

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-009609**Date Inspected:** 20-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

This QA Inspector observed the following work in progress:

FCAW process Repair welding of weld joint # 001 located on Counter Weight CW001B – PP048. Welder is identified as 219188. ZPMC QC is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U4b – F – 1.

FCAW process Repair welding of weld joint # 010 located on Counter Weight CW002B – PP100. Welder is identified as 219189. ZPMC QC is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2233 – B – L1a – F.

BAY 2

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This QA Inspector observed the following work in progress:

FCAW process welding of weld joint # 022 located on FB3086 – 001. Welder is identified as 045203. ZPMC QC is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

FCAW process welding of weld joint # 146 located on FB3054 – 001. Welder is identified as 058245. ZPMC QC is identified as Zhang Hai Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U4b – F.

FCAW process welding of weld joint # 006 located on FB3001 – 001. Welder is identified as 045209. ZPMC QC is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2133.

BAY 3

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint # 011 located on Longitudinal Diaphragm LD008 – 005. Welder is identified as 208035. ZPMC QC is identified as Yin Donghai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

FCAW process welding of weld joint # 011 located on Longitudinal Diaphragm LD003 – 060. Welder is identified as 044830. ZPMC QC is identified as Yin Donghai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

BAY 5

The following NDT inspection carried out as per the ZPMC submitted Notification No. 004443

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. CB202B – 016 – 001 ~ 004

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint # 013 located on Traveler Rail 10TR3 – 027. Welder is identified as 068858.

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

FCAW process welding of weld joint # 007 located on Traveler Rail 10TR3 – 032. Welder is identified as 215689.

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

FCAW process welding of weld joint # 014 located on Traveler Rail 10TR3 – 010. Welder is identified as 217805.

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

BAY 6

Tower

This QA Inspector observed the following work in progress:

SMAW process welding of weld joint #7B located on Tower Strut WD1 – A305 – 65M – 2. Welder is identified as 048617. 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 #8A located on Tower Strut WD1 – A305 – 65M – 4. Welder is identified as 053753. 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 #8A located on Tower Strut WD1 – A305 – 77M – 2. Welder is identified as 048617. 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.

OUTSIDE YARD

The following NDT inspection carried out as per the ZPMC submitted Notification No. 004434 & 004435

Visual Inspection Testing

This QA inspector performed VT of the area previously tested and accepted by ZPMC Quality Control personnel. The members are identified as OBG Components. The identified component reviewed as follows:

1. DP430 – 001 – 001 ~ 010
2. DP349 – 001 – 001 ~ 008
3. DP265 – 001 – 001 ~ 010

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 members are identified as OBG Components. The weld designations reviewed are as follows:

1. DP430 – 001 – 001 ~ 010 – Green Tag # 007900
2. DP349 – 001 – 001 ~ 008 – Green Tag # 007901
3. DP265 – 001 – 001 ~ 010 – Green Tag # 007899

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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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