

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-007991**Date Inspected:** 15-Jul-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wu Zhi Cheng**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:** Tower&OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Utekar Shrikant was present during the times noted above for observations relative to the work being performed.

TRIAL ASSEMBLY YARD

Magnetic Particle Inspection

This Q.A Inspector performed Magnetic Particle Inspection of approximately 15% of the area previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated a (M.T) report for this date. The members are identified as the Segment 4BE-4AE Designation are as follows.

Bolt hole repair area on 4BE FL3 on top stiffener.

TRIAL ASSEMBLY YARD

Ultrasonic Inspection

This Q.A Inspector performed Ultrasonic Inspection of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated a (U.T) report for this date. The members are identified as the Segment 4BE-4AE Designation are as follows.

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Bolt hole repair area on 4BE FL3 on top stiffener.

TRIAL ASSEMBLY YARD

Ultrasonic Inspection

This Q.A Inspector performed Ultrasonic Inspection of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated a (U.T) report for this date. The members are identified as the Segment 1BE, 5AW Designation are as follows.

SEG021A-007

CA098-002

During random 10% verification Ultrasonic Testing (UT) on the weld joint between edge panel to deck panel (CA098-002) of segment 1BE, This Caltrans Quality Assurance (QA) Inspector discovered a class "A" non conforming indication measuring approximately 10 to 15mm in length. Incident report was issued.

This QA Inspector randomly observed the following work in progress.

BAY#10

SMAW welding process of weld joint 13 located on PCMK SSD1-FDSA4-1C/C. Welder is identified as 052939 ZPMC QC is identified as Wai Wen Zhang. The welding variables recorded by QC appeared to comply with the WPS-B-T-3212-TC-U5B-1.

SMAW welding process of weld joint 53A located on PCMK SSD1-FDSA4-1C/C. Welder is identified as 050289 ZPMC QC is identified as Wai Wen Zhang. The welding variables recorded by QC appeared to comply with the WPS-B-T-3212-TC-U5B-1.

TRIAL ASSEMBLY YARD

FCAW welding process of weld joint 009 located on PCMK OBW01. Welder is identified as 220069 ZPMC QC is identified as Chen Bo. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-3G (3F) Repair.

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversation

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 + (86) 15000422372, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

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Inspected By:	Utekar,Shrikant	Quality Assurance Inspector
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Reviewed By:	Clifford,William	QA Reviewer
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