

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-006486**Date Inspected:** 24-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 COMPONENT**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:

FB011 – 027 – 043

SEG040D – 082; 087; 054; 059; 068; 073

SEG040E – 001; 006; 024; 029; 047; 052

SEG036D - 068; 073; 082; 087; 054; 059

SEG036E – 001; 006; 024; 029; 047; 052

CA046 – 081; 057

CA040 – 069; 021

CA045 – 045

CA039 – 034

FB040 – 003 – 146

Magnetic Particle Testing

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows:

SEG040D – 004; 056; 063; 072; 077; 085

SEG040E – 003; 010; 025; 033; 048; 066

SEG036D – 004; 056; 063; 069; 077; 083

SEG036E – 002; 009; 026; 032; 049; 055

CA046 – 081; 057; 108; 112

CA040 – 069; 021; 102; 110

CA045 – 045; 105; 106

CA039 – 033; 104

Green Tags

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

FB011 – 027 – Green Tag # 006641

SEG040D – 054 ~ 059 – Green Tag # 007301

SEG040D – 068 ~ 073 – Green Tag # 007302

SEG040D – 082 ~ 087 – Green Tag # 007303

SEG040E – 001 ~ 006 – Green Tag # 007304

SEG040E – 047 ~ 052 – Green Tag # 007305

SEG040E – 024 ~ 029 – Green Tag # 007306

SEG036D – 082 ~ 087 – Green Tag # 007307

SEG036D – 054 ~ 059 – Green Tag # 007308

SEG036D – 088 ~ 093 – Green Tag # 007309

SEG036E – 024 ~ 029 – Green Tag # 007310

SEG036E – 001 ~ 001 – Green Tag # 007311

SEG036E – 047 ~ 052 – Green Tag # 007312

CA046 – 057; 058 – Green Tag # 007299

CA046 – 081; 082 – Green Tag # 007230

CA040 – 069; 070 – Green Tag # 007298

CA045 – 045; 046 – Green Tag # 006860

CA039 – 034; 034 – Green Tag # 007230

This QA Inspector observed the following work in progress:

SAW process welding of weld joint 023 located on FB010 - 037. Welder is identified as 044780. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2221 – B – L2c – S – 2.

Bay 02

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint 580 located on SEG1E. Welder is identified as 045260. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2233 – B – u2a – F.

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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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.

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