

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-009333**Date Inspected:** 23-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Wei Wei**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**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 #1

Magnetic Particle inspection

This Q.A Inspector performed Magnetic Particle Testing of approximately 15% of the area previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated a (M.T) report for this date. The members are identified as the Floor Beam Designation are as follows.

FB204-016-086, 30, 029, 35, 36, 34, 03, 04

FB204-014-17, 16, 22, 18, 15

FB205-015-01, 02, 05, 041

FB205-013-010, 11, 04, 15

FB204-015-086, 030, 28, 36, 34

BAY#2

Green Tag

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The following green tags issued for OBG components after completing the NDT requirements are:

1. SSD16/16A-PP092-Green tag No-009563
2. SSD19/19A-PP091-Green tag No-009562
3. SSD19/19A-PP089-Green tag No-009560
4. SSD17/17A-PP087-Green tag No-009558

BAY #2

Magnetic Particle Inspection

This Q.A Inspector performed Magnetic Particle Testing of base metal repair area on segment 1AAE, Location A00, Plate Detail-X185A, previously tested and accepted by ZPMC Quality control personnel. The members are identified as the segment 1AAE.

BAY #5

Visual Inspection

This Q.A Inspector performed Visual Testing of the area previously tested and accepted by ZPMC Quality control personnel. The members are identified as the Cable tray support Designation are as follows.

CTS1E1 (A/B/C/D)

CTS1E (H)

BAY#03

This QA Inspector randomly observed the following work in progress

FCAW welding process of weld joint 16 located on PCMK FB010-038. Welder is identified as 208035 ZPMC QC is identified as Shi Lei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3

FCAW welding process of weld joint 100 located on PCMK CSD4-PP76. Welder is identified as 204338 ZPMC QC is identified as Zhang Yaxu. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

FCAW welding process of weld joint 101 located on PCMK CSD4-PP80. Welder is identified as 204338 ZPMC QC is identified as Zhang Yaxu. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

FCAW welding process of weld joint 27 located on PCMK CA58. Welder is identified as 0271028 ZPMC QC is identified as Xin Dong Hen. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3

FCAW welding process of weld joint 39 located on PCMK FB024-011. Welder is identified as 044790 ZPMC

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QC is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

BAY#2

This QA Inspector randomly observed the following work in progress

FCAW welding process of weld joint 08 located on PCMK FB003-167. Welder is identified as 048433 ZPMC QC is identified as Wang Liang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-TC-U4B-F.

FCAW welding process of weld joint 011 located on PCMK LD002-033. Welder is identified as 058075 ZPMC QC is identified as Wang Liang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2331-TC-P4-F.

BAY#2

This Quality Assurance (QA) Inspector observed In Bay#2 FB 014-040 was damaged during handling. Offset observed more than 20mm. Incident report issued.

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 Eric Tsang +(86) 150.0042.2372, who represents the Office of Structural Materials for your project.

Inspected By:	Utekar,Shrikant	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
