

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-008716**Date Inspected:** 25-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Xi**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 and TOWER COMPONENT**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance(QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

In process Inspection

BAY #2

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) in the 2F position of the OBG Floor beam to stiffener weld No. FB3070-002-001 and 002. The welder is identified as #062438. ZPMC QC is identified as Mr. Xiang Fang Tang. The welding variables recorded by QC appear to comply with WPS- B – T-2132-3.

Flux Core Arc Welding (FCAW) in the 2F position of the OBG Floor beam to stiffener weld No. FB3070-003-001 and 002. The welder is identified as #215676. ZPMC QC is identified as Mr. Xiang Fang Tang. The welding variables recorded by QC appear to comply with WPS- B – T-2132-3.

BAY #1

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) in the 3G position of the OBG Floor beam Corner assembly weld No. FB-204-047-005 and 009. The welder is identified as #059450. ZPMC QC is identified as Mr. Tian Lei. The welding variables recorded by QC appear to comply with WPS- B – T-2233-Tc-U4b-F.

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Flux Core Arc Welding (FCAW) in the 3G position of the OBG Floor beam Corner assembly weld No. FB-205-045-005 and 009. The welder is identified as #059450. ZPMC QC is identified as Mr.Tian Lei .The welding variables recorded by QC appear to comply with WPS- B – T-2233-Tc-U4b-F.

Flux Core Arc Welding (FCAW) in the 3G position of the OBG Floor beam Corner assembly weld No. FB-205-046-013 and 019. The welder is identified as #216575. ZPMC QC is identified as Mr.Tian Lei .The welding variables recorded by QC appear to comply with WPS- B – T-2233-Tc-U4b-F.

Magnetic Particle Testing

This Quality Insurance Inspector (QA) performed 15% verification Magnetic Particle Testing (MT) for Diaphragm to skin fit lugs at 28M. This weld was previously tested and accepted by ZPMC QC MT technicians.

The weld designations reviewed are as follows:

WSD1A-115-D/J-001
WSD1A-115-D/J-007
WSD1A-115-D/J-008
WSD1A-115-D/J-015
WSD1A-115-D/J-033
WSD1A-115-D/J-035
WSD1A-115-D/J-037
WSD1A-115-D/J-054
WSD1A-115-D/J-082
WSD1A-115-D/J-091
WSD1A-115-D/J-112
WSD1A-115-D/J-123
WSD1A-115-D/J-124
WSD1A-115-D/J-144
WSD1A-115-D/J-156
WSD1A-115-D/J-187
WSD1A-115-D/J-189
WSD1A-115-D/J-192
WSD1A-115-D/J-203
WSD1A-115-D/J-204
WSD1A-115-D/J-212
WSD1A-115-D/J-215
WSD1A-115-D/J-226

This Quality Assurance Inspector (QA) performed 15% verification of Magnetic Particle Testing (MT) on weld joints identified as # WSD1-A115-D,J-14,73,60,198,165,222 and 224 at West Tower diaphragm to skin fit Lugs (28M) . This QA Inspector discovered total seven (7) rejectable linear Indication measuring approximately 8 to 26 mm in length.

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This welds were previously tested and accepted by ZPMC QC MT technicians.

This QA Inspector generated an incident report for this date.

Unless otherwise noted, all work observed on this date 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 Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Bera,Subhasis	Quality Assurance Inspector
Reviewed By:	Prue,Erik	QA Reviewer
