

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-009468**Date Inspected:** 26-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, Liu Xiao Zhong**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.

This QA Inspector observed ZPMC welder Mr. Zhu Tang Quan stencil 069043 performing FCAW process for the weld joint 78 located on PCMK WSTL3-4B/K. The QA Inspector observed that Mr. Zhu Tang Quan is certified to make this weld. ZPMC QC Liu Xiao Zhong monitoring this welding. The welding variables recorded by QC appeared to comply with the Caltrans engineer approved procedure i.e. WPS-B-T-2331-TC-P4-F.

This QA Inspector observed ZPMC welder Mr. Yang Hong Jun stencil 070254 performing FCAW process for the weld joint 77 located on PCMK WSTL3-4B/K. The QA Inspector observed that Mr. Yang Hong Jun is certified to make this weld. ZPMC QC Liu Xiao Zhong monitoring this welding. The welding variables recorded by QC appeared to comply with the Caltrans engineer approved procedure i.e. WPS-B-T-2332-TC-P4-F.

This QA Inspector observed ZPMC welder Mr. Wang Shouru stencil 042218 performing FCAW process for the weld joint 78 located on PCMK WSTL3-4B/K. The QA Inspector observed that Mr. Wang Shouru is certified to make this weld. ZPMC QC Liu Xiao Zhong monitoring this welding. The welding variables recorded by QC appeared to comply with the Caltrans engineer approved procedure i.e. WPS-B-T-2331-TC-P4-F.

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This QA Inspector observed ZPMC welder Mr. Liu Fiquan stencil 070140 performing FCAW process for the weld joint 77 located on PCMK WSTL3-4B/K. The QA Inspector observed that Mr. Liu Fiquan is certified to make this weld. ZPMC QC Liu Xiao Zhong monitoring this welding. The welding variables recorded by QC appeared to comply with the Caltrans engineer approved procedure i.e. WPS-B-T-2332-TC-P4-F.

BAY#10

This QA Inspector randomly observed the following work in progress.

This QA Inspector observed ZPMC welder Mr. Zhang Jin Long stencil 057220 performing SMAW process for the weld joint 4A located on PCMK SSSL4-1B/L. The QA Inspector observed that Mr. Zhang Jin Long is certified to make this weld. ZPMC QC Shi Jiang Wei monitoring this welding. The welding variables recorded by QC appeared to comply with the Caltrans engineer approved procedure i.e. WPS-B-P-2214-B-U2.

This QA Inspector observed ZPMC welder Mr. Bi Chun Long stencil 040343 performing FCAW process for the weld joint 3A located on PCMK SSSL4-4B/L. The QA Inspector observed that Mr. Bi Chun Long is certified to make this weld. ZPMC QC Shi Jiang Wei monitoring this welding. The welding variables recorded by QC appeared to comply with the Caltrans engineer approved procedure i.e. WPS-B-T-2232-C-U2-F.

This QA Inspector observed ZPMC welder Mr. Yu Chaoye stencil 053869 performing FCAW process for the weld joint 3A located on PCMK SSSL4-4B/L. The QA Inspector observed that Mr. Yu Chaoye is certified to make this weld. ZPMC QC Shi Jiang Wei monitoring this welding. The welding variables recorded by QC appeared to comply with the Caltrans engineer approved procedure i.e. WPS-B-T-2232-C-U2-F.

This QA Inspector observed ZPMC welder Mr. Bu Xuezheng stencil 052075 performing FCAW process for the weld joint 55 located on PCMK SSSL4-1J/L. The QA Inspector observed that Mr. Bu Xuezheng is certified to make this weld. ZPMC QC Wang Hao monitoring this welding. The welding variables recorded by QC appeared to comply with the Caltrans engineer approved procedure i.e. WPS-B-T-4333-TC-P5-F.

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 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. This QA Inspector did not generate a magnetic particle Inspection(M.T) report for this date.

DP3053-001-001 through 010

DP3029-001-001 through 008

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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
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Reviewed By:	Dawson,Paul	QA Reviewer
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