

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-008614**Date Inspected:** 05-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wu Zhi Chen, Peng Guo**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:** Tower & OBG**Summary of Items Observed:**

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

BAY#10

This QA Inspector randomly observed the following work in progress

SMAW welding process of weld joint 18 located on PCMK SSD1-FASA3-1C/E. Welder is identified as 040581 ZPMC QC is identified as Deng Zhin Bing. The welding variables recorded by QC appeared to comply with the WPS-B-T-2314-TC-P4.

FCAW welding process of weld joint 83B located on PCMK SSSL3-1B/K. Welders are identified as 052075 ZPMC QC is identified as Deng Zhin Bing. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-C-U2-F.

FCAW welding process of weld joint 82B located on PCMK SSSL3-1B/K. Welders are identified as 053116 ZPMC QC is identified as Deng Zhin Bing. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-C-U2-F.

BAY#11

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FCAW welding process of weld joint 67 located on PCMK ESD1-FDSA4-2C/D. Welders are identified as 066882 ZPMC QC is identified as Peng Guo. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P5-F.

FCAW welding process of weld joint 55 located on PCMK ESD1-FDSA4- 2C/D. Welders are identified as 070212 ZPMC QC is identified as Peng Guo. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P5-F.

TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress.

OBG SEGMENT-1AAW-1AW

FCAW welding process of weld joint 50 located on PCMK SEG-003B. Welder is identified as 053609 ZPMC QC is identified as Chen Bo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U3-F.

FCAW welding process of weld joint 50 located on PCMK SEG-003C. Welder is identified as 220063 ZPMC QC is identified as Chen Bo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U3-F.

FCAW welding process of weld joint 003 located on PCMK OBW1A. Welders are identified as 053742, 200676 ZPMC QC is identified as Chen Bo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231T.

This QA Inspector observed ZPMC performing carbon air arc gouging on the weld joint between deck panel to 'I' rib stiffener in OBG segment 1AAW.

OBG SEGMENT-3AE-3BE

FCAW welding process of weld joint 004 located on PCMK SSD18A-PP022. Welder is identified as 058551 ZPMC QC is identified as Xu Tao. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-2G (2F) Repair.

BK-3

This QA Inspector observed ZPMC performing Build Up on the BK3 web plate BKX6A. This Buildup going on with FCAW welding process. Welder is identified as 220066 ZPMC QC is identified as Chen Bo. The welding variable recorded by QC appeared to comply with the WPS-345-FCAW-3G (3F) Repair. The weld repair report noted as B-WR6762.

OBG SEGMENT-1AE

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This QA Inspector observed ZPMC performing heat straitening on deck panel 'I' rib stiffener at PP8.5-PP09. The heat straitening record noted as HSR1 (B)-7310.

OBG SEGMENT-4BW

This QA Inspector observed ZPMC personnel performing snug bolt tightening on south side floor beam at PP28.

This QA Inspector observed ABF personnel performing Magnetic Particle Inspection on weld joint between longitudinal diaphragms to bottom panel in segment 4BW north side.

OBG SEGMENT-1AW

This Caltrans Quality Assurance (QA) Inspector observed:

1. ZPMC welding personnel performing SMAW welding on weld joints SSD37A-268 and SSD37A-270 at OBG Segment 1AW near PP10, "I-rib" stiffener to bottom panel while the base material was wet.
2. On August 6, 2009 between the hours of 00:10 and 01:15 during the welding of joints SSD37A-268 and SSD37A-270 at OBG Segment 1AW near PP10, no ZPMC Quality Control (QC) CWI Inspection personnel were present to monitor this welding.

Unless otherwise noted, all work observed on this dated 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 Serge Sinevod 13482570045, who represents the Office of Structural Materials for your project.

Inspected By:	Utekar,Shrikant	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
