

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-009327**Date Inspected:** 23-Sep-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:** Li Ming, Lvli Qing**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/OBG**Summary of Items Observed:**

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

BAY#11

This QA Inspector randomly observed the following work in progress.

FCAW welding process of weld joint 80 located on PCMK WSTL3-4B/K. Welder is identified as 040713 ZPMC QC is identified as Guo Peng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2331-TC-P4.

FCAW welding process of weld joint 79 located on PCMK WSTL3-4B/K. Welder is identified as 046706 ZPMC QC is identified as Guo Peng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P4.

BAY#14

This QA Inspector randomly observed the following work in progress.

FCAW welding process of weld joint 005 located on PCMK SSD19-PP85. Welder is identified as 058551 ZPMC QC is identified as Wang Xu. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132.

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SAW welding process of weld joint 028 located on PCMK SEG064. Welder is identified as 058100ZPMC QC is identified as Zhang Guo Hui. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-T-2.

FCAW welding process of weld joint 009 located on PCMK SEG055A. Welder is identified as 201215 ZPMC QC is identified as Li Ming Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-TC-U4B-F.

BAY#10

This QA Inspector randomly observed the following work in progress.

This QA Inspector observed ZPMC welders 057244, 050041 and 052075 performing buttering with the help of FCAW processes on skin 'A' of north tower lift four. The ZPMC QC identified as Wang Hao. The welding variable recorded by QC appeared to comply with WPS -345-FCAW-2G (2F) Repair. ZPMC weld repair report noted as T-WR2173.

TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress.

OBG SEGMENT 1AAE-1AE

SMAW welding process of weld joint 003 located on PCMK OBE01A. Welder is identified as 045138 ZPMC QC is identified as Wang Li Yang. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F) Repair. The weld repair report noted as B-WR7764 and ZPMC Ultrasonic inspection report noted as B787-UT-8332-5.

INCIDENT

OUTSIDE YARD

OBG SEGMENT 6AW

This Caltrans Quality Assurance (QA) Inspector observed ZPMC welding personnel performed SMAW welding on weld SEG27F-036 at OBG Segment 6AW near PP40 in outside yard, "Longitudinal diaphragm to bottom panel while the base material was wet. See the attached photos for additional information. Regarding this issue incident report was issued.

BAY#09

MAGNETIC PARTICLE INSPECTION

This Caltrans QA Inspector performed approximately 15% Magnetic Particle Testing verification of OBG Deck panel U rib tack welds after ZPMC initial MT inspection. ZPMC personnel have made repairs of areas found

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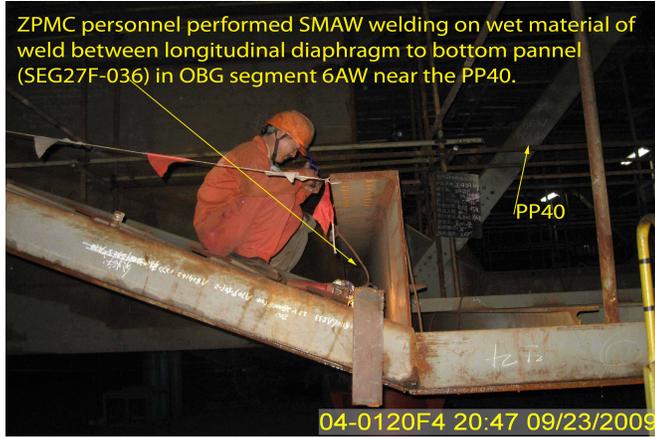
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unacceptable. ZPMC has not performed the final MT of the repair areas. No relevant indications were found during this in process inspection. The Following panels were tested

DP3044-001-001 through 010

DP3047-001-001 through 008

Unless otherwise noted, all work observed on this dated 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 Serge Sinevod 13482570045, who represents the Office of Structural Materials for your project.

Inspected By: Utekar,Shrikant

Quality Assurance Inspector

Reviewed By: Clifford,William

QA Reviewer
