

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-007591**Date Inspected:** 26-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		
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
Component:	OBG and TOWER Components		

Bridge No: 34-0006**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 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. FB205 – 025 – 027; 028; 001; 005; 009; 033; 034
2. FB205 – 028 – 027; 028; 001; 005; 009
3. FB204 – 025 – 051; 052; 067; 068; 055; 056; 001; 005; 009
4. FB204 – 026 – 051; 052; 001; 005; 009; 055; 056
5. FB204 – 027 – 051; 052; 001; 005; 009; 055; 056
6. FB204 – 028 – 055; 056
7. FB205 – 027 – 033; 034
8. FB205 – 026 – 033; 034

BAY 5

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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:

CB202B – 011 – 001; 002; 003; 004

This QA Inspector observed the following work in progress:

SMAW process welding of weld joint #062 located on BK001 – 019. Welder is identified as 216703. ZPMC QC is identified as Zhen Zhi Wei. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2112.

FCAW process welding of weld joint #002 located on TR2A – PP16. Welder is identified as 20534. ZPMC QC is identified as Zhen Zhi Wei. The welding variables recorded by QC appeared to comply with the WPS - B - T - 2232 - TC - U4C - F.

BAY 6

This QA Inspector observed the following work in progress:

SAW process welding of weld joint # 004 located on CB202B – 009. Welder is identified as 054458. ZPMC QC is identified as Lin Chuen Gang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2221 – B – L2C – S – 2.

SMAW process welding of weld joint #014 located on WSD1 – DPSA4 – 10B/B. Welder is identified as 066459. 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.

FCAW process welding of weld joint #002 located on WSD1 – DPSA4 – 10B/B. Welder is identified as 019006. ZPMC QC is identified as Zou Liu Hai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 4332 – Tc – P4 – F.

SMAW process welding of weld joint #015 located on WSD1 – DPSA4 – 10B/B. Welder is identified as 068918. 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.

BAY 7

This QA Inspector observed the following work in progress:

SMAW process welding of weld joint #013 located on SP3018 – 001. Welder is identified as 051015. 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 SP3057 – 001. Welder is identified as 048625. ZPMC QC is identified as Shen Jian Guo. 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 #017 located on SP3018 – 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.

BAY 8

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #021 located on Floor Beam FB204 – 035. 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.

SAW process welding of weld joint #002 located on Cross Beam CB201F – 012. Welder is identified as 207463. ZPMC QC is identified as Zhang Hai Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2221 – B – L2C – S – 2.

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
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Reviewed By:	Prue,Erik	QA Reviewer
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