

**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-007229**Date Inspected:** 05-Jun-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 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:

Magnetic Particle Testing (MT):

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:

SI # Section # Weld # Green Tag # Location

1. DP 203-016 008,010,012,014 008478 11 D

2. FB 201-016 3,5,7,9,11,13 008475 11 D

3. SP 201-016 006,008,010,012 008479 11 D

4. BP 205-013 001,002 008476 10 A

5. BP 204-015 001,002 008477 11 B

SAW Process:

Welding of weld joints# 004 located on PCMK CB 202C-008. Welder is identified as 049804. ZPMC QC is

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identified as Wang Liang. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2221-B-L2c-S-2.

Bay# 6-Tower Assembly

This QA Inspector randomly observed the following work in progress:

SMAW Process:

Welding of weld joints# B/B-9 located on PCMK ESD1 DPSA4-13. Welder is identified as 069493. ZPMC QC is identified as Zhang Bao Bo. 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-8 located on PCMK ESD1 DPSA4-13. Welder is identified as 066459. ZPMC QC is identified as Zhang Bao Bo. 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-20 located on PCMK SSD1 DPSA4-7. Welder is identified as 066456. ZPMC QC is identified as Zhang Bao Bo. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3313-TC-P5.

Welding of weld joints# B/B-21 located on PCMK SSD1 DPSA4-7. Welder is identified as 067588. ZPMC QC is identified as Zhang Bao Bo. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3313-TC-P5.

SAW Process:

Welding of weld joints# 6A located on PCMK WD1 A305-65M-1,2. Welder is identified as 054458. ZPMC QC is identified as Shi Yu. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-4221-B-U3c-S.

Bay# 5-OBG Assembly

This QA Inspector randomly observed the following work in progress:

Magnetic Particle Testing (MT):

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. 14 TB2-1 005,006 NA NA
2. 15 TB5-1 002,003 NA NA

Bay # 7-OBG Assembly:

This QA Inspector randomly observed the following work in progress:

FCAW Process:

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Welding of weld joints# 13&14 located on PCMK SP 3035-001. Welder is identified as 062447. ZPMC QC is identified as Sheng Jian Guo. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2132-3.

Welding of weld joints# 5&6 located on PCMK SP 3035-001. Welder is identified as 051246. ZPMC QC is identified as Sheng Jian Guo. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2132-3.

Welding of weld joints# 1&2 located on PCMK SP 3035-001. Welder is identified as 053742. ZPMC QC is identified as Sheng Jian Guo. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2132-3.

### Ultrasonic Testing (UT):

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:

SI # Section # Weld # Green Tag # Location

1. BP 3048-001 097,098 NA NA
2. BP 3046-001 097,098 NA NA
3. BP 3047-001 097,098 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 conversation

### 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.

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<b>Inspected By:</b>	Chakrabarti,Dilip Kumar	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

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