

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-009718**Date Inspected:** 22-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 CW002A – PP094. 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 – 2132 – 2.

FCAW process Repair welding of weld joint # 002 located on Counter Weight CW002B – PP084. Welder is identified as 054460. 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 # 001 located on Counter Weight CW002A – PP104. Welder is identified as 059450. ZPMC QC is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 2.

WELDING INSPECTION REPORT

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BAY 2

The following NDT inspection carried out as per the ZPMC submitted Notification No. 004453

Ultrasonic Testing

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member is identified as OBG Component. The weld designations reviewed are as follows:

1. FB3030 – 001 – 095; 096

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint # 039 located on FB3081 – 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 # 031 located on FB3065 – 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 – 2133.

FCAW process welding of weld joint # 087 located on FB3081 – 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 – 2132 – 3.

BAY 5

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint # 010 located on Traveler Rail 10TR3 – 013. 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.

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 # 008 located on Traveler Rail 10TR1 – 024. 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 – 2132 – 3.

FCAW process welding of weld joint # 011 located on Traveler Rail 10TR3 – 013. 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 – 2132.

BAY 6

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Tower

This QA Inspector observed the following work in progress:

SMAW process welding of weld joint #7B located on Tower Strut WD1 – A305 – 77M – 1. 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 #2A located on Tower Strut WD1 – A305 – 77M – 4. 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 #7A located on Tower Strut WD1 – A305 – 77M – 1. 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.

BAY 9

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint # 310 located on Deck Panel DP3043 – 001. Welder is identified as 059378. ZPMC QC is identified as Chen Shigang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2133.

FCAW process welding of weld joint # 088 located on Deck Panel DP3043 – 001. Welder is identified as 059443. ZPMC QC is identified as Chen Shigang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2233 – Tc – U4b – F.

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
Reviewed By:	Hall,Steven	QA Reviewer
