

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-007882**Date Inspected:** 05-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 2

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #012 located on Longitudinal Diaphragm LD004-048. Welder is identified as 203871. 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 #002 located on Longitudinal Diaphragm LD007-009. Welder is identified as 058245. ZPMC QC is identified as Zhang Hai Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

FCAW process welding of weld joint #012 located on Longitudinal Diaphragm LD014-013. Welder is identified as 062438. 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 #003 located on Longitudinal Diaphragm LD004-049. Welder is identified as 062708. 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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BAY 3

This QA Inspector observed the following work in progress:

SMAW process Tack welding of weld joint #011 located on Longitudinal Diaphragm LD004-054. Welder is identified as 207292. ZPMC QC is identified as Zhang Yaxu. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2112.

FCAW process welding of weld joint #148 located on Floor Beam FB020 – 009. Welder is identified as 204338. ZPMC QC is identified as Shi Lei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U4b – F.

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. CSD4 – PP74 – 100; 101; 102; 103 – Green Tag # 008657
2. CSD4 – PP76 – 100; 101; 102; 103 – Green Tag # 008658
3. CSD4 – PP80 – 100; 101; 102; 103 – Green Tag # 008659
4. CSD4 – PP82 – 100; 101; 102; 103 – Green Tag # 008660
5. CSD5– PP75 – 100; 101; 102; 103 – Green Tag # 008661
6. CSD5– PP81 – 100; 101; 102; 103 – Green Tag # 008662
7. CSD5 – PP73 – 035; 036; 037; 038 – Green Tag # 008663
8. CSD5 – PP77 – 035; 036; 037; 038 – Green Tag # 008664
9. CSD5 – PP79 – 035; 036; 037; 038 – Green Tag # 008665
10. CSD5 – PP83 – 035; 036; 037; 038 – Green Tag # 008666
11. CSD5 – PP85 – 035; 036; 037; 038 – Green Tag # 008667
12. CSD6– PP72 – 097; 098; 099; 100 – Green Tag # 008668
13. CSD6 – PP73 – 097; 098; 099; 100 – Green Tag # 008669
14. CSD6 – PP77 – 097; 098; 099; 100 – Green Tag # 008670
15. CSD6 – PP78 – 097; 098; 099; 100 – Green Tag # 008671
16. CSD6 – PP79 – 097; 098; 099; 100 – Green Tag # 008672
17. CSD6– PP83 – 097; 098; 099; 100 – Green Tag # 008673
18. CSD6– PP84 – 097; 098; 099; 100 – Green Tag # 008674
19. CSD6 – PP85 – 097; 098; 099; 100 – Green Tag # 008675
20. CSD7 – PP72 – 035; 036; 037; 038 – Green Tag # 008676
21. CSD7 – PP78 – 035; 036; 037; 038 – Green Tag # 008677
22. CSD7– PP84 – 035; 036; 037; 038 – Green Tag # 008678

BAY 6

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

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OBG & TOWER Components. The weld designations reviewed are as follows:

1. FB201 – 15 – 001 – Green Tag # 009420
2. SP3048 – 001 – 026; 028; 030; 038; 040; 042; 050; 052; 054; 071; 135 – Green Tag # 009419
3. SP3004 – 001 – 129; 131; 141; 143 – Green Tag # 009418
4. SP3004 – 001 – 041; 043 – Green Tag # 009417
5. SP3002 – 001 – 012; 014; 047; 049 – Green Tag # 009415
6. SP3004 – 001 – 017; 019; 073; 075 – Green Tag # 009416
7. SP3006 – 001 – 015; 016; 017; 018; 019; 020 – Green Tag # 009414
8. SP3019 – 001 – 010; 011; 012; 013; 014 – Green Tag # 009413
9. SSD1 – DPSA4 – 3B/B – 05; 12; 16
10. SSD1 – DPSA4 – 9B/B – 05; 12; 16
11. SSD1 – DPSA4 – 19B/B – 03; 07
12. SSD1 – DPSA4 – 19B/B – 01
13. SSD1 – SA4 – 55 – 04; 05
14. SSD1 – DPSA4 – 19B/B – 02
15. SSD1 – DPSA4 – 3B/B – 09; 11; 18

This QA Inspector observed the following work in progress:

SAW process welding of weld joint #10 – 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 WSD1 – 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.

SMAW process welding of weld joint #23 located on WD1 – A305 – 53M – 2. 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 – 4113 – 1.

SMAW process welding of weld joint #04 located on WSD1 – 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.

SMAW process welding of weld joint #26 located on WD1 – A305 – 53M – 2. 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 #06 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 #22 located on WD1 – A305 – 53M – 2. Welder is identified as 037780. ZPMC QC is identified as Shi Yu. The welding variables recorded by QC appeared to comply with the WPS – B –

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T – 2113.

SMAW process welding of weld joint #07 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 #27 located on WD1 – A305 – 53M – 2. Welder is identified as 068918. ZPMC QC is identified as Shi Yu. The welding variables recorded by QC appeared to comply with the WPS – B – T – 4113 – 1.

BAY 7

This QA Inspector observed the following work in progress:

SAW process welding of weld joint #116 located on BP3001 – 001. Welder is identified as 046830. ZPMC QC is identified as Zhong Dian Xing. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2221 – L2c – S – 2.

BAY 8

This QA Inspector observed the following work in progress:

SAW process welding of weld joint #003 located on CB201B – 012. Welder is identified as 207463. ZPMC QC is identified as Guo Yan Fei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2221 – L2c – S – 2.

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:

CB201F – 012 – 002

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