

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-014553**Date Inspected:** 07-Jun-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:** Guo Yanfei**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:** Bay 9**Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Christopher D'souza was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China. QA Inspector observed and/or found the following:

Bay 9, Gantry 2

DP 3150 – 001 (PL 3346A, PL 3346B, PL 3346C)

This inspector performed In- Process inspections of production welding of deck panels in Bay 9. Welding was being performed on panel DP 3150 – 001 (PL 3346A, PL 3346B, PL 3346C). The weld procedure was found to be WPS-B-T-2342-U1-(U-rib)-5. The welding operators were identified as follows:

Weld 1, Weld 138, Weld 176 – 201788

Weld 2, Weld 139, Weld 177 – 059416

Weld 3, Weld 173, Weld 178 – 201788

Weld 4, Weld 174, Weld 179 – 059416

Weld 5, Weld 141, Weld 180 – 059421

Weld 6, Weld 140, Weld 181 – 059418

ZPMC and ABF QC were present during the welding process and identified as Guo Yanfei and Huang Wen

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Guang respectively. The ZPMC CWI was present during the welding process and identified as Guo Yanfei.

During FCAW root welding process, the welding parameters were verified by this inspector and were as follows:

Head 3, Weld 1, 138, 176 - 369 Amps, 30.5 Volts
Head 4, Weld 2, 139, 177 - 373 Amps, 30.5 Volts
Head 3, Weld 3, 173, 178 - 372 Amps, 30.8 Volts
Head 4, Weld 4, 174, 179 - 369 Amps, 30.3 Volts
Head 5, Weld 5, 141, 180 - 368 Amps, 30.0 Volts
Head 6, Weld 6, 140, 180 - 371 Amps, 30.0 Volts

DP 3131 – 001 (PL 3327A, PL 3327B)

This inspector performed In- Process inspections of production welding of deck panels in Bay 9. Welding was being performed on panel DP 3131 – 001 (PL 3327A, PL 3327B).

The weld procedure was found to be WPS-B-T-2342-U1-(U-rib)-5. The welding operators were identified as follows:

Weld 1, Weld 145 – 059418
Weld 2, Weld 146 – 059421
Weld 3, Weld 147 – 059416
Weld 4, Weld 148 – 201788
Weld 5, Weld 149 – 059416
Weld 6, Weld 150 – 201788
Weld 7, Weld 151 – 203805
Weld 8, Weld 152 – 059375

ZPMC and ABF QC were present during the welding process and identified as Guo Yanfei and Huang Wen Guang respectively. The ZPMC CWI was present during the welding process and identified as Guo Yanfei.

During FCAW root welding process, the welding parameters were verified by this inspector and were as follows:

Head 1, Weld 1, 145 - 372 Amps, 31.0 Volts
Head 2, Weld 2, 146 - 373 Amps, 31.0 Volts
Head 3, Weld 3, 147 - 372 Amps, 31.1 Volts
Head 4, Weld 4, 148 - 369 Amps, 30.7 Volts
Head 3, Weld 5, 149 - 372 Amps, 31.3 Volts
Head 4, Weld 6, 150 - 369 Amps, 31.4 Volts
Head 5, Weld 7, 151 - 368 Amps, 31.5 Volts
Head 6, Weld 8, 152 - 371 Amps, 31.3 Volts

Travel speed for weld pass 1 was 528mm/min

Travel speed for weld pass 2 was 525mm/min

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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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:	Dsouza,Christopher	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
