

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-007584**Date Inspected:** 04-Jul-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:	Xu Xian Ping		
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 and TOWER 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:

SMAW process welding of weld joint #001 located on Counter Weight CW002B – PP090. Welder is identified as 215326. ZPMC QC is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2112.

BAY 2

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #012 located on Longitudinal Diaphragm LD014-013. Welder is identified as 058247. ZPMC QC is identified as Zhang Hai Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – Tc – U4b – F.

FCAW process welding of weld joint #011 located on Longitudinal Diaphragm LD014-047. Welder is identified as 045209. ZPMC QC is identified as Zhang Hai Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

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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 member is identified as OBG Component. The weld designations reviewed are as follows:

1. FB012 – 028 – 043
2. FB012 – 032 – 043
3. FB027 – 010 – 146

BAY 3

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #127 located on Floor Beam FB028 –011. Welder is identified as 044830. ZPMC QC is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U4b – F.

FCAW process welding of weld joint #064 located on Floor Beam FB019 – 009. Welder is identified as 204338. ZPMC QC is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U4b – F.

BAY 5

Visual Inspection Testing

This QA inspector performed Visual Verification of the area previously tested and accepted by ZPMC Quality Control personnel. The member is identified as OBG Component. The component designations reviewed are as follows:

Cable tray support

1. CTS10(A,B)
2. CTS1E1(F)
3. CTS1D1(I,J,K,L)
4. CTS1F(B,C)
5. CTS1F1(A,B,C,D)

BAY 6

This QA Inspector observed the following work in progress:

SAW process welding of weld joint #4 – 1A located on ND1 – SA658 – 77M. Welder is identified as 054458. ZPMC QC is identified as Shi Yu. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3221 – TC – U5 – S – 1.

SMAW process welding of weld joint #03 located on NSD1 – DPSA4 – 10B/B. Welder is identified as 067588. ZPMC QC is identified as Zhao Chen Sun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3312 – Tc – P5.

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SMAW process welding of weld joint #17 located on NSD1 – DPSA4 – 14B/B. Welder is identified as 067588. ZPMC QC is identified as Zhao Chen Sun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3312 – Tc – P5.

SMAW process welding of weld joint #41 located on WD1 – A305 – 53M – 4. Welder is identified as 069894. ZPMC QC is identified as Shi Yu. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2113.

SMAW process welding of weld joint #16 located on NSD1 – DPSA4 – 14B/B. Welder is identified as 069493. ZPMC QC is identified as Zhao Chen Sun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3312 – Tc – P5.

SMAW process welding of weld joint #35 located on WD1 – A305 – 53M – 4. Welder is identified as 066456. ZPMC QC is identified as Shi Yu. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2113.

SMAW process welding of weld joint #04 located on NSD1 – DPSA4 – 10B/B. Welder is identified as 069493. ZPMC QC is identified as Zhao Chen Sun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3312 – Tc – P5.

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.

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