

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-008258**Date Inspected:** 06-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:** 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 & 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 QA 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 (MT) report for this date. The members are identified as the Cross Beam#3 the welds Designation are as follows.

CB205A-001-006, 018

CB205J-001-075, 076, 400, 401, 133

300mm from East side

CB 205J-001-134, 81, 82, 93, 94

300mm from East side

CB205J-001-95, 96, 135, 136, 75, 76, 400, 401

300mm from West side

Ultrasonic Inspection

This QA Inspector performed Ultrasonic Testing of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated a (UT) report for this date. The members are identified as the Cross Beam#3 the welds Designation are as follows.

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CB205A-001-004, 016

This QA Inspector randomly observed the following work in progress

BAY#10

SAW welding process of weld joint 66A located on PCMK SSD1-FCSA4-1A/C. Welder is identified as 220081 ZPMC QC is identified as Zougyi. The welding variables recorded by QC appeared to comply with the WPS-B-T-4221-B-U3C-S-3.

SAW welding process of weld joint 127B located on PCMK SSD1-FASA4-1E/E. Welder is identified as 048784 ZPMC QC is identified as Yang Ming Ming. The welding variables recorded by QC appeared to comply with the WPS-B-T-4231-B-U3-F.

SAW welding process of weld joint 4A located on PCMK NSD1-TL8B/L. Welder is identified as 051713 ZPMC QC is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-CU2B-S.

SAW welding process of weld joint 113B located on PCMK NSD1-A112B/H. Welder is identified as 040252 ZPMC QC is identified as Wei Shong Shi. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-C-U2-F

SAW welding process of weld joint 32A located on PCMK NSD1-166E/J. Welder is identified as 0503060 ZPMC QC is identified as Wei Shong Shi. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-C-U2-F.

BAY#11

SAW welding process of weld joint 4B located on PCMK ESD1-FDSA4-2-A/D-88. Welder is identified as 067993 ZPMC QC is identified as Ma Qian 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 7 located on PCMK ESD1-FDSA4-2A/D. Welder is identified as 062143 ZPMC QC is identified as ma Qian Li. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221B-P4-S2.

SAW welding process of weld joint 51A located on PCMK ESD1-FBSA4-2AC. Welder is identified as 207463 ZPMC QC is identified as Ma Qian Li. The welding variables recorded by QC appeared to comply with the WPS-B-T-4221B-U3C-S2.

SAW welding process of weld joint 64A located on PCMK ESD1-FCSA4-2AC. Welder is identified as 067993 ZPMC QC is identified as Ma Qian Li. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221B-U3C-S2

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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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