

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-008838**Date Inspected:** 29-Aug-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:	CWI: Zhang Bo/Chen Ying Xin	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 components	

Summary of Items Observed:

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

Bay# 11- Tower Assembly:

This QA Inspector randomly observed the following work in progress:

Magnetic Particle Testing (MT):

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6028 MT report on this date.

The member and the weld designations are as follows:

Sl # Section # Weld # Green Tag # Location

1. WSTL3-4 B/K 82A NA NA

Final VT:

This QA inspector performed Final Visual Testing (FVT) of entire welded area, previously tested and accepted by ZPMC Quality Control personnel of the member and weld designated are as follows:

Sl # Section # Weld # Green Tag # Location

1. WSTL3-4 B/K 82A NA NA

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Ultrasonic Testing (UT):

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6027 UT report on this date. The member and the weld designations are as follows:

Sl #	Section #	Weld #	Green Tag #	Location
1.	WSTL3-4 B/K	82A	NA	NA

FCAW Process:

Welding of weld Joint# 119 located on PCMK WSTL3-4 I/K. Welder is identified as 066471. ZPMC QC is identified as Zhang Bo. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-4332-TC-P4-F.

Welding of weld Joint# 21 located on PCMK WSTL3-4 I/K. Welder is identified as 068206. ZPMC QC is identified as Zhang Bo. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-4332-TC-P4-F.

Welding of weld Joint# 122 located on PCMK WSTL3-4 G/K. Welder is identified as 070254. ZPMC QC is identified as Zhang Bo. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-4332-TC-P4-F.

Bay# 10- Tower Assembly:

This QA Inspector randomly observed the following work in progress:

FCAW Process:

Welding of weld Joint# 44 located on PCMK SSTL3-1 K/K. Welder is identified as 050041. ZPMC QC is identified as Chen Ying Xin. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2233-B-U2a-F-1.

Welding of weld Joint# 45 located on PCMK SSTL3-1 K/K. Welder is identified as 052075. ZPMC QC is identified as Chen Ying Xin. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2233-B-U2a-F-1.

Welding of weld Joint# 42 located on PCMK SSTL3-1 K/K. Welder is identified as 057244. ZPMC QC is identified as Chen Ying Xin. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2233-B-U2a-F-1.

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

Summary of Conversations:

No relevant Conversation

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

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remedial efforts please contact Serge Sinevod 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By:	Chakrabarti,Dilip Kumar	Quality Assurance Inspector
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Reviewed By:	Clifford,William	QA Reviewer
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