

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-008238**Date Inspected:** 29-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Weing Wei**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**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 # 2

Magnetic Particle Inspection

This QA 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 (MT) report for this date. The members are identified as the Floor Beam Designation are as follows.

FB012-031-029, 030, 37, 38, 21, 22, 13

FB016-037-22, 23, 37, 38, 13, 14, 21, 28

BAY # 3

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 Floor Beam Designation are as follows.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

FB205-028-34, 33, 15

FB205-027-27, 08, 26

FB204-027-68, 44, 67

FB204-026-61, 26, 62

FB205-026-27, 07, 28

FB204-027-62, 28, 61

FB204-026-68, 67, 42

This QA Inspector randomly observed the following work in progress.

BAY#02

FCAW welding process of weld joint 005 located on PCMK LD007-010. Welder is identified as 215676 ZPMC QC is identified as Wang Liang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

FCAW welding process of weld joint 032 located on PCMK FB003-174. Welder is identified as 062438 ZPMC QC is identified as Wang Liang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-TC-U4B-F.

FCAW welding process of weld joint 012 located on PCMK LD012-019. Welder is identified as 206358 ZPMC QC is identified as Wang Liang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2331-TC-P4-F.

BAY#01

FCAW welding process of weld joint 002 located on PCMK CW001B-PP056. Welder is identified as 251246 ZPMC QC is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-TC-U4B-F.

This QA Inspector also noted that the following Counter Weight fit up in progress.

CW001B-PP066

CW001B-PP074

CW001B-PP058

BAY#03

FCAW welding process of weld joint 45 located on PCMK FB010-036. Welder is identified as 066746 ZPMC QC is identified as Yin Dong Hai. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-TC-U4B-F.

FCAW welding process of weld joint 045 located on PCMK 016-042. Welder is identified as 044824 ZPMC QC is

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

identified as Yin Dong Hai. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-TC-U4B-F.

FCAW welding process of weld joint 14 located on PCMK FB010-036. Welder is identified as 204338 ZPMC QC is identified as Yin Donghai. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

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 Jim Simonis - 134-7246-3441, who represents the Office of Structural Materials for your project.

Inspected By:	Utekar,Shrikant	Quality Assurance Inspector
----------------------	-----------------	-----------------------------

Reviewed By:	Clifford,William	QA Reviewer
---------------------	------------------	-------------