

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-008734**Date Inspected:** 19-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:	Xu Xian Ping		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No	
Rod Oven in Use:	Yes	No	N/A
Weld Procedures Followed:	Yes	No	N/A
Verified Joint Fit-up:	Yes	No	N/A
Approved WPS:	Yes	No	N/A
Delayed / Cancelled:	Yes	No	N/A

Bridge No: 34-0006**Component:** OBG & TOWER Components**Summary of Items Observed:**

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

BAY 1

This QA Inspector observed the following work in progress:

SAW process welding of weld joint #003 located on Cross Beam CB202E – 015. Welder is identified as 207345. ZPMC QC is identified as Zhang Yaxu. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2221 – L2c – S – 2.

FCAW process welding of weld joint #001 located on Cross Beam CB202E – 015. Welder is identified as 054460.

ZPMC QC is identified as Zhang Yaxu. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – B – U2 – F – 1.

BAY 2

This QA Inspector observed the following work in progress:

SMAW process welding of weld joint #003; 005 located on Floor Beam FB3030 – 001. Welder is identified as 205098. ZPMC QC is identified as Zhang Hai Feng. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2112.

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SAW process welding of weld joint #078 located on Floor Beam FB3056 – 001. Welder is identified as 250050. ZPMC QC is identified as Xiang Feng Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2221 – L2c – S – 2.

FCAW process welding of weld joint #095 located on Floor Beam FB3003 – 001. Welder is identified as 066887. ZPMC QC is identified as Zhang Hai Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – B – U2 – F – 1.

FCAW process welding of weld joint #010 located on Floor Beam FB3005 – 001. Welder is identified as 066164. ZPMC QC is identified as Zhang Hai Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

BAY 3

Magnetic Particle Testing

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows:

1. FB024 - 010 - 125~127;
2. FB024 - 010 - 104; 105; 084; 085
3. FB024 - 010 - 102; 103; 142; 143
4. FB024 - 010 - 100; 113; 116; 146
5. FB003 - 177 - 035; 036; 047; 048 – Green Tag # 009987
6. FB003 - 198 - 035; 036; 047; 048 – Green Tag # 009986

This QA Inspector observed the following work not in compliance:

During random verification Magnetic Particle Testing (MT) for the OBG Side Plate, observed one (1) Transverse linear indication approximately 6mm in length in the weld metal on FB024 – 001 - 079.

For Further details please see the incident report: - 040120F4_TL-15_B227_08-19-09_ (MT) Transverse Indication.

BAY 5

This QA Inspector observed the following work in progress:

SMAW process tack welding of weld joint #026 located on Bike Path BK001 – 034. Welder is identified as 203176. ZPMC QC is identified as Xu Hong Min. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2113.

SMAW process tack welding of weld joint #032 located on Bike Path BK001 – 034. Welder is identified as 215691. ZPMC QC is identified as Xu Hong Min. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2113.

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BAY 6

Magnetic Particle Testing

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows:

1. BP3027 - 001 - 008~019; 044~055 – Green Tag # 10405
2. SP3034 - 001 - 021~030 – Green Tag # 10402
3. SP3034 - 001 - 041~050 – Green Tag # 10403
4. SP3001 - 001 - 001~010; 093~102 – Green Tag # 10404

This QA Inspector observed the following work in progress:

SMAW process welding of weld joint #36 located on WD1 – A305 – 65M – 4. Welder is identified as 069493. ZPMC QC is identified as Zhang Bao Bo. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2112.

SMAW process welding of weld joint #1A located on WD1 – A305 – 65M – 1. Welder is identified as 037780. ZPMC QC is identified as Zhang Bao Bo. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3212 – Tc – U5b – 1.

SMAW process welding of weld joint #39 located on WD1 – A305 – 77M – 3. Welder is identified as 037780. ZPMC QC is identified as Zhang Bao Bo. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2112.

SMAW process welding of weld joint #7B located on WD1 – A305 – 65M – 1. Welder is identified as 066457. ZPMC QC is identified as Zhang Bao Bo. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3212 – Tc – U5b – 1.

BAY 7

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #005 located on Edge Plate EP3012 – 001. Welder is identified as 209554. ZPMC QC is identified as Zhou Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

FCAW process welding of weld joint #001 located on Edge Plate EP3009 – 001. Welder is identified as 062447. ZPMC QC is identified as Zhou Jie. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2112.

FCAW process welding of weld joint #002 located on Edge Plate EP3024 – 001. Welder is identified as 051246. ZPMC QC is identified as Zhou Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

BAY 11

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Visual Inspection Testing

This QA inspector performed VT of the area previously tested and accepted by ZPMC Quality Control personnel. The member is identified as TOWER Component. The weld designations reviewed are as follows:

EAST TOWER – LIFT3 – 85.25 M DIAPHRAGM TO SKIN E

ESTL3 – 4B/K – 028; 029

EAST TOWER – LIFT3 – 85.25 M DIAPHRAGM TO SKIN E – FIT LUGS

ESTL3 – 4B/K – 024 ~ 027; 030 ~ 033

EAST TOWER – LIFT3 – 89 M DIAPHRAGM TO SKIN E

ESTL3 – 4C/K – 038

ESTL3 – 4D/K – 037

EAST TOWER – LIFT3 – 89 M DIAPHRAGM TO SKIN E – FIT LUGS

ESTL3 – 4C/K – 030; 031

ESTL3 – 4D/K – 031; 033

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 - 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Sandeep	Quality Assurance Inspector
Reviewed By:	Prue,Erik	QA Reviewer
