

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-008715**Date Inspected:** 24-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:** Chen Xi**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 #2

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) in the 3F position of the OBG Floor beam to stiffener weld No. FB3030-002-053 and 54. The welder is identified as #045209. ZPMC QC is identified as Mr.Zhang Yaxu .The welding variables recorded by QC appear to comply with WPS- B – T-2133.

Flux Core Arc Welding (FCAW) in the 2F position of the OBG Floor beam to stiffener weld No. FB3030-002-091 and 92. The welder is identified as #207464. ZPMC QC is identified as Mr.Zhang Yaxu .The welding variables recorded by QC appear to comply with WPS- B – T-2132-3.

Flux Core Arc Welding (FCAW) in the 2F position of the OBG Floor beam to stiffener weld No. FB3066-001-016. The welder is identified as #068764. ZPMC QC is identified as Mr.Zhang Yaxu .The welding variables recorded by QC appear to comply with WPS- B – T-2132-3.

WELDING INSPECTION REPORT

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BAY #1

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) in the 2F position of the OBG Floor beam Corner Assembly weld No. FB205-045-007 and 008. The welder is identified as #054460. ZPMC QC is identified as Mr. Tian Lei. The welding variables recorded by QC appear to comply with WPS- B – T-2132-3.

Flux Core Arc Welding (FCAW) in the 2F position of the OBG Floor beam Corner Assembly weld No. FB205-047-001 and 002. The welder is identified as #219189. ZPMC QC is identified as Mr. Tian Lei. The welding variables recorded by QC appear to comply with WPS- B – T-2132-3.

Ultrasonic Testing(Phased Array)

The QA Inspector performed Phased Array Ultrasonic Testing (PAUT) on Orthotropic Box Girder deck plates to closed rib welds at the tack weld locations (marked for crack confirmation) which were previously tested by Caltrans QA personnel. The QA Inspector generated a field inspection UT report on this date designating areas of rejectable indications.

Panel identification numbers are

DP-482-001(11BE)
DP-159-001(11CW)

Ultrasonic Testing (UT)

This QA Inspector performed Ultrasonic testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as OBG Splice Plate of U-Rib weld.

The Weld Designations are as follows

DP3041-001-019 and 020
DP3009-001-031 and 032

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.

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Inspected By:	Bera,Subhasis	Quality Assurance Inspector
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Reviewed By:	Prue,Erik	QA Reviewer
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