

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-007283**Date Inspected:** 14-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:** Wen zhong wan**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:** Tower Stiffener**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, D.Sukanthan was present during the time noted above for observations relative to the work being performed.

TOWER # BAY 10

This QA inspector performed Ultrasonic Test of approximately 10% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an Ultrasonic Test report for this date. The member is identified as Stiffener. The weld designations reviewed are as follows:

(SSD1-FBSA4-1A/C-51 A/B, 52 A/B, 55 A/B)

(SSD1-FCSA4-1C/C-7 A/B, 8 A/B)

(SSD1-FBSA4-1A/C-65 A/B)

This QA inspector performed Magnetic Particle Test of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an Magnetic Particle Test report for this date. The member is identified as Stiffener. The weld designations reviewed are as follows:

(SSD1-FBSA4-1A/C-51B, 52B, 53B, 54B, 55B, 56B)

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(SSD1-FBSA4-1A/C-65B)

(SSD1-FDSA4-1A/C-6A)

(SSD1-FESA4-1F/F – 7A, 13A, 21A, 28A)

This QA Inspector randomly observed the following work in progress:

TOWER # BAY 10

Flux Cored Arc Welding Process:

Welding of weld joint –2B located on PCMK SSD1-FCSA4-1C/C. Welder is identified as 040338. ZPMC QC is identified as Liu zheng an. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-B-U3-F.

Submerged Arc Welding:

Welding of weld joint –80 located on PCMK NSD1-FCSA4-1A/C. Welder is identified as 207746 / 207745. ZPMC QC is identified as Wen zhong wan. The welding variables recorded by QC appeared to comply with the WPS-B-T-2321-B-P3-S-2.

Welding of weld joint –15 located on PCMK NSD1-FDSA4-3A/C. Welder is identified as 250252 / 040252. ZPMC QC is identified as Wen zhong wan. The welding variables recorded by QC appeared to comply with the WPS-B-T-2321-B-P3-S-2.

Unless otherwise noted, all work observed on this date appeared to 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 Serge 13482570045, who represents the Office of Structural Materials for your project.

Inspected By:	Sukanthan,Dhanasingh	Quality Assurance Inspector
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Reviewed By:	Prue,Erik	QA Reviewer
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