

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-007996**Date Inspected:** 09-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:** Li Ming**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.

BAY#10

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 North tower, Lift 4 skin'd' Designation are as follows.

NSD1-FDSA4-3B, 6B

BAY#19

Green Tag

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

1. BP026A-007-004~023, 044~053-Green tag No-005441.

WELDING INSPECTION REPORT

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This QA Inspector randomly observed the following work in progress.

BAY#11

FCAW welding process of weld joint 6 located on PCMK ESD1-FCSA4-2C/C. Welder is identified as 070140 ZPMC QC is identified as Liu Xiao Zhong. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P5-F.

FCAW welding process of weld joint 6 located on PCMK ESD1-FCSA4-2C/C. Welder is identified as 068920 ZPMC QC is identified as Liu Xiao Zhong. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P5-F.

FCAW welding process of weld joint 3 located on PCMK ESD1-FCSA4-2C/C. Welder is identified as 067601 ZPMC QC is identified as Liu Xiao Zhong. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P5-F.

FCAW welding process of weld joint 2 located on PCMK ESD1-FCSA4-2C/C. Welder is identified as 070046 ZPMC QC is identified as Liu Xiao Zhong. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P5-F.

TRIAL ASSEMBLY YARD

FCAW welding process of weld joint 008 located on PCMK SSD27-PP033. Welder is identified as 048801 ZPMC QC is identified as Chen Bo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132T.

BAY#10

FCAW welding process of weld joint 053A located on PCMK NSD1FCSA4-1A/C. Welder is identified as 052075 ZPMC QC is identified as Li Ming. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-1G (1F) Repair.

FCAW welding process of weld joint 42 located on PCMK NSD1-A166J/J. Welder is identified as 050041 ZPMC QC is identified as Jiang Xiao Bo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U2A-F.

FCAW welding process of weld joint 19 located on PCMK NSD1-A166J/J. Welder is identified as 053116 ZPMC QC is identified as Jiang Xiao Bo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U2A-F.

TRIAL ASSEMBLY YARD

VISUAL INSPECTION

WELDING INSPECTION REPORT

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This QA noted the following Observation during the random visual inspection in Trial assembly yard.

This QA Inspector observed ZPMC performing the welding on the 37A plate at PP26-27 in segment 4BE south side.

This QA Inspector observed ZPMC performing the welding on the 37A plate at PP26-27 in segment 4BE north side.

This QA Inspector observed ZPMC performing bolt tensioning on 'U' rib bolt at PP22 in segment 3AE-3BE north side.

This QA Inspector observed ZPMC performing the welding on the 37A plate at PP20-21 in segment 3AE north side.

This QA Inspector observed ZPMC performing the welding on the 37A plate at PP27-28 in segment 4BE north side.

This QA Inspector observed ZPMC performing Magnetic Particle Testing on the floor beam stiffeners at PP20 in segment 3AW north side.

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.

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