

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-007590**Date Inspected:** 27-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:** Xu Xian Ping**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 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 6

This QA Inspector observed the following work in progress:

SMAW process welding of weld joint #014 located on NSD1 – DPSA4 – 10B/B. Welder is identified as 068924. 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.

FCAW process welding of weld joint #001 located on CB202F – 009. Welder is identified as 048625. ZPMC QC is identified as Shu Yang Hua. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – B – U2 – F – 1.

SMAW process welding of weld joint #009 located on NSD1 – DPSA4 – 01B/B. Welder is identified as 069493. ZPMC QC is identified as Zou Liu Hai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3312 – Tc – P5.

SMAW process tack welding of weld joint #02 – 1B located on ND1 – SA658 – 65M. Welder is identified as 067656. ZPMC QC is identified as Wang Xiao Bing. The welding variables recorded by QC appeared to comply

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with the WPS – B – T – 3211 – Tc – U5b – 1.

SMAW process welding of weld joint #015 located on NSD1 – DPSA4 – 10B/B. Welder is identified as 037743. 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 #008 located on NSD1 – DPSA4 – 01B/B. Welder is identified as 067588. ZPMC QC is identified as Zou Liu Hai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3312 – Tc – P5.

SMAW process tack welding of weld joint #01 – 1B located on ND1 – SA658 – 77M. Welder is identified as 037840. ZPMC QC is identified as Wang Xiao Bing. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3211 – Tc – U5b – 1.

BAY 7

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. SP3044 – 001 – 006
2. SP3055 – 001 – 006
3. SP3010 – 001 – 008
4. SP3056 – 001 – 006
5. SP3011 – 001 – 007
6. SP3023 – 001 – 006
7. SP3054 – 001 – 020
8. SP3022 – 001 – 007
9. SP3043 – 001 – 006
10. SP3021 – 001 – 020
11. BP3029 – 001 – 056
12. BP3010 – 001 – 056
13. BP3011 – 001 – 056
14. BP3028 – 001 – 056

This QA Inspector observed the following work in progress:

SMAW process welding of weld joint #038 located on SP3015 – 001. Welder is identified as 203204. ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2112.

SAW process welding of weld joint #011 located on SP3024 – 001. Welder is identified as 048625. ZPMC QC is identified as Gui Jun Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2221 – B – L2C – S – 2.

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SMAW process welding of weld joint #131 located on SP3015 – 001. Welder is identified as 250833. ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2112.

BAY 8

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #006 located on Floor Beam FB204 – 034. Welder is identified as 066687. ZPMC QC is identified as Zhang Hai Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – u4b – F.

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
