

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-009877**Date Inspected:** 26-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:** Chen Xi**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.

OBG # BAY 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 Counter Weight. Inspection Notification number- 004482. The weld designations reviewed are as follows:

(CW001-PP056-131,132,133) Green Tag # 10796

(CW001A-PP056-001)

(CW001-PP066-131,132,133) Green Tag # 10797

(CW001A-PP066-001)

OBG # BAY 2

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 Floor beam. Inspection Notification number- 004479. The weld designations reviewed are as follows:

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

(FB3030-003-002,004,071,072,079,080,073,074,081,082,047,048,049,050,055,056,057,058)

(FB3059-001-002,004,071,072,079,080,073,074,081,082,047,048,049,050,055,056,057,058)

Green Tag # 10724

(FB3065-002-051,052,053,054,059,060,061,062,003,005,091,092,093,094,083,084,085,086)

Green Tag # 10729

(FB3030-001-002,004,071,072,079,080,073,074,081,082,047,048,049,050,055,056,057,058)

(FB3003-001-002,004,071,072,079,080,073,074,081,082,047,048,049,050,055,056,057,058)

Green Tag # 10717

This QA Inspector randomly observed the following work in progress:

OBG # BAY 2

Flux Cored Arc Welding Process:

Welding of weld joint –058,059 located on PCMK FB3054-001. Welder is identified as 045209. ZPMC QC is identified as Zhan hai feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-TC-U4b-F.

Welding of weld joint –113,149 located on PCMK FB3031-001. Welder is identified as 045203. ZPMC QC is identified as Zhan hai feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

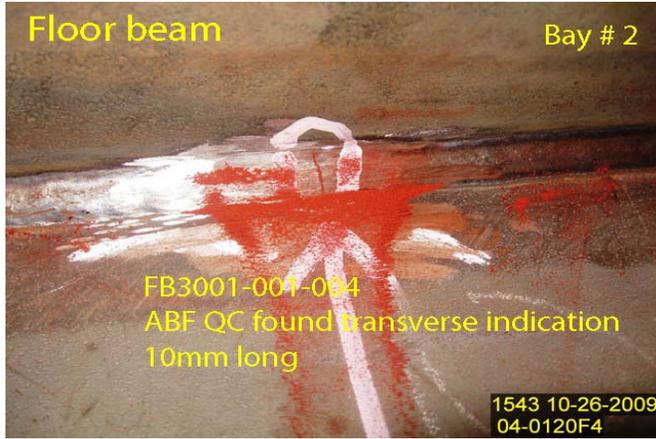
Welding of weld joint –134,135 located on PCMK FB3031-001. Welder is identified as 062438. ZPMC QC is identified as Zhan hai feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133.

During in-process visual inspection of OBG floor beam components in Bay 2, This QA inspector observed that ABF QC Magnetic particle Testing (MT) Personnel identified as Mr. Fang yun long appears to have rejected one (1) transverse linear indication. The weld designation as identified on the material is FB3001-001-004. See attached picture.

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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



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 your project.

Inspected By: Sukanthan,Dhanasingh

Quality Assurance Inspector

Reviewed By: Hall,Steven

QA Reviewer