

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-007242**Date Inspected:** 08-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: Wu Ming Kai
Inspected CWI report: Yes No N/A
Electrode to specification: Yes No N/A
Qualified Welders: Yes No N/A
Approved Drawings: Yes No N/A

CWI Present: Yes No
Rod Oven in Use: Yes No N/A
Weld Procedures Followed: Yes No N/A
Verified Joint Fit-up: Yes No N/A
Approved WPS: Yes No N/A
Delayed / Cancelled: Yes No N/A

Bridge No: 34-0006**Component:** OBG & TOWER 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. SP 202-015 002,004,006 008467 11 B
2. DP 202-016 001,002,003,004 008466 11 D
3. BP 204-016 001,002 008468 11 D

Bay# 6-Tower Assembly

This QA Inspector randomly observed the following work in progress:

SMAW Process:

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Welding of weld joints# B/B-20 located on PCMK SSD1 DPSA4-14. Welder is identified as 066478. 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-21 located on PCMK SSD1 DPSA4-14 Welder is identified as 068924. 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-22 located on PCMK SSD1 DPSA4-14. Welder is identified as 066481. 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-23 located on PCMK SSD1 DPSA4-14. Welder is identified as 068250. 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.

SAW Process:

Welding of weld joints# 6B located on PCMK WD1 SA305-77M-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-3221-TC-U5-S-1.

FCAW Process:

Welding of weld joints# 1 located on PCMK WD1 GUSA3-3-65M-1. Welder is identified as 062447. ZPMC QC is identified as Wang Sun. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2132.

Welding of weld joints# 1 located on PCMK WD1 GUSA3-3-65M-2. Welder is identified as 054459. ZPMC QC is identified as Wang Sun. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2132.

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.	SSD1 DPSA4-2	B/B-1,2,5,6,24,25	A/B-3,6	NA NA
2.	SSD1 SA4-51	2,5	NA	NA

Bay# 5-OBG Assembly

This QA Inspector randomly observed the following work in progress:

Magnetic Particle Testing (MT):

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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. 17 TB12-1 010 NA NA

2. 14 TB8-1 010 NA NA

3. 12 TR6-001 001,002,003,004 NA NA

4. 12 TR6-005 001,002,003,004 NA NA

Final VT:

This QA inspector performed Final Visual Testing (FVT) of entire welded area of 6 no, miscellaneous items Cable Tray Support CTS 4B(A,B,C) & CTS 4E(A,B,C), previously tested and accepted by ZPMC Quality Control personnel.

Bay # 7-OBG Assembly:

This QA Inspector randomly observed the following work in progress:

FCAW Process:

Welding of weld joints# 72&73 located on PCMK SP 3035-001. Welder is identified as 205774. 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# 76&77 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# 82&83 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.

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.

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