

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-007268**Date Inspected:** 19-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:** 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 1

This QA Inspector observed the following work in progress:

SAW process welding of weld joint #004 located on Cross Beam CB201C - 007. Welder is identified as 207345. ZPMC QC is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2221 – B – L2C – S – 2.

FCAW process welding of a repair weld joint #009 located on Floor Beam FB205 – 014. Welder is identified as 054460. ZPMC QC is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the WPS – 345 – FCAW – 3G (3F) - Repair.

FCAW process welding of a repair weld joint #012 located on Floor Beam FB205 – 013. Welder is identified as 054460. ZPMC QC is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the WPS – 345 – FCAW – 3G (3F) - Repair.

BAY 2

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This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #003 located on LD013 – 011. Welder is identified as 215676. ZPMC QC is identified as Zhang Hai Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

FCAW process welding of weld joint #134 located on SSD18A – PP088. Welder is identified as 203871. ZPMC QC is identified as Zhang Hai Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2233 – Tc – u4b – F.

BAY 3

Magnetic Particle Testing

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:

1. FB010 – 034 – 011; 012; 015; 016; 017; 018
2. FB010 – 040 – 011; 012; 015; 016; 017; 018
3. FB015 – 043 – 011; 012; 015; 016; 017; 018
4. FB015 – 040 – 011; 012; 015; 016; 017; 018

Green Tags

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

1. FB005 – 042 – Green Tag # 009087
2. FB005 – 043 – Green Tag # 009088
3. FB005 – 047 – Green Tag # 009089
4. FB013 – 040 – Green Tag # 009090
5. FB013 – 042 – Green Tag # 009091
6. FB013 – 046 – Green Tag # 009092
7. FB003 – 178 – Green Tag # 009083
8. FB003 – 185 – Green Tag # 009084
9. FB003 – 192 – Green Tag # 009085
10. FB003 – 197 – Green Tag # 009086

This QA Inspector observed the following work in progress:

SAW process welding of weld joint #002 located on Cross Beam CB202B - 010. Welder is identified as 044780. ZPMC QC is identified as Yin Dong Hai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2221 – B – L2C – S – 2.

FCAW process welding of weld joint #043 located on Floor Beam FB009 – 036. Welder is identified as 066746. ZPMC QC is identified as Shi Lei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – u4b - F.

FCAW process welding of weld joint #095 located on CSD6 – PP77. Welder is identified as 204338. ZPMC QC is identified as Zhang Yaxu. The welding variables recorded by QC appeared to comply with the WPS – B – T –

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2132 – 3.

BAY 5

Magnetic Particle Testing

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:

1. TR5C – PP19 – 005; 006
2. TR6B – PP24 – 003; 004
3. TR6C – PP26 – 006

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:

1. TR5C – PP19 – 005; 006
2. TR5C – PP23 – 005; 006
3. TR5C – PP25 – 005; 006
4. TR5C – PP24 – 003; 004

BAY 12

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:

1. USPL1 – 072 – 001; 002
2. USPL1 – 088 – 001; 002
3. USPL1 – 096 – 001; 002
4. USPL1 – 084 – 001; 002
5. USPL1 – 085 – 001; 002

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.

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Inspected By:	Kumar,Sandeep	Quality Assurance Inspector
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Reviewed By:	Prue,Erik	QA Reviewer
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