

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-009531**Date Inspected:** 10-Oct-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

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|------------------------------------|----------------------------|----------------------------------|------------|----|
| CWI Name: | Wang Chuan Ging , Xu Yumin | 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 #10

This QA Inspector randomly observed the following work in progress.

SOUTH TOWER LIFT #4

Flux Cored Arc welding process of weld joint 142 located on PCMK SSSL4-1C/L. Welder is identified as 057244 ZPMC QC is identified as Wang Chuan Ging. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P5-F.

Flux Cored Arc welding process of weld joint 143 located on PCMK SSSL4-1C/L. Welder is identified as 057180 ZPMC QC is identified as Wang Chuan Ging. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P5-F.

Flux Cored Arc welding process of weld joint 138 located on PCMK SSSL4-1G/L. Welder is identified as 053116 ZPMC QC is identified as Wang Chuan Ging. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P5-F.

Flux Cored Arc welding process of weld joint 139 located on PCMK SSSL4-1G/L. Welder is identified as

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054069 ZPMC QC is identified as Wang Chuan Ging. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P5-F.

Flux Cored Arc welding process of weld joint 156 located on PCMK SSSL4-1K/L. Welder is identified as 040533 ZPMC QC is identified as Sun Tian Liang. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P5-F.

Flux Cored Arc welding process of weld joint 127 located on PCMK SSSL4-1K/L. Welder is identified as 040343 ZPMC QC is identified as Sun Tian Liang. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-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. This Quality Assurance (QA) did not generate Magnetic particle Inspection (MT) report for above inspection. No relevant indications were found during this in process inspection. The Following panels were tested

DP3063-001-001 through 08

DP3021-001-001 through 06

TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress.

OBG SEGMENT# 1AW-1BW

This Quality Assurance (QA) Inspector observed ZPMC welders 220067, 049769, 054467, 048659 are performing Shielded Metal Arc Welding (SMAW) on the weld joint OBW1A-007 side panel splice weld joint between OBG segment 1AW and 1BW counter weight side. ZPMC QC (CWI) is identified as Xu Yumin. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-3G (3F)-FCM-Repair-1. The critical weld repair report identified as B-CWR831.

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

Summary of Conversations:

No relevant conversations.

Comments

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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.

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| Inspected By: | Utekar,Shrikant | Quality Assurance Inspector |
| Reviewed By: | Dawson,Paul | QA Reviewer |
