

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-007887**Date Inspected:** 10-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**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 1

This QA Inspector observed the following work in progress:

SMAW process Tack welding of weld joint # 001 located on Counter Weight CW001B-PP078. 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.

SMAW process Tack welding of weld joint # 002 located on Counter Weight CW001B-PP060. 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**Green Tags**

The following green tags issued for OBG components after completing the NDT requirements are:

1. FB012 – 028 – Green Tag # 009636
2. FB010 – 032 – Green Tag # 009635
3. FB012 – 032 – Green Tag # 009637

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4. FB012 – 030 – Green Tag # 009633

5. FB012 – 029 – Green Tag # 009634

BAY 3

Green Tags

The following green tags issued for OBG components after completing the NDT requirements are:

1. FB012 – 036 – Green Tag # 009632

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #030 located on Floor Beam FB023 –010. Welder is identified as 208035. ZPMC QC is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

FCAW process welding of weld joint #127 located on Floor Beam FB020 – 009. Welder is identified as 044790. ZPMC QC is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2133.

BAY 5

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #005 located on Traveler Rail TR6C– PP46. Welder is identified as 205390. ZPMC QC is identified as Xu Hong Min. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – Tc – U4c – F – 1.

FCAW process welding of weld joint #007 located on Traveler Rail TR2D– PP10. Welder is identified as 205390. ZPMC QC is identified as Xu Hong Min. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – Tc – U4c – F – 1.

BAY 6

This QA Inspector observed the following work in progress:

SMAW process welding of weld joint #49 located on WD1 – A305 – 53M – 4. 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 – 2113.

SAW process welding of weld joint #6 – 1A located on ND1 – SA658 – 65M. Welder is identified as 054458. ZPMC QC is identified as Zhao Chen Sun. 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 #48 located on WD1 – A305 – 53M – 4. 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 – 2113.

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FCAW process welding of weld joint #019 located on Floor Beam FB205 – 021. Welder is identified as 222396. ZPMC QC is identified as Huang Min. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U4b – F.

SMAW process welding of weld joint #1 – 10A located on WD1 – A305 – 77M. Welder is identified as 066456. ZPMC QC is identified as Zhao Chen Sun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2212 – Tc – U5b.

BAY 7

This QA Inspector observed the following work in progress:

SAW process of weld joint #076 located on Side Plate SP3001 – 001. Welder is identified as 046830. ZPMC QC is identified as Zhan Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2221 – B – L2c – S – 2.

FCAW process of Tacking weld joint #099 located on Side Plate SP5036 – 001. Welder is identified as 019006. ZPMC QC is identified as Zhan Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – B – U2 – F.

SAW process of weld joint #099 located on Side Plate SP3003 – 001. Welder is identified as 046830. ZPMC QC is identified as Zhan Jie. 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
Reviewed By:	Prue,Erik	QA Reviewer
