

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-008244**Date Inspected:** 09-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:****Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:****Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wei Shong Shi**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**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

Magnetic Particle Inspection.

This Q.A Inspector performed Magnetic particle Testing 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 Stiffener the welds Designation are as follows
SSD1-FASA4-1E/E-106A; 112A, 120A and 127A.

This QA Inspector randomly observed the following work in progress

BAY#10

SAW welding process of weld joint 3 located on PCMK NSD1-FESA4-3A/F. Welder is identified as 207745
ZPMC QC is identified as Zougyi. The welding variables recorded by QC appeared to comply with the
WPS-B-T-2321-B-P3-S-2.

SAW welding process of weld joint 48 located on PCMK NSD1-FCSA4-1A/C Welder is identified as 209106

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ZPMC QC is identified as Jiang Xiao Bo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2321-B-P3-S-2

BAY#11

SAW welding process of weld joint 3B located on PCMK SSD1-A111B/H. Welder is identified as 041716 ZPMC QC is identified as Fu Wei Min. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-B-U3C-S-2.

SAW welding process of weld joint 1B located on PCMK SSD1-A111B/H. Welder is identified as 042195 ZPMC QC is identified as Fu Wei Min. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-B-U3C-S-2.

SAW welding process of weld joint 2B located on PCMK SSD1-A111B/H. Welder is identified as 040634 ZPMC QC is identified as Fu Wei Min. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-B-U3C-S-2.

SAW welding process of weld joint 7A located on PCMK ESD1-FASA4-2D/E. Welder is identified as 202756 ZPMC QC is identified as Ma Quian Li. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-B-U3C-S-2.

SAW welding process of weld joint 13A located on PCMK ESD1-FESA4-2A/F. Welder is identified as 040772 ZPMC QC is identified as Peng Bmo. The welding variables recorded by QC appeared to comply with the WPS-B-T-4221-B-U3C-S-2.

BAY#10

Visual Inspection.

Caltrans Quality Assurance (QA) Inspector observed ZPMC personnel had performed Magnetic Particle Testing (MT) after completion of Ultrasonic Testing earlier today. ZPMC appears to have performed power wire brushing of the weld surfaces in an attempt to clean and remove the residual Ultrasonic couplant, but a film of couplant remained on the surfaces where magnetic particle inspections were subsequently performed. This layer of couplant prevents magnetic particles from moving freely on the surfaces of the welds. This condition was observed in Bay # 10, on skin plate splice welds identified as SSD1-FCSA4-1A/C-66A; NSD1-FESA4-3A/F-15A and NSD1-FDSA4-3A/C-11A. ZPMC QA representative Mr. Zhang Jiad was informed of this problem. An incident report was submitted for this.

This Caltrans Quality Assurance Inspector observed ZPMC performed weld repairs of weld NSD1-A166E/J-124A/B, North tower, Lift 1, without adequate preheating of the adjacent base material. This QA Inspector observed a 160 degree Celsius. Tempstick did not melt when applied to the adjacent base material. This repair was being performed as directed by ZPMC weld repair report# T-WR1642. An incident report was submitted for this.

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Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

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