

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-012397**Date Inspected:** 02-Feb-2010**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/Liu Fa Wen**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 Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Hiranch Patel, was present during the times noted above for observations relative to the work being performed.

Bay #12

This QA inspector performed UT of wrong drilled holes repair area 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 Components. The area designations reviewed are as follows:

-(ND1-A213-17A/B~21A/B)

-(ND1-A229-03A/B~06A/B)

Bay#12

This QA inspector performed MT of wrong drilled holes repair area 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 Tower Components. The area designations reviewed are as follows:

-(ND1-A213-17A/B~21A/B)

-(ND1-A229-03A/B~06A/B)

Bay#12

This QA inspector performed random visual inspection of wrong drilled holes repair area previously tested and accepted by ZPMC Quality Control personnel. The member is identified as Tower Components. The area designations reviewed are as follows:

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-(ND1-A213-17A/B~21A/B)

-(ND1-A229-03A/B~06A/B)

Bay#1

FCAW welding of weld joint 21TR4-002-003 located on Traveler Rail 21TR4. Welder is identified as 215397 (1G). ZPMC QC is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-Tc-U5-F.

FCAW welding of weld joint 21TR1-001-001 located on Traveler Rail 21TR1. Welder is identified as 219188 (1G). ZPMC QC is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-Tc-U5-F.

FCAW welding of weld joint 21TR1-001-003 located on Traveler Rail 21TR1. Welder is identified as 219188 (1G). ZPMC QC is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-Tc-U5-F.

Bay#2

Weld repair by FCAW welding of weld joint 11TR2-006-014 located on Traveler Rail 11TR2. Welder is identified as 201912 (1G). ZPMC QC is identified as Yan Qing Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-Tc-U5-F.

Weld repair by FCAW welding of weld joint 10TR1-010-014 located on Traveler Rail 10TR1. Welder is identified as 201981 (1G). ZPMC QC is identified as Yan Qing Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-Tc-U5-F.

Weld repair by FCAW welding of weld joint 10TR2-002-014 located on Traveler Rail 10TR2. Welder is identified as 201981 (1G). ZPMC QC is identified as Yan Qing Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-Tc-U5-F.

Bay#3

FCAW welding of weld joint 20TR2-015-015 located on Traveler Rail 20TR2. Welder is identified as 214945 (1G). ZPMC QC is identified as Guo Yuan Ting. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-Tc-U5-F.

FCAW welding of weld joint 20TR2-012-012 located on Traveler Rail 20TR2. Welder is identified as 044824 (1G). ZPMC QC is identified as Guo Yuan Ting. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-Tc-U5-F.

Unless otherwise noted, all observed on this date 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 Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Patel,Hiranch	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
