

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-007999**Date Inspected:** 06-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:** Zhang Zhi Lang**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#11

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 West tower Lift 4 Skin 'A' Designation are as follows.

WSD1-FASA4-2A/E-1A

WSD1-FASA4-2A/E-2A

WSD1-FASA4-2A/E-3A

WSD1-FASA4-2A/E-7A

BAY#19

Magnetic Particle inspection

This Q.A Inspector performed Magnetic Particle Inspection of approximately 15% of the area previously tested

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

and accepted by ZPMC Quality control personnel. This QA Inspector generated a (M.T) report for this date. The members are identified as the OBG bottom plate Designation are as follows.

BP026-007-004~023

BP026-007-044~053

This QA Inspector randomly observed the following work in progress.

BAY#1

FCAW welding process of weld joint 008 located on PCMK CB201A-007. Welder is identified as 216575 ZPMC QC is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

BAY#11

FCAW welding process of weld joint 56 located on PCMK WSD1-TL6J/L. Welder is identified as 067550 ZPMC QC is identified as Zhang Zhi Neng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2331-TC-P4-F.

FCAW welding process of weld joint 55 located on PCMK WSD1-TL6J/L. Welder is identified as 068047 ZPMC QC is identified as Zhang Zhi Neng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P4-F.

SAW welding process of weld joint 86A located on PCMK WSD1-FCSA4-2A/C. Welder is identified as 041716 ZPMC QC is identified as Cao Cheng. The welding variables recorded by QC appeared to comply with the WPS-B-T-4221-B-U3-C-S-3

FCAW welding process of weld joint 58 located on PCMK WSD1-TL6J/L. Welder is identified as 070046 ZPMC QC is identified as Zhang Zhi Neng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P4-F.

BAY#10

FCAW welding process of weld joint 14B located on PCMK SSD1-FCSA4-1B/C. Welder is identified as 056260 ZPMC QC is identified as Deng Zhi Bing. The welding variables recorded by QC appeared to comply with the WPS-B-T-3212-TC-U5-B-1.

FCAW welding process of weld joint 6 located on PCMK SSD1-FDSA4-1C/C. Welder is identified as 201825 ZPMC QC is identified as Li Peng Fei. 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 SSD1-FDSA4-1C/C. Welder is identified as 057266 ZPMC QC is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

WPS-B-T-2332-TC-P5-F.

FCAW welding process of weld joint 5 located on PCMK SSD1-FDSA4-1C/C. Welder is identified as 050041 ZPMC QC is identified as Li Peng Fei. 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 SSD1-FDSA4-1C/C. Welder is identified as 057266 ZPMC QC is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P5-F.

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
