

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-009513**Date Inspected:** 05-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:** Li zhi jiang**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, D.Sukanthan was present during the time noted above for observations relative to the work being performed.

TOWER # SOUTH TOWER LIFT 1

This QA inspector performed Magnetic Particle Test of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an Magnetic Particle Test report for this date. The member is identified as South Tower Lift 1 Handrail at Skin A. The weld designations reviewed are as follows:

(E74-SSD1-A-33M-2-001,002,003)

(E74-SSD1-A-33M-3-001,002,003)

This QA Inspector randomly observed the following work in progress:

OBG # BAY 02**Flux Cored Arc Welding Process:**

Welding of weld joint -060,061 located on PCMK FB3047-001. Welder is identified as 045203. ZPMC QC is identified as Yang Qing fang. The welding variables recorded by QC appeared to comply with the

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WPS-B-T-2132-3.

Welding of weld joint –027,028 located on PCMK FB3027-001. Welder is identified as 045209. ZPMC QC is identified as Yang Qing fang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

Welding of weld joint –032,033 located on PCMK FB3042-001. Welder is identified as 206358. ZPMC QC is identified as Yang Qing fang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

Welding of weld joint –030,031 located on PCMK FB3046-001. Welder is identified as 045203. ZPMC QC is identified as Yang Qing fang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

OBG # BAY 05, Cross Beam 16

Flux Cored Arc Welding Process:

Welding of weld joint –003 located on PCMK CB202C-016. Welder is identified as 217185. ZPMC QC is identified as Zheng zhi wei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-B-U2-F.

Submerged Arc Welding Process:

Welding of weld joint –002 located on PCMK CB202C-016. Welder is identified as 215248. ZPMC QC is identified as Zheng zhi wei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-B-L2C-S-2.

OBG # BAY 01

During a random visual inspection of OBG Cross Beam # 15. The Caltrans Quality Assurance (QA) Inspector observed that ZPMC personnel had welded third time repairs without the Engineers approval. The following two joints FB 205-045-013 and FB204-047-009 have been previously repaired three (3) times by ZPMC personal, due to non-conforming indications found with ultrasonic testing (UT).

The QA Inspector informed ZPMC QC Mr. Tian Lei that the QA Inspector will be issuing incident report.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

As mention above

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 150-00422372, who represents the Office of Structural Materials for

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your project.

Inspected By:	Sukanthan,Dhanasingh	Quality Assurance Inspector
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Reviewed By:	Hall,Steven	QA Reviewer
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