

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-007284**Date Inspected:** 12-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:** Liu zheng an**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:** West Tower Lift 1 Doubly plate**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 11

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 West Tower Lift 1 Doubly plate. The weld designations reviewed are as follows:

(WSD1-SA39A/K-1, 3, 5, 10)

(WSD1-SA39A/K-7) Reject able Indication found by MT method.

(WSD1-SA39B/K-1, 3, 5)

(WSD1-SA39B/K-6) Reject able Indication found by MT method.

(WSD1-SA225A/H-19, 20, 87)

(WSD1-SA39A/K-7R1)

(WSD1-SA39B/K-6R1)

This QA Inspector randomly observed the following work in progress:

TOWER # BAY 11

WELDING INSPECTION REPORT

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Submerged Arc Welding:

Welding of weld joint –84B located on PCMK ESD1-FCSA4-2A/C. Welder is identified as 047304. ZPMC QC is identified as Xu le feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-B-U3C-S-2.

TOWER # BAY 10

Flux Cored Arc Welding Process:

Welding of weld joint –024,025 located on PCMK SSD1-FASA4-1E/E. Welder is identified as 040365/040533. ZPMC QC is identified as Liu zheng an. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P5-F.

Welding of weld joint –094,095 located on PCMK SSD1-FASA4-1E/E. Welder is identified as 050041/040338. ZPMC QC is identified as Liu zheng an. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P5-F.

Submerged Arc Welding:

Welding of weld joint –82B, 47B located on PCMK NSD1-FBSA4-1A/C. Welder is identified as 250252. ZPMC QC is identified as Xu le feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-4221-B-U3C-S-3.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

The QA Inspector informed ZPMC QC Mr. Xu lie feng that the QA Inspector performed Magnetic particle Test of weld WSD1-SA39A/K-7 & WSD1-SA39B/K-6 that welds have linear indication. The QA Inspector informed that the QA Inspector will be issuing incident report welds which have linear indication.

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
Reviewed By:	Prue,Erik	QA Reviewer
