

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-008036**Date Inspected:** 10-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:** Fu You Shen**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 & TOWER components**Summary of Items Observed:**

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

Bay# 6-Tower Assembly:

This QA Inspector randomly observed the following work in progress:

SMAW Process:

Welding of weld joint# 41 located on PCMK WD1 A305-53M-3. Welder is identified as 037932. ZPMC QC is identified as Shi Yu. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2113.

Welding of weld joint# 40 located on PCMK WD1 A305-53M-3. Welder is identified as 068924. ZPMC QC is identified as Shi Yu. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2113.

Welding of weld joint# 34 located on PCMK WD1 A305-53M-3. Welder is identified as 066268. ZPMC QC is identified as Shi Yu. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2113.

Welding of weld joint# 35 located on PCMK WD1 A305-53M-3. Welder is identified as 068091. ZPMC QC is identified as Shi Yu. The welding variables recorded by QC appeared to comply with the specified WPS no.

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B-T-2113.

Bay# 8-OBG Assembly:

This QA Inspector randomly observed the following work in progress:

Ultrasonic Testing (UT):

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6027 UT report on this date.

The member and the weld designations are as follows:

Sl # Section # Weld # Green Tag # Location

1. CB 202E-012 001,002,003 NA NA

Bay# 12-OBG Assembly:

This QA Inspector randomly observed the following work in progress:

Ultrasonic Testing (UT):

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6027 UT report on this date.

The member and the weld designations are as follows:

Sl # Section # Weld # Green Tag # Location

1. USPL1-103 001 NA NA

2. USPL1-129 001 NA NA

3. USPL1-134 001 NA NA

4. USPL1-110 002 NA NA

5. USPL1-109 002 NA NA

6. USPL1-137 001 NA NA

7. USOL1-139 002 NA NA

8. USPL1-136 002 NA NA

Bay# 10-Tower Assembly:

This QA Inspector randomly observed the following work in progress:

Ultrasonic Testing (UT):

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6027 UT report on this date.

The member and the weld designations are as follows:

Sl # Section # Weld # Green Tag # Location

1. NSD1 FDSA4-3D/D 45 A,B NA NA

2. NSD1 FDSA4-3D/D 36 A,B NA NA

3. NSD1 FDSA4-3D/D 22 A,B NA NA

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Unless otherwise noted, all work observed on this date appeared to be 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 Serge Sinevod 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By:	Chakrabarti,Dilip Kumar	Quality Assurance Inspector
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Reviewed By:	Clifford,William	QA Reviewer
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