for this date. The member is identified as ND1-468-38M-1. The weld designations reviewed as marked on the part are as follows: 7A, 22B. QA Inspector also notated MT review on the member.

Bay 3

This QA inspector proceeded to Bay 3 in response to a ZPMC notification of witness inspection to perform MT inspection as follows:

This QA Inspector performed MT of approximately 15% the total linear distance of the 25% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an MT report for this date. The member is identified as FB010-027. The weld designations reviewed as marked on the part are as follows: 002, 010, 013, 014, 021, 022, 027~030, 033~038, 041, 042, 044, 047, 048, 061. QA Inspector also notated MT review on the member.

This QA Inspector performed MT of approximately 15% the total linear distance of the 25% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an MT report for this date. The member is identified as FB015-034. The weld designations reviewed as marked on the part are as follows: 002, 010, 013, 014, 021, 022, 027~030, 033~038, 041, 042, 044, 047, 048, 061. QA Inspector also notated MT review on the member.

This QA Inspector performed MT of approximately 15% the total linear distance of the 25% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an MT report for this date. The member is identified as FB015-030. The weld designations reviewed as marked on the part are as follows: 002, 010, 013, 014, 021, 022, 027~030, 033~038, 041, 042, 044, 047, 048, 061. QA Inspector also notated MT review on the member.

This QA Inspector performed MT of approximately 15% the total linear distance of the 25% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an MT report for this date. The member is identified as FB015-031. The weld designations reviewed as marked on the part are as follows: 002, 010, 013, 014, 021, 022, 027~030, 033~038, 041, 042, 044, 047, 048, 061. QA Inspector also notated MT review on the member.

This QA Inspector performed MT of approximately 15% the total linear distance of the 25% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an MT report for this date. The member is identified as FB015-036. The weld designations reviewed as marked on the part are as follows: 001, 003~009, 011, 012, 015~020, 024, 025, 031, 032, 039, 040, 046. QA Inspector also notated MT review on the member.

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This QA Inspector performed MT of approximately 15% the total linear distance of the 25% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an MT report for this date.

The member is identified as FB016-033. The weld designations reviewed as marked on the part are as follows: 001~003, 005~009, 011, 012, 015~020, 024, 025, 033, 034, 041, 042, 046. QA Inspector also notated MT review on the member.

This QA Inspector performed MT of approximately 15% the total linear distance of the 25% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an MT report for this date. The member is identified as FB016-030. The weld designations reviewed as marked on the part are as follows: 001~003, 005~009, 011, 012, 015~020, 024, 025, 033, 034, 041, 042, 046. QA Inspector also notated MT review on the member.

This QA Inspector performed MT of approximately 15% the total linear distance of the 25% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an MT report for this date. The member is identified as FB015-033. The weld designations reviewed as marked on the part are as follows: 001, 003~009, 011, 012, 015~020, 024, 025, 031, 032, 039, 040, 046. QA Inspector also notated MT review on the member.

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

Summary of Conversations:

This QA inspector asked QC noted above if all the welding variables observed by him appeared to comply with the appropriate WPS, including preheat and interpass temperature requirements according to thickness of the thickest member being welded. QC showed this QA Inspector that he was carrying the appropriate temperature sticks to monitor the minimum and maximum preheat and interpass temperatures and replied that all he observed did appear to comply.

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

Inspected By:	Goulet,George	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
