

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-009356**Date Inspected:** 20-Sep-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:	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 / Tower Subassemblies	

Summary of Items Observed:

On this day Caltrans OSM Quality Assurance (QA) Inspector Stefan Holmes was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China.

This QA Inspector observed the following work in progress:

SMAW welding of weld joint 10B located on PCMK WD1-A305-77M-4. Welder is identified as 053753. ZPMC QC is identified as Xu Xian Ping. The welding variables recorded by QC appeared to comply with the Applicable WPS.

SMAW welding of weld joint 08B located on PCMK WD1-A305-65M-1. Welder is identified as 067707. ZPMC QC is identified as Xu Xian Ping. The welding variables recorded by QC appeared to comply with the Applicable WPS.

SMAW welding of weld joint 009 located on PCMK WSD1-DPSA4-13B/B. Welder is identified as 048800. ZPMC QC is identified as Xu Xian Ping. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint 005 located on PCMKs TR1C-PP072, TR6C-PP056 and TR6C-PP070. Welder is identified as 051784. ZPMC QC is identified as Li Yong. The welding variables recorded by QC appeared to comply with the Applicable WPS.

QA Inspector performed VT for Cable Tray assemblies previously tested and accepted by ZPMC Quality Control personnel. The assemblies reviewed are as follows:

1. CTS4D (A,B,J,K)

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2. CTS4D1 (H,I,J)
3. CTS4F (B,C)
4. CTS4E1 (G)

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 members are identified as OBG Traveller Rail Components. The weld designations reviewed are as follows:

1. 10TR3-019-003,004
2. 10TR3-016-003,004
3. 10TR3-014-003,004
4. 10TR3-013-003,004
5. 10TR3-007-003,004
6. 10TR3-018-003,004
7. 10TR3-017-003,004
8. 10TR3-012-003,004
9. 10TR3-008-003,004
10. 10TR3-015-003,004

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 Traveller Rail and Tower Components. The weld designations reviewed are as follows:

1. 10TR3-019-003,004
2. 10TR3-016-003,004
3. 10TR3-014-003,004
4. 10TR3-013-003,004
5. 10TR3-007-003,004
6. 10TR3-018-003,004
7. 10TR3-017-003,004
8. 10TR3-012-003,004
9. 10TR3-008-003,004
10. 10TR3-015-003,004
11. WSD1-DPSA4-11A/B-3-8,1,26
12. WSD1-DPSA4-16-3-8
13. WSD1-DPSA4-11B/B-27,2
14. WSD1-DPSA4-11B/B-01,11,7,6,18,19,14,15
15. NSD1-DPSA4-9B/B-3
16. NSD1-DPSA4-9B/B-20-25
17. NSD1-DPSA4-9B/B-4-7,12,13,16,17
18. NSD1-DPSA4-1B/B-4,5,8,9,12,13,16,17
19. NSD1-DPSA4-1B/B-20-25

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20. NSD1-DPSA4-1B/B-3

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the 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 , who represents the Office of Structural Materials for your project.

Inspected By:	Holmes,Stefan	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
