

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-009512**Date Inspected:** 06-Oct-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:** Li zhi jiang**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**Summary of Items Observed:**

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

This QA Inspector randomly observed the following work in progress:

OBG # BAY 05 Cross Beam 16

Submerged Arc Welding Process:

Welding of weld joint -004 located on PCMK CB202C-016. Welder is identified as 215248. ZPMC QC is identified as Zhang zhi wei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-B-L2C-S-2.

OBG # BAY 02

Submerged Arc Welding Process:

Welding of weld joint -043 located on PCMK FB3055-001. Welder is identified as 045276. ZPMC QC is identified as Yang Qing fang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-B-L2C-S-2.

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Flux Cored Arc Welding Process:

Welding of weld joint –036,039 located on PCMK FB6501-001. Welder is identified as 045203. ZPMC QC is identified as Yang Qing fang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-TC-U4b-F.

Welding of weld joint –043 located on PCMK FB3052-001. Welder is identified as 045276. ZPMC QC is identified as Yang Qing fang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-TC-U4b-F.

Welding of weld joint –014,015 located on PCMK FB3027-001. Welder is identified as 062438. ZPMC QC is identified as Yang Qing fang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

Welding of weld joint –064 located on PCMK FB3098-001. Welder is identified as 045209. ZPMC QC is identified as Zhan hai feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-TC-U4b-F.

Welding of weld joint –041,003 located on PCMK FB3083-003. Welder is identified as 045209. ZPMC QC is identified as Zhan hai feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-TC-U4b-F.

OBG # Cross Beam 07 (OPEN YARD)

During in-process visual inspection of the OBG Cross Beam 07 components in Open yard, This QA inspector witnessed that ZPMC UT Technician Mr. Han feng discovered a total of three CJP joints (3) Repair two (R2) non-conforming indications found with ultrasonic testing (UT) for the following Cross beam components.

(CB201G-016-097)

(CB201G-016-101)

(CB201G-015-063)

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

Summary of Conversations:

As mention above

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 150-00422372, who represents the Office of Structural Materials for your project.

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Inspected By: Sukanthan,Dhanasingh

Quality Assurance Inspector

Reviewed By: Hall,Steven

QA Reviewer