

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-008768**Date Inspected:** 30-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:

FCAW process welding of weld joint #021 located on Floor Beam FB204 – 047. Welder is identified as 216575. ZPMC QC is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2233 – Tc – U4b – F.

FCAW process welding of weld joint #028 located on Floor Beam FB204 – 045. Welder is identified as 216575. ZPMC QC is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2233 – Tc – U4b – F.

BAY 2

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #009 located on Floor Beam FB3067 – 002. Welder is identified as 045209. ZPMC QC is identified as Zhang Hai Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

SAW process welding of weld joint #117 located on Floor Beam FB3006 – 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 – B – L2c – S – 2.

FCAW process welding of weld joint #012 located on Floor Beam FB3067 – 002. Welder is identified as 045209. ZPMC QC is identified as Zhang Hai Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2133.

SAW process welding of weld joint #122 located on Floor Beam FB3039 – 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 – B – L2c – S – 2.

FCAW process welding of weld joint #007 located on Floor Beam FB3040 – 001. Welder is identified as 215864. ZPMC QC is identified as Xiang Feng Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U4b.

BAY 5

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #004 located on Traveler Rail TR11A – 005. Welder is identified as 217805. ZPMC QC is identified as Xu Hong Min. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – B – U2 – F.

FCAW process welding of weld joint #003 located on Traveler Rail TR11B – 002. Welder is identified as 217805. ZPMC QC is identified as Xu Hong Min. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – B – U2 – F.

BAY 6

This QA Inspector observed the following work in progress:

SMAW process welding of weld joint #7B located on WD1 – A305 – 77M – 2. Welder is identified as 053753. ZPMC QC is identified as Wang Xiao Bing. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3212 – Tc – U5b – 1.

SMAW process welding of weld joint #10 located on WD1 – A305 – 65M – 1. Welder is identified as 067707. ZPMC QC is identified as Wang Xiao Bing. 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 – 77M – 2. Welder is identified as 040769. ZPMC QC is identified as Wang Xiao Bing. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3212 – Tc – U5b – 1.

SMAW process welding of weld joint #19 located on WD1 – A305 – 77M – 1. Welder is identified as 067707.

WELDING INSPECTION REPORT

(Continued Page 3 of 4)

ZPMC QC is identified as Wang Xiao Bing. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2112.

BAY 7

Ultrasonic Testing

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member is identified as OBG Component. The weld designations reviewed are as follows:

1. SP3025 – 017 – 031

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #008 located on Deck Plate DP3037 – 017. Welder is identified as 222396. 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 #012 located on Deck Plate DP3035 – 017. 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 – T – 2132 – 3.

FCAW process welding of weld joint #014 located on Deck Plate DP3037 – 017. 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.

FCAW process welding of weld joint #005 located on Deck Plate DP3035 – 017. Welder is identified as 205774. ZPMC QC is identified as Zhou Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

BAY 10

Ultrasonic Testing

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member is identified as Tower Component. The weld designations reviewed are as follows:

SOUTH TOWER LIFT-3 A/B CORNER

1. SSSL3 – 1B/K – 83B

SKIRT PLATES

1. NSD1 – A802D/D – 1B
2. SSD1 – A434D/D – 1B

BAY 11

Ultrasonic Testing

WELDING INSPECTION REPORT

(Continued Page 4 of 4)

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member is identified as Tower Component. The weld designations reviewed are as follows:

EAST TOWER LIFT-3 B/C CORNER

1. SSTL3 – 1B/K – 83B

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
