

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-009474**Date Inspected:** 08-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name: Xu Xian Ping
Inspected CWI report: Yes No N/A
Electrode to specification: Yes No N/A
Qualified Welders: Yes No N/A
Approved Drawings: Yes No N/A

CWI Present: Yes No
Rod Oven in Use: Yes No N/A
Weld Procedures Followed: Yes No N/A
Verified Joint Fit-up: Yes No N/A
Approved WPS: Yes No N/A
Delayed / Cancelled: Yes No N/A

Bridge No: 34-0006**Component:** OBG & TOWER Components**Summary of Items Observed:**

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

BAY 1**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 member is identified as OBG Component. The weld designations reviewed are as follows:

1. CB202C – 015 – 001; 004

BAY 2

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint # 052 located on Floor Beam FB3047 – 001. Welder is identified as 062438.

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ZPMC QC is identified as Zhang Hai Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2233 – Tc – U4b – F.

FCAW process welding of weld joint # 050 located on Floor Beam FB3047 – 001. Welder is identified as 045209.

ZPMC QC is identified as Zhang Hai Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

FCAW process welding of weld joint # 008 located on Floor Beam FB3047 – 001. Welder is identified as 062438.

ZPMC QC is identified as Zhang Hai Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2133.

This QA Inspector observed the following work not in compliance:

During a random visual inspection of Floor Beams located in BAY 2, observed ZPMC performing a weld repair on Floor Beam FB3030-003-096 as per weld repair report B-WR 7901. During this repair process it was observed the top of the cope hole area had been arc gouged approximately 14mm in length and 9mm in deep. The nominal thickness of this base metal plate is 12mm.

For Further details please see the incident report: - 040120F4_TL015_B227_10-08-09_Base Material Damage.

BAY 3

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 member is identified as OBG Component. The weld designations reviewed are as follows:

1. CSD6 – PP095 – 035~038
2. CSD6 – PP102 – 035~038
3. CSD6 – PP101 – 035~038
4. CSD6 – PP103 – 035~038
5. CSD6 – PP097 – 035~038
6. CSD5 – PP095 – 035~038
7. CSD3 – PP100 – 095~105
8. CSD9 – PP099 – 035~038
9. CSD4 – PP098 – 095~105
10. CSD9 – PP096 – 095~100
11. CSD5 – PP101 – 033~038
12. CSD4 – PP100 – 095~105
13. CSD5 – PP099 – 095~105
14. CSD3 – PP101 – 033~038
15. CSD6 – PP096 – 033~038
16. CSD9 – PP102 – 095~100

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17. CSD3 – PP098 – 095~105
18. CSD3 – PP097 – 033~038
19. CSD5 – PP103 – 033~038
20. CSD3 – PP095 – 033~038
21. CSD3 – PP103 – 033~038
22. CSD7 – PP102 – 033~038
23. CSD5 – PP097 – 033~038
24. CSD6 – PP103 – 095~100
25. CSD7 – PP096 – 033~038

BAY 5

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint # 002 located on Traveler Rail 10TR2 – 009. Welder is identified as 215689.

ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – B – U2 – F.

FCAW process welding of weld joint # 002 located on Bike Path BK001 – 038. Welder is identified as 215009.

ZPMC QC is identified as Wang Liyang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – Tc – U4c – F.

FCAW process welding of weld joint # 014 located on Traveler Rail 11TR2 – 013. Welder is identified as 068858.

ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U5 – F.

FCAW process welding of weld joint # 002 located on Bike Path BK001 – 039. Welder is identified as 217185.

ZPMC QC is identified as Wang Liyang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – Tc – U4c – F.

FCAW process welding of weld joint # 002 located on Traveler Rail 10TR2 – 009. Welder is identified as 215689.

ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – B – U2 – F.

FCAW process welding of weld joint # 002 located on Bike Path BK001 – 037. Welder is identified as 205390.

ZPMC QC is identified as Wang Liyang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – Tc – U4c – F.

BAY 6

Tower

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This QA Inspector observed the following work in progress:

SMAW process welding of weld joint #2A located on Tower Strut WD1 – A305 – 53M – 1. Welder is identified as 067707. ZPMC QC is identified as Zhao Chen Sun. The welding variables recorded by QC appeared to comply with the WPS – 485 – SMAW – 2G (2F) – FCM – Repair – 1.

SMAW process welding of weld joint #2A located on Tower Strut WD1 – A305 – 77M – 3. Welder is identified as 067707. ZPMC QC is identified as Zhao Chen Sun. The welding variables recorded by QC appeared to comply with the WPS – 485 – SMAW – 2G (2F) – FCM – Repair – 1.

Unless otherwise noted, all work observed on this date 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 - 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Sandeep	Quality Assurance Inspector
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Reviewed By:	Hall,Steven	QA Reviewer
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