

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-013765**Date Inspected:** 20-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yan Hua**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 COMPONENT**Summary of Items Observed:**

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

In process Inspection

Out Side Segment Yard

This QA Inspector observed the following work in progress:

FCAW in the 3G position for the OBG Segment 10CE, weld No. SEG064D-065. The welder is identified as #044801. ZPMC QC is identified as Mr. Wang Xiang Qin. The welding variables recorded by QC appear to comply with WPS-B-T-2213-Tc-U4b-F.

SMAW in the 4G position for the OBG Segment 10CE, weld No. SEG057B-006. The welder is identified as #205718. ZPMC QC is identified as Mr. Li Ping. The welding variables recorded by QC appear to comply with WPS-345-SMAW-4G (4F)-FCM-REPAIR-1. The weld repair report is B-WR-11288.

Green Tagging

This QA inspector performed Visual Inspection for Green Tagging which were previously tested and accepted by ZPMC Quality Control personnel and ABF QA personnel. The members are identified as Tower 13M Exterior Diaphragm.

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The Exterior Diaphragms welds are WD1-A1-4, 5, 54, 55.

The green Tag number is identified as 12498.

Magnetic Particle Testing (MPT)

This Quality Assurance (QA) Inspector performed Visual inspection and verification of Magnetic Particle Testing (MT) 15% for Tower 13 meter Facade welds area. This QA inspector generated a (MT) report for this date .This weld was previously tested and accepted by ZPMC QC MT technicians.

The weld designations reviewed are as follows:

ND-A261-001, 004, 13, 18

ND1-A236-1, 2

ND1-A214-8-1, 3

ND1-A216-8-9, 12

SD1-A262-1, 4, 13, 18

SD1-A237-1, 2

ND1-A214-7-1, 8

ND1-A216-7-9, 11

During random in-process visual inspection in Bay # 14, Caltrans Quality Assurance (QA) Inspector observed ZPMC personnel (205098) welding being performed welding prior to achieving the required pre-heat temperature.

This occurred on Corner assembly Diaphragm at panel point PP117 (material A709M-Gr-345 to A709M HFS485WT2, thickness 30mm). The weld joint identified as CA3010E-203. The measured temperature was below 60 deg C; the required preheat temperature according to approved WPS is Min.100 deg C. The WPS is WPS-B-T-4113-2.

The QA inspector informed to ZPMC QC personnel Mr. Xu Tao to do Magnetic Particle Testing at that lack of pre heated area.

The QA inspector did not generate any incident report for this date.

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 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By: Bera,Subhasis

Quality Assurance Inspector

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Reviewed By: Patterson,Rodney

QA Reviewer