

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-006563**Date Inspected:** 06-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1645**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 this 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:

SAW Process:

Welding of weld joints# 001 located on PCMK CB 202F-008. Welder is identified as 216836. ZPMC QC is identified as Wang Liang. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2221-L2c-S2.

FCAW Process:

Welding of weld joints# 25,31 located on PCMK FB 204-17. Welder is identified as 053609. ZPMC QC is identified as Wang Liang. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2232-TC-U4b-F.

Bay# 6-Tower Assembly

This QA Inspector randomly observed the following work in progress:

SMAW Process:

Welding of weld joints# 1B located on PCMK ND1 SA658-65M-4. Welder is identified as 053753. ZPMC QC is

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

identified as Wang Xiao Bing. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3211-TC-U5b-1.

Welding of weld joints# 1B located on PCMK ND1 SA658-65M-3. Welder is identified as 068250. ZPMC QC is identified as Wang Xiao Bing. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3211-TC-U5b-1.

Welding of weld joints# B/B-4 located on PCMK ESD1 DPSA4-1. Welder is identified as 037743 & 066481. ZPMC QC is identified as Liu Hua Jie. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3312-TC-P5.

Welding of weld joints# B/B-5 located on PCMK ESD1 DPSA4-1. Welder is identified as 037779 & 066261. ZPMC QC is identified as Liu Hua Jie. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3312-TC-P5.

SAW Process:

Welding of weld joints# 56B located on PCMK WD1-A305-53M-4. Welder is identified as 054458. ZPMC QC is identified as Wang Xiao Bing. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-4221-b-U-3c-S.

FCAW Process:

Welding of weld joints# 25,30 located on PCMK WD1 CBSA3-1-7. Welder is identified as 019006. ZPMC QC is identified as Liu Zhi. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2332-TC-P4-F-1.

Welding of weld joints# 29,49 located on PCMK WD1 CBSA3-1-7. Welder is identified as 222396. ZPMC QC is identified as Liu Zhi. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2332-TC-P4-F-1.

Welding of weld joints# 33,47 located on PCMK WD1 CBSA3-1-7. Welder is identified as 220688. ZPMC QC is identified as Liu Zhi. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2332-TC-P4-F-1.

Welding of weld joints# 17,35 located on PCMK WD1 CBSA3-1-7. Welder is identified as 209554. ZPMC QC is identified as Liu Zhi. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2332-TC-P4-F-1.

Bay # 7-OBG Assembly:

This QA Inspector randomly observed the following work in progress:

FCAW Process:

Welding of weld joints# 5&6 located on PCMK DP 202-013. Welder is identified as 205774. ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2132-3.

WELDING INSPECTION REPORT

(Continued Page 3 of 4)

Welding of weld joints# 9&10 located on PCMK DP 202-013. Welder is identified as 062447. ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2132-3.

Ultrasonic Testing:

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6027 UT report on this date. The member and the weld designations are as follows:

Sl # Section # Weld # Green Tag # Location

1. SP 207-012 060 NA NA
2. SP 209-012 010 NA NA

Bay# 5-OBG Assembly

This QA Inspector randomly observed the following work in progress:

Final VT:

This QA inspector performed Final Visual Testing (FVT) of entire welded area of 8 nos. miscellaneous items PCMK CTS 11 previously tested and accepted by ZPMC Quality Control personnel.

Ultrasonic Testing:

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6027 UT report on this date. The member and the weld designations are as follows:

Sl # Section # Weld # Green Tag # Location

1. FB 204-001 043 NA NA
2. FB 204-003 043,046 NA NA

Unless otherwise noted, all work observed on this date appeared to be 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 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By: Chakrabarti,Dilip Kumar

Quality Assurance Inspector

WELDING INSPECTION REPORT

(Continued Page 4 of 4)

Reviewed By: Clifford, William

QA Reviewer