

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-014326**Date Inspected:** 13-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**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:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this date Caltrans Office of Structural Material (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 1

This QA observed ZPMC qualified welding personnel identified as 219188 perform Flux Cored Arc Weld (FCAW) Process on weld joint 20TR1-041-003. ZPMC Quality Control Personnel (QC) identified as Mr. Xiang Feng Feng was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-TC-U5-F.

This QA observed ZPMC qualified welding personnel identified as 216575 perform Flux Cored Arc Weld (FCAW) Process on weld joint 20TR2-032-013. ZPMC Quality Control Personnel (QC) identified as Mr. Xiang Feng Feng was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-TC-U5-F.

OBG # BAY 2

This QA observed ZPMC qualified welding personnel identified as 062438 perform Flux Cored Arc Weld (FCAW) Process on weld joint FB3177-001-108,109. ZPMC Quality Control Personnel (QC) identified as Mr.

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Zhu Lin was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132-3.

This QA observed ZPMC qualified welding personnel identified as 045209 perform Flux Cored Arc Weld (FCAW) Process on weld joint FB3176-001-088,089. ZPMC Quality Control Personnel (QC) identified as Mr. Zhu Lin was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132-3.

This QA observed ZPMC qualified welding personnel identified as 045203 perform Flux Cored Arc Weld (FCAW) Process on weld joint FB3212-001-018,019. ZPMC Quality Control Personnel (QC) identified as Mr. Zhu Lin was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132-3.

During random in process inspection of the joint fit up this QA observed that ABF personnel performing MT on tack weld at Floor beam identified as FB3177-001. ABF MT technician found ten (10) crack tack welds in Two (2) fillets Welds joints identified as FB3177-001-068 & 069 that did not appear to comply with the contract documents. The ABF QC inspectors identified as Mr. Wang Wen Bin instructed the workers in the area to grind the tack and re-tack the joint prior to welding. This tack weld had not yet been repaired prior to QA departing the area. The attached photo of this tack weld is intended to capture the in-process workmanship being performed on this component.

OBG # BAY 3

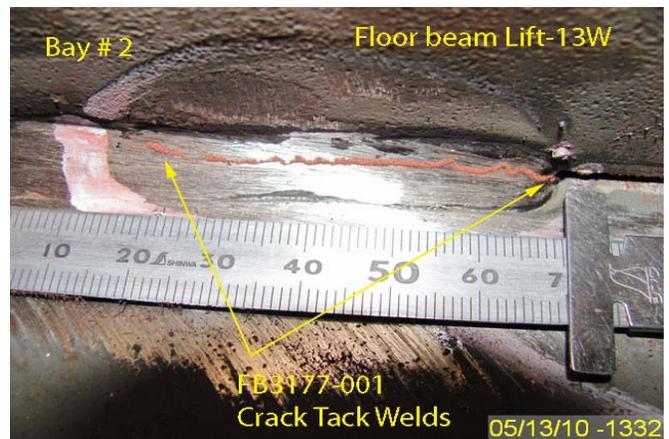
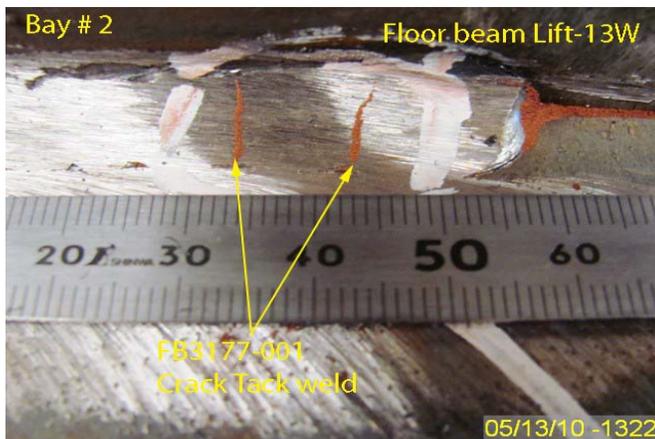
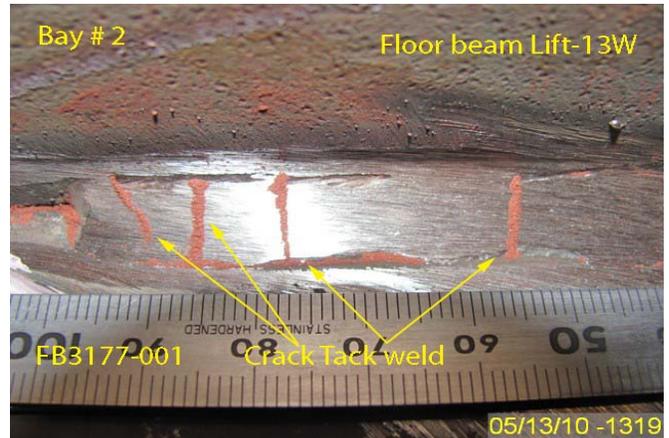
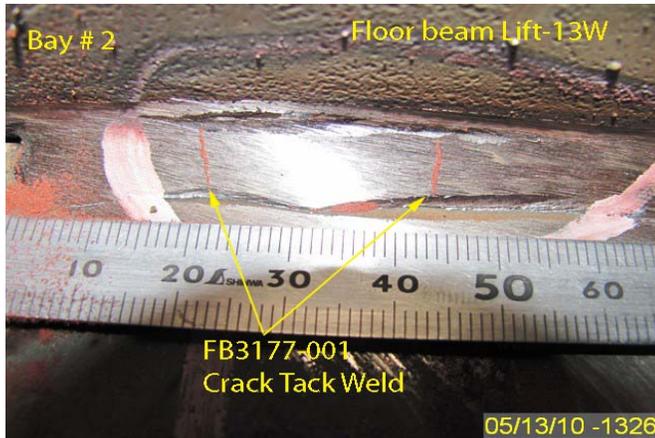
This QA observed ZPMC qualified welding personnel identified as 050502 perform Submerged Arc Weld (SAW) Process on weld joint FB3111-001-003. ZPMC Quality Control Personnel (QC) identified as Mr. Zhang yaxu was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-U3C-S-2.

This QA observed ZPMC qualified welding personnel identified as 062406 perform Submerged Arc Weld (SAW) Process on weld joint FB3110-001-002. ZPMC Quality Control Personnel (QC) identified as Mr. Zhang yaxu was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-L2C-S-2.

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

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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.

Inspected By: Sukanthan,Dhanasingh

Quality Assurance Inspector

Reviewed By: Hall,Steven

QA Reviewer