

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-005939**Date Inspected:** 24-Mar-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:** 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.	SP 383-001	014,016,018,020,	005880	11DE
2.	SP 381-001	014,016,018,020,	005877	11BE
3.	SP 170-001	014,016,018,020	005876	11 DW
4.	BP 205-007	001	005878	7 B
5.	BP 202-007	002,004	005879	7 B

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

6. DP 689-001 002,004 005875 10 BW
7. SP 201-007 003,005,007,009 005872 7 B
8. BP 189-001 013,015,017 005874 11 DE
9. SP 384-001 013,015,017,019 006873 11 EE

Bay# 6-Tower Assembly:

This QA Inspector randomly observed the following work in progress:

SMAW Process:

Welding of weld joint# B/B-9 located on PCMK NSD1-DPSA3-1. Welder is identified as 037743. ZPMC QC is identified as Wang Xiao Bing. 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-13 located on PCMK NSD1-DPSA3-1. Welder is identified as 066028. ZPMC QC is identified as Wang Xiao Bing. 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-10 located on PCMK NSD1-DPSA3-1. Welder is identified as 066413. ZPMC QC is identified as Wang Xiao Bing. 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-14 located on PCMK NSD1-DPSA3-1. Welder is identified as 066236. ZPMC QC is identified as Wang Xiao Bing. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3312-TC-P5

Bay# 7-OBG Assembly

This QA Inspector randomly observed the following work in progress:

FCAW Process:

Welding of weld joint# 7&8 located on PCMK BP 078-001. Welder is identified as 054459. ZPMC QC is identified as Zhong Dian Xing. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2132-3.

Welding of weld joint# 11&12 located on PCMK BP 078-001. Welder is identified as 205774. ZPMC QC is identified as Zhong Dian Xing. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2132-3.

Welding of weld joint# 15&16 located on PCMK BP 078-001. Welder is identified as 062447. ZPMC QC is identified as Zhong Dian Xing. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2132-3.

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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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.

Inspected By:	Chakrabarti,Dilip Kumar	Quality Assurance Inspector
----------------------	-------------------------	-----------------------------

Reviewed By:	Clifford,William	QA Reviewer
---------------------	------------------	-------------