

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-008250**Date Inspected:** 16-Jun-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:** Cheng Ying Xing**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.

OBG TRIAL ASSEMBLY YARD**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 Side panel of Segment 2AW welds Designation are as follows.

SP642-001-022

BAY #10

Ultrasonic Inspection

This Q.A Inspector performed Ultrasonic Testing of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated a (U.T) report for this date. The members are identified as the Skin plate splice joint of North and South tower lift 4 welds Designation are as follows.

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SSD1-FDSA4-1A/C-24A, 23A

NSD1-FBSA4-1A/C-82B, 47B

This QA Inspector randomly observed the following work in progress

BAY#10

SAW welding process of weld joint 55A located on PCMK SSD1-FCSA4-1A/C. Welder is identified as 201750 ZPMC QC is identified as Zong Yi. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-B-U3C-S-2

FCAW welding process of weld joint 6 located on PCMK SSSL3-1G/K. 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-4332-TC-P5-F.

FCAW welding process of weld joint 13 located on PCMK SSSL3-1G/K. Welder is identified as 057766 ZPMC QC is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P5-F

FCAW welding process of weld joint 18 located on PCMK SSSL3-1C/K. Welder is identified as 054069 ZPMC QC is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P5-F.

FCAW welding process of weld joint 53 located on PCMK SSD1-FBSA4-1A/C. Welder is identified as 040261 ZPMC QC is identified as Yang Ming Ming. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P5-F.

SMAW welding process of weld joint 5A/B located on PCMK NSD1-TL8B/L. Welder is identified as 040269 ZPMC QC is identified as Yuan Hui Gang. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G (2F)Repair.

BAY#11

SAW welding process of weld joint 31A (1) located on PCMK WSD1-FCSA4-2A/C. Welder is identified as 056975 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 5 located on PCMK WSD1-FCSA4-2A/C. Welder is identified as 044550 ZPMC QC is identified as Fu Wei Min. The welding variables recorded by QC appeared to comply with the WPS-B-T-2321-B-P3-S-2.

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

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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
Reviewed By:	Clifford,William	QA Reviewer
