

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-006419**Date Inspected:** 27-Apr-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:** Huang Wen pang**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 this date Caltrans OSM Quality Assurance (QA) Inspector, Sandeep Kumar was present during the times noted above for observations relative to the work being performed.

Bay 03

Ultrasonic Testing

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows:

FB019 – 007 – 078; 079; 080; 081; 101; 108; 117; 122; 126; 127

FB027 – 007 – 126; 021

FB023 – 010 – 108

FB019 – 009 – 108

FB019 – 008 – 108

FB027 – 011 – 108

FB024 – 010 – 108

FB020 – 019 – 108

FB010 – 023 – 043

SSD19 – PP078 – 137

SSD13 – PP072 – 137

FB003 – 132 – 008; 020

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

SSD19 – PP083 – 137
FB003 – 143 – 008; 020

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint 030 located on FB205 - 007. Welder is identified as 044824. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2233 – B – u2 – F.

FCAW process welding of weld joint 023 located on FB015 – 046. Welder is identified as 204338. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – B – u2 - F.

Bay 03

Green Tags

The following green tags issued for OBG components after completing the NDT requirements are:

SSD19/19A – PP078 – Green Tag # 006648
FB003 – 148 – Green Tag # 006648
FB006 – 152 – Green Tag # 006648
FB013 – 031 – Green Tag # 006648
SSD13/13A – PP072 – Green Tag # 006649
FB003 – 132 – Green Tag # 006649
FB006 – 149 – Green Tag # 006649
FB004 – 036 – Green Tag # 006649
SSD19/19A – PP083 – Green Tag # 006650
FB003 – 143 – Green Tag # 006650
FB006 – 146 – Green Tag # 006650
FB013 – 034 – Green Tag # 006650

Bay 02

Ultrasonic Testing

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member is identified as OBG Component. The weld designations reviewed are as follows:

SEG 2E – 582; 583

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 Eric Tsang - 15000422372, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By:	Kumar,Sandeep	Quality Assurance Inspector
----------------------	---------------	-----------------------------

Reviewed By:	Prue,Erik	QA Reviewer
---------------------	-----------	-------------
