

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-009357**Date Inspected:** 18-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:

FCAW welding of weld joint 041 located on PCMK SP206-011-031. Welder is identified as 037780. 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 019 located on PCMK SP203A-011-009. Welder is identified as 066268. 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 003 located on PCMK TR5B-PP085 and TR5B-PP075. Welder is identified as 066064. ZPMC QC is identified as Li Yong. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint 003 located on PCMKs TR5B-PP071, TR5B-PP073 and TR5B-PP061. Welder is identified as 068858. ZPMC QC is identified as Li Yong. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint 057-060 located on PCMK BK001-033. Welder is identified as 058174. ZPMC QC is identified as Li Yong. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint 026-027 located on PCMKs BK001-033. Welder is identified as 053742. ZPMC QC is identified as Li Yong. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint 051-052 located on PCMKs BK001-033. Welder is identified as 058174. ZPMC QC

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is identified as Li Yong. The welding variables recorded by QC appeared to comply with the Applicable WPS. FCAW welding of weld joint 014-015 located on PCMKs BK001-033. Welder is identified as 053742. ZPMC QC is identified as Li Yong. The welding variables recorded by QC appeared to comply with the Applicable WPS. FCAW welding of weld joint 051-052 located on PCMKs BK001-034. Welder is identified as 215185. ZPMC QC is identified as Li Yong. The welding variables recorded by QC appeared to comply with the Applicable WPS. FCAW welding of weld joint 014-015 located on PCMKs BK001-034. Welder is identified as 215009. ZPMC QC is identified as Li Yong. The welding variables recorded by QC appeared to comply with the Applicable WPS. FCAW welding of weld joint 057-060 located on PCMKs BK001-034. Welder is identified as 215185. ZPMC QC is identified as Li Yong. The welding variables recorded by QC appeared to comply with the Applicable WPS. FCAW welding of weld joint 036-037 located on PCMKs BK001-034. Welder is identified as 215009. ZPMC QC is identified as Li Yong. The welding variables recorded by QC appeared to comply with the Applicable WPS.

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. 11TR2-012-003,004
2. 11TR2-013-003,004
3. 11TR2-014-003,004
4. 11TR2-015-003,004
5. 11TR2-001-001,002
6. 11TR2-002-001,002
7. 11TR2-004-001,002
8. 11TR2-005-001,002
9. TR7B-PP8.5-001-005
10. TR8B-PP8.5-001-005

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
