

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-008181**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:** Wan Wen Zhong**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# 2-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. FB 028-010 146 NA NA

2. FB 028-011 021 NA NA

3. FB 028-009 127 NA NA

4. FB 016-038 045 NA NA

5. FB 020-006 127 NA NA

Bay# 3-OBG Assembly:

This QA Inspector randomly observed the following work in progress:

Ultrasonic Testing (UT):

WELDING INSPECTION REPORT

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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. FB 003-188 032 NA NA
2. FB 003-182 020 NA NA
3. SSD 14A-PP101 132 NA NA
4. SSD 17A-PP105 131 NA NA

Bay# 10-Tower Assembly:

This QA Inspector randomly observed the following work in progress:

SAW Process:

Welding of weld joint# 3B located on PCMK ND1 A6002-6,7,8,9,10. Welder is identified as 040460. ZPMC QC is identified as Wan Wen Zhong. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-4221-B-U3c-S-1.

Welding of weld joint# 5B located on PCMK ND1 A6003-4,5,6. Welder is identified as 209051. ZPMC QC is identified as Wan Wen Zhong. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-4221-B-U3c-S-1.

SMAW Process:

Welding of weld joint# 29,30B located on PCMK SSD1 FDSA4-1 C/C. Welder is identified as 052930. ZPMC QC is identified as Wan Wen Zhong. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3212-TC-U5b-1.

Welding of weld joint# 41,42B located on PCMK SSD1 FDSA4-1 C/C. Welder is identified as 050289. ZPMC QC is identified as Wan Wen Zhong. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3212-TC-U5b-1.

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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