

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-015985**Date Inspected:** 18-Jul-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:** Xu Tao**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

Bay #14

This QA Inspector observed the following work in progress:

FCAW in the 2F position for the OBG Segment 13AW, weld No. SP3099A-001-011~022. The welders are identified as #055564/044795. ZPMC QC is identified as Mr. Wang Xu. The welding variables recorded by QC appear to comply with WPS-B-T-2132.

FCAW in the 2F position for the OBG Segment 13AW, weld No. SP3099A-001-061~068. The welders are identified as #044850/044774. ZPMC QC is identified as Mr. Wang Xu. The welding variables recorded by QC appear to comply with WPS-B-T-2132.

SMAW in the 2F position for the OBG Segment 12AW, weld No. SEG3004B-010. The welder is identified as #051348. ZPMC QC is identified as Mr. Tang Ya Jun. The welding variables recorded by QC appear to comply with WPS-345-SMAW-2G(2F)-REPAIR. The weld repair report is identified as B-CWR-1691.

SMAW in the 4G position for the OBG Segment 12AW, weld No. SEG3004*-024. The welder is identified as #047864. ZPMC QC is identified as Mr. Tang Ya Jun. The welding variables recorded by QC appear to comply

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with WPS-345-SMAW-4G(4F)-REPAIR.

Bay #16

This QA Inspector observed the following work in progress:

SAW in the 1G position for the OBG Segment 13AW Longitudinal Diaphragm, weld No. LD3034-001-001. The welder is identified as #250050. ZPMC QC is identified as Mr. Li Ming Yang. The welding variables recorded by QC appear to comply with WPS-B-T-2221-B-L2c-S-2.

SAW in the 1G position for the OBG Segment 13AW Longitudinal Diaphragm, weld No. LD3034-001-003. The welder is identified as #045265. ZPMC QC is identified as Mr. Li Ming Yang. The welding variables recorded by QC appear to comply with WPS-B-T-2221-B-L2c-S-2.

Out Side Yard

This QA Inspector observed the following work in progress:

SMAW in the 2F position for the OBG Segment 11EE, weld No. SSD19-PP107-048/049. The welder is identified as #204339. ZPMC QC is identified as Mr. Li Ping. The welding variables recorded by QC appear to comply with WPS-B-P-2112-FCM-1.

SMAW in the 2F position for the OBG Segment 11EE, weld No. SSD19A-PP108-062/063. The welder is identified as #067589. ZPMC QC is identified as Mr. Li Ping. The welding variables recorded by QC appear to comply with WPS-B-P-2112-FCM-1.

SMAW in the 4F position for the OBG Segment 11DE, weld No. SSD19-PP105-191/192. The welder is identified as #043661. ZPMC QC is identified as Mr. Li Ping. The welding variables recorded by QC appear to comply with WPS-B-P-2114-FCM-1.

Magnetic Particle Testing (MPT)

This Quality Assurance (QA) Inspector performed Visual inspection and verification of Magnetic Particle Testing (MT) 15% of Bottom plate to stiffener welds. 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 is as follows:

BP3038-001-007~012,043~048

BP3065-001-013~018,025~030,037~042

Visual Inspection after Blast at 10AE

This Quality Assurance (QA) Inspector performed random visual inspection of OBG segment 10AW internal side panel and bottom panel surfaces after grit blasting. Areas that marked for repair were recorded for future repair. Areas requiring additional grinding were marked by QA and repaired by ZPMC personnel.

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

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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.

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Inspected By:	Bera,Subhasis	Quality Assurance Inspector
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Reviewed By:	Patterson,Rodney	QA Reviewer
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