

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-010973**Date Inspected:** 19-Dec-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:** Liu Fawen**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:** Orthotropic Box Girder (OBG) & Tower Com**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

BAY 2**Green Tags**

The following green tags issued for OBG components after completing the NDT requirements are:

1. FB3081 – 001 – Green Tag # 11346
2. FB3007 – 001 – Green Tag # 11269

BAY 3

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW):

Weld joint # 022 located on Longitudinal Diaphragm LD3011 – 001. Welder is identified as 204338. ZPMC Quality Control (QC) Inspector is identified as Guo Yuan Ting. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

Weld joint # 019 located on Longitudinal Diaphragm LD3012 – 001. Welder is identified as 208035. ZPMC

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Quality Control (QC) Inspector is identified as Guo Yuan Ting. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

Weld joint # 014 located on Longitudinal Diaphragm LD3011 – 001. Welder is identified as 204338. ZPMC Quality Control (QC) Inspector is identified as Guo Yuan Ting. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 004893

Ultrasonic Testing (UT)

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

1. CA094 – 041; 042; 018; 054
2. CA093 – 017; 018
3. CA090 – 070; 021
4. LD3007 – 001 – 017
5. LD3008 – 001 – 018
6. LD3009 – 001 – 012; 026
7. LD3010 – 001 – 008; 022
8. LD3011 – 001 – 006; 009
9. LD3012 – 001 – 006

BAY 5

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW):

Weld joint # 007 located on Traveler Rail 11TR4 – 001. Welder is identified as 217185. ZPMC Quality Control (QC) Inspector is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U5 – F.

Weld joint # 010 located on Traveler Rail 10TR1 – 029. Welder is identified as 066359. ZPMC Quality Control (QC) Inspector is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U5 – F.

Weld joint # 007 located on Traveler Rail 10TR5 – 001. Welder is identified as 204342. ZPMC Quality Control (QC) Inspector is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U5 – F.

Weld joint # 013 located on Traveler Rail 10TR5 – 002. Welder is identified as 067601. ZPMC Quality Control (QC) Inspector is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U5 – F.

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Weld joint # 014 located on Traveler Rail 10TR1 – 014. Welder is identified as 067275. ZPMC Quality Control (QC) Inspector is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U5 – F.

BAY 6

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 004891

Visual Inspection Testing (VT)

This QA inspector performed VT of the area previously tested and accepted by ZPMC Quality Control personnel. The member is identified as Tower Component. The identified component reviewed as follows:

WEST TOWER LIFT 2 STRUT PLATE

1. WD1 – A305 – 53M – 1

Ultrasonic Testing (UT)

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 Tower Component. The weld designations reviewed are as follows:

WEST TOWER LIFT 2 STRUT PLATE

1. WD1 – A305 – 53M – 1 – 1; 2; 7; 8; 9; 10 (A/B)

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
