

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-007888**Date Inspected:** 11-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**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. CB201C – 007 – 003

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint # 014 located on Cross Beam CB201A-007. Welder is identified as 054460. ZPMC QC is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U4b – F.

BAY 2

This QA Inspector observed the following work in progress:

FCAW process Repair welding of weld joint #127 located on Floor Beam FB019 –006. Welder is identified as

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045209. ZPMC QC is identified as Zhang Hai Feng. The welding variables recorded by QC appeared to comply with the WPS – 345 – FCAW – 2G (2F) – FCM – Repair.

FCAW process Repair welding of weld joint #127 located on Floor Beam FB020 –006. 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 – 345 – FCAW – 2G (2F) – FCM – Repair.

BAY 3

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. FB003 –199 – 008; 020
2. FB003 – 201 – 020; 032
3. SSD19 – PP095 – 137
4. SSD13 – PP095 – 137
5. FB016 – 047 – 045

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. LD003 – 040 – 011 – Green Tag # 008887
2. LD001 – 030 – 011 – Green Tag # 008879
3. LD014 – 009 – 011 – Green Tag # 008902
4. LD011 – 013 – 011 – Green Tag # 008894
5. LD004 – 041 – 011 – Green Tag # 008892
6. LD001 – 027 – 011 – Green Tag # 008876
7. LD014 – 010 – 011 – Green Tag # 008903
8. LD013 – 009 – 011 – Green Tag # 008900
9. LD003 – 039 – 011 – Green Tag # 008848
10. LD001 – 028 – 011 – Green Tag # 008877
11. LD003 – 041 – 011 – Green Tag # 008888
12. LD002 – 031 – 011 – Green Tag # 008885
13. LD001 – 029 – 011 – Green Tag # 008878
14. LD011 – 014 – 011 – Green Tag # 008895
15. LD002 – 029 – 011 – Green Tag # 008883
16. LD002 – 028 – 011 – Green Tag # 008882
17. LD012 – 013 – 011 – Green Tag # 008897
18. LD004 – 042 – 011 – Green Tag # 008893
19. LD011 – 015 – 011 – Green Tag # 008896
20. LD012 – 015 – 011 – Green Tag # 008899
21. LD004 – 039 – 011 – Green Tag # 008890

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- 22. LD012 – 014 – 011 – Green Tag # 008898
- 23. LD001 – 031 – 011 – Green Tag # 008880
- 24. LD013 – 010 – 011 – Green Tag # 008901
- 25. LD002 – 027 – 011 – Green Tag # 008881
- 26. LD003 – 042 – 011 – Green Tag # 008889
- 27. LD004 – 040 – 011 – Green Tag # 008891
- 28. LD002 – 030 – 011 – Green Tag # 008884

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #034 located on Floor Beam FB003 –194. Welder is identified as 044824. ZPMC QC is identified as Shi Lei. The welding variables recorded by QC appeared to comply with the WPS – B – T –2233 – Tc – U4b – F.

FCAW process welding of weld joint #126 located on Floor Beam FB019 – 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 – 2231 – Tc – U4b – F.

FCAW process welding of weld joint #137 located on SSD13 – PP097. Welder is identified as 044824. ZPMC QC is identified as Shi Lei. The welding variables recorded by QC appeared to comply with the WPS – B – T –2233 – Tc – U4b – F.

FCAW process welding of weld joint #028 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.

BAY 5

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #004 located on Traveler Rail TR5B– PP47. 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 #002 located on Traveler Rail TR6A– PP52. 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 #003 located on Traveler Rail TR1B– PP35. 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

Magnetic Particle Testing

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC

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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. SP3017 – 001 – 013 ~ 024 – Green Tag # 009410
2. SP3018 – 001 – 001 ~ 012 – Green Tag # 009412
3. SP3003 – 001 – 196; 198 – Green Tag # 009411
4. SP3003 – 001 – 095; 097; 039; 041 – Green Tag # 009409
5. SP3002 – 001 – 145; 147; 173; 175 – Green Tag # 009408

This QA Inspector observed the following work in progress:

SMAW process welding of weld joint #46 located on WD1 – A305 – 65M – 2. Welder is identified as 066459. 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 #16 – 1A located on ND1 – SA658 – 77M. 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 #22 located on WD1 – A305 – 65M – 2. 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 – 2113.

FCAW process welding of weld joint #012 located on Floor Beam FB205 – 024. 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 #47 located on WD1 – A305 – 65M – 2. Welder is identified as 069894. ZPMC QC is identified as Zhao Chen Sun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 4113 – 1.

FCAW process welding of weld joint #024 located on Floor Beam FB204 – 024. 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 #27 located on WD1 – A305 – 65M – 2. Welder is identified as 068918. ZPMC QC is identified as Zhao Chen Sun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 4113 – 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 member is identified as OBG Component. The weld designations reviewed are as follows:

1. SP3057 – 001 – 011

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2. SP3024 – 001 – 011
3. BP3001 – 001 – 115; 116
4. BP3003 – 001 – 115; 116
5. BP3002 – 001 – 115; 116

This QA Inspector observed the following work in progress:

SMAW process of Tacking weld joint #047 located on Side Plate SP3055 – 001. Welder is identified as 250489. 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 of weld joint #099 located on Side Plate SP3036 – 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.

SMAW process of Tacking weld joint #056 located on Side Plate SP3011 – 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.

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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