

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-008705**Date Inspected:** 25-Aug-2009**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:	Zhan Hai Feng/ Guo Yuan Ting	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 #3

This QA inspector performed UT of 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 OBG Components. The weld designations reviewed are as follows:

- (FB205-042-005, 006, 009, 012, 013, 016, 019, 022)
- (FB204-042-005, 006, 009, 012, 015, 018, 021, 024, 025, 028, 031, 034, 037, 040, 043, 046)
- (FB204-043-005, 006, 009, 012, 015, 018, 021, 024, 028, 031, 034, 037, 040, 043)
- (FB205-044-005, 009, 012, 013, 016, 019, 022)
- (FB205-041-005, 009, 012, 016, 019, 022)
- (FB204-044-006, 009, 012, 015, 018, 021, 024, 025, 028, 031, 034, 037, 040, 043, 046)
- (FB204-041-006, 009, 012, 015, 018, 021, 024, 025, 028, 031, 034, 037, 040, 043, 046)

This QA inspector observed the following work in progress:

Bay#2

FCAW welding of weld joint FB3061-001-002, 003 located on FB3061-001. Welder is identified as 045209 (2F). ZPMC QC-CWI is identified as Zhan Hai Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint FB3059-001-002, 003 located on FB3059-001. Welder is identified as 045203 (2F).

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ZPMC QC-CWI is identified as Zhan Hai Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint FB3030-001-002, 003 located on FB3030-001. Welder is identified as 045240 (2F). ZPMC QC-CWI is identified as Zhan Hai Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Cross Beams Update:

CB007-Bay#1- Rectification work is in progress

CB015-Bay#1-

FCAW welding of weld joint FB204-046-015, 021 and FB204-047-025, 031 located on FB204-046 and FB204-047. Welder is identified as 054460 (2F). ZPMC QC-CWI is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint FB204-047-0005, 009 and FB204-046-037, 043 located on FB204-047 and FB204-046. Welder is identified as 054460 (2F). ZPMC QC-CWI is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint FB205-046-013, 019 and FB204-047-012, 006 located on FB205-046 and FB204-047. Welder is identified as 216575 (2F). ZPMC QC-CWI is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS.

CB014-Bay#3-

SAW welding of weld joint CB202E-014-001 located on CB-014. Welder is identified as 058100 (1G). ZPMC QC-CWI is identified as Chen Xi. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Caltrans Quality Assurance Inspector observed on cross beam-014 ZPMC QC change the joint designs of the weld numbers CB202E-014-002. According to approved WPS-B-T-2231-B-L2c-S-2, allowable root opening is 0 (+2, -0), where root opening measured is 16mm (sixteen). Because of an excessive root opening (more than 2mm) on these joints, they were changed to CJP (Complete Joint Penetration) welds, with steel backing bar. According to approved drawing these welds are CJP without steel backing bar. This joint design change was performed without prior engineer approval. This QA inspector generated TL 015 Incident report for this date.

CB008-Bay#6-

FCAW welding of weld joint CB202A-008-014 located on CB-008. Welder is identified as 058174 (3G) and 048625 (3G). ZPMC QC-CWI is identified as Liu Chun Gang. The welding variables recorded by QC appeared to comply with the Applicable WPS.

CB012-Bay#8-

FCAW welding of weld joint CB201A-012-014 located on CB-012. Welder is identified as 066687 and 069118

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(1G). ZPMC QC-CWI is identified as Zhang Jiang Xin. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint CB201G-034-139, 157 and CB201G-033-139, 157 located on CB-012. Welder is identified as 066687 (3F). ZPMC QC-CWI is identified as Zhang Jiang Xin. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint CB201G-036-139, 157 and CB201G-035-139, 157 located on CB-012. Welder is identified as 069118 (3F). ZPMC QC-CWI is identified as Zhang Jiang Xin. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Unless otherwise noted, all 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:	Patel,Hiranch	Quality Assurance Inspector
Reviewed By:	Prue,Erik	QA Reviewer
