

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-009307**Date Inspected:** 28-Sep-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**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 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**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. CW002A – PP094 – 002; 003
2. CW002B – PP094 – 004 ~ 023
3. CW002A – PP096 – 002; 003
4. CW002B – PP096 – 004~023

BAY 2

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

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. FB3063 – 001 – 26; 27; 28; 36; 37; 40; 41; 44
2. FB3011 – 001 – 01; 03; 04; 12; 16; 24
3. FB3060 – 001 – 01; 03; 04; 12; 21; 31
4. FB3004 – 001 – 09; 26; 29; 30; 39; 42; 43; 44
5. FB3062 – 001 – 001

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #037 located on Floor Beam FB3093 – 001. Welder is identified as 045203. ZPMC QC is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

FCAW process welding of weld joint #046 located on Floor Beam FB3025 – 001. Welder is identified as 215676. ZPMC QC is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U4b – F.

FCAW process welding of weld joint #027 located on Floor Beam FB3026 – 001. Welder is identified as 203871. ZPMC QC is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2133.

FCAW process welding of weld joint #010 located on Floor Beam FB3012 – 001. Welder is identified as 045240. ZPMC QC is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

FCAW process welding of weld joint #047 located on Floor Beam FB3093 – 001. Welder is identified as 045203. ZPMC QC is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U4b – F.

BAY 3

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #033 located on X-37 stiffener CA085. Welder is identified as 044790. ZPMC QC is identified as Yin Dong Hai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2233 – Tc – U4b – F.

FCAW process welding of weld joint #095 located on CSD3 – PP100. Welder is identified as 208035. ZPMC QC is identified as Yin Dong Hai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U4b – F.

WELDING INSPECTION REPORT

(Continued Page 3 of 4)

FCAW process welding of weld joint #057 located on X-37 stiffener CA086. Welder is identified as 044824. ZPMC QC is identified as Yin Dong Hai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2233 – Tc – U4b – F.

FCAW process welding of weld joint #103 located on X-37 stiffener CA085. Welder is identified as 044790. ZPMC QC is identified as Yin Dong Hai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

BAY 5

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #002 located on Traveler Rail 11TR10 – 001. Welder is identified as 205390. ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – B – U2 – F.

FCAW process welding of weld joint #001 located on Traveler Rail 10TR2 – 021. Welder is identified as 068858. ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – B – U2 – F.

FCAW process welding of weld joint #002 located on Traveler Rail 11TR3 – 018. Welder is identified as 217185. ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – B – U2 – F.

FCAW process welding of weld joint #001 located on Traveler Rail 10TR1 – 026. Welder is identified as 215009. ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – B – U2 – F.

BAY 6

Cross Beam – 8

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #148 located on Cross Beam CB202G – 019. Welder is identified as 053742. ZPMC QC is identified as Liu Chuan Gang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

FCAW process welding of weld joint #148 located on Cross Beam CB202G – 019. Welder is identified as 053609. ZPMC QC is identified as Liu Chuan Gang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

WELDING INSPECTION REPORT

(Continued Page 4 of 4)

BAY 7

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #001 located on Bottom Plate BP201 – 015. Welder is identified as 019006. ZPMC QC is identified as Cui Jun Jie. The welding variables recorded by QC appeared to comply with the WPS –345 – FCAW– 2G (2F) – FCM – Repair.

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
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Reviewed By:	Whitehead,Lonnie	QA Reviewer
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