

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-020047**Date Inspected:** 01-Apr-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:	Liu Hua Jie, Lu Li Qing, Geng Wei			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)		

Summary of Items Observed:

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

This QA Inspector observed the following work in progress:

Assembly, Bay 14, 12CW.

FCAW welding of weld joint SEG3006F-017, 018; located on assembly, Bay 14, 12CW. Welder is identified as 202122; ZPMC Quality Control Inspector (QC) is identified as Liu Hua Jie. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2233-TC-U4B-F.

Assembly, Bay 14, 12CW.

FCAW welding of weld joint SEG3006E-016, 017; located on assembly, Bay 14, 12CW. Welder is identified as 201215; ZPMC Quality Control Inspector (QC) is identified as Liu Hua Jie. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2233-TC-U4B-F.

Assembly, Bay 14, 12AE, Deck plate (DP3006A) to Deck plate (DP3007A).

SAW welding of weld joint SEG3001*-021; located on assembly, Bay 14, 12AE. Welder is identified as 058100; ZPMC Quality Control Inspector (QC) is identified as Geng Wei. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2221-B-L2C-S-2.

Assembly, Bay 14, 12AE, Deck plate (DP3009A) to Deck plate (DP3010A).

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

SAW welding of weld joint SEG3001*-024; located on assembly, Bay 14, 12AE. Welder is identified as 044780; ZPMC Quality Control Inspector (QC) is identified as Geng Wei. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2221-B-L2C-S-2.

Assembly, Bay 14, 12BE, Corner Assembly CA3003.

FCAW welding of weld joint CA3003-003; located on assembly, Bay 14, 12BE. Welder is identified as 055491; ZPMC Quality Control Inspector (QC) is identified as Geng Wei. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2231-TC-U4B-F.

Assembly, Bay 14, 12AE.

SMAW welding of weld joint SEG3002K-008, 007; located on assembly, Bay 14, 12AE. Welder is identified as 200113; ZPMC Quality Control Inspector (QC) is identified as Geng Wei. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-P-2214-TC-U4B-FCM-1.

Assembly, Bay 19, Suspender Brackets.

During the Quality Assurance (QA) random in-process visual inspection, this QA inspector observed AB/F Personnel performing Magnetic Particle Testing (MT) of Suspender Brackets. The attached photographs provide additional detail.

Assembly, Outside Yard, 9BW, Between PP74 & PP75.

During the Quality Assurance (QA) random in-process visual inspection, this QA inspector observed AB/F Personnel performing Ultrasonic Testing (UT) of Deck panel to Deck panel weld repair spot. Weld identified as SEG051A-003. The attached photographs provide additional detail.

Assembly, Bay 13, Mock-Up for 13AE.

During the Quality Assurance (QA) random in-process visual inspection, this QA inspector observed ZPMC caring out Mock-Up for 13AE. This QA inspector noticed following things
- BP3032-007 Bottom panel plate welding in process.

This QA Inspector carried out NDE on following

Bay 16, Tower Façade Plate.

This QA inspector performs Random Visual Testing & random Magnetic Particle Testing (MT) of approximately 15% area previously tested and accepted by ZPMC Quality Control personnel (Notification # 005454). This QA Inspector generated an MT report (TL-6028) for this date. The members are identified as

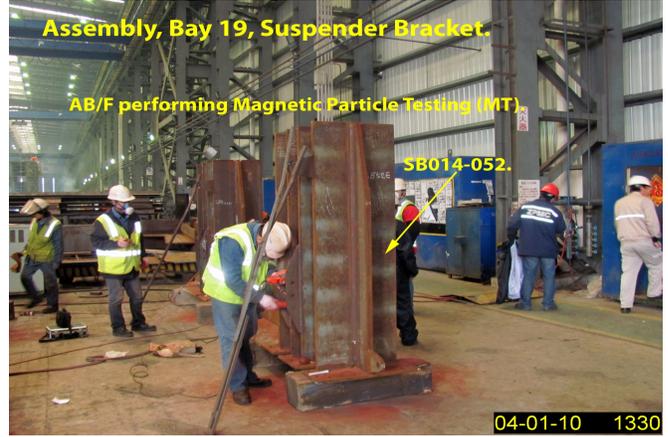
- 1) WD1-A224-3-10, 11, 22.
- 2) WD1-A145-3-6, 5.
- 3) ED1-A204-6-1, 2, 6, 51, 67, 68, 3, 66.
- 4) ED1-A222-6-1, 2, 21, 22.
- 5) ED1-A227-10, 22, 11.
- 6) ED1-A206-3-1, 2.
- 7) ED1-A204-5-1, 2, 6, 51, 67, 68, 3, 66.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

8) ED1-A222-5-1, 2, 21, 22.

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, 1500.042.2372, who represents the Office of Structural Materials for your project.

Inspected By: Juvekar,Amit

Quality Assurance Inspector

Reviewed By: Miller,Mark

QA Reviewer
