

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-011189**Date Inspected:** 26-Dec-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:** Liu Fawen**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) Components**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

BAY 2**Green Tags**

The following green tags issued for OBG components after completing the NDT requirements are:

1. FB3043 – 001 – Green Tag # 11314
2. FB3069 – 004 – Green Tag # 11280
3. FB3007 – 001 – Green Tag # 11268
4. FB3017 – 001 – Green Tag # 11272
5. FB3077 – 001 – Green Tag # 11270

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW):

Weld joint # 058 located on Longitudinal Diaphragm LD3020 – 001. Welder is identified as 045209. ZPMC Quality Control (QC) Inspector is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

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Weld joint # 069 located on Longitudinal Diaphragm LD3020 – 001. Welder is identified as 045209. ZPMC Quality Control (QC) Inspector is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U5 – F.

BAY 3

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW):

Weld joint # 067 located on Corner Assembly CA6501C. Welder is identified as 208035. ZPMC Quality Control (QC) Inspector is identified as Yin Dong Hai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U4b – F.

Weld joint # 033 located on Corner Assembly CA3001F. Welder is identified as 208035. ZPMC Quality Control (QC) Inspector is identified as Yin Dong Hai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

Weld joint # 160 located on Cross Beam CB202G – 041. Welder is identified as 204338. ZPMC Quality Control (QC) Inspector is identified as Guo Yuan Ting. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

Weld joint # 014 located on Cross Beam CB202A – 014. Welder is identified as 206623. ZPMC Quality Control (QC) Inspector is identified as Yin Dong Hai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U4b – F.

BAY 5

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 004930

Ultrasonic Testing (UT)

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 members are identified as OBG Components. The weld designations reviewed are as follows:

1. BK001 – 048 – 067~070
2. BK001 – 050 – 067~070

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW):

Weld joint # 003 located on Bike Path BK001 – 046. Welder is identified as 066734. ZPMC Quality Control (QC) Inspector is identified as Wang Liyang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – Tc – U4c – F.

Weld joint # 001 located on Bike Path BK001 – 043. Welder is identified as 067275. ZPMC Quality Control

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(QC) Inspector is identified as Wang Liyang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – Tc – U4c – F.

Weld joint # 003 located on Bike Path BK001 – 044. Welder is identified as 204342. ZPMC Quality Control (QC) Inspector is identified as Wang Liyang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – Tc – U4c – F.

Weld joint # 001 located on Bike Path BK001 – 047. Welder is identified as 217185. ZPMC Quality Control (QC) Inspector is identified as Wang Liyang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – Tc – U4c – F.

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 004933

Ultrasonic Testing (UT)

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 Component. The weld designations reviewed are as follows:

1. BK001 – 049 – 067~070

BAY 7

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW):

Weld joint # 003 located on Traveler Rail 22TR4 – 002. Welder is identified as 067877. ZPMC Quality Control (QC) Inspector is identified as Zhou Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U5 – F.

Weld joint # 007 located on Traveler Rail 22TR2 – 001. Welder is identified as 053609. ZPMC Quality Control (QC) Inspector is identified as Zhou Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U5 – F.

BAY 8

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW):

Weld joint # 006 located on Floor Beam FB3057 – 054. Welder is identified as 054459. ZPMC Quality Control (QC) Inspector is identified as Zhang Qiao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U4b – F.

Weld joint # 012 located on Floor Beam FB3057 – 053. Welder is identified as 215082. ZPMC Quality Control (QC) Inspector is identified as Zhang Qiao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U4b – F.

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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 - 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Sandeep	Quality Assurance Inspector
Reviewed By:	Hall,Steven	QA Reviewer
