

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-014921**Date Inspected:** 14-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:** Chen Shi Gang**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 3143 – 001 (PL 3339A, PL 3339B, PL 3339C)

This Inspector performed In- Process inspections of production welding of deck panels in Bay 9. Welding was being performed on panel DP 3143 – 001 (PL 3339A, PL 3339B, PL 3339C). 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 140, Weld 180 – 059421

Weld 6, Weld 141, Weld 181 – 059418

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

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Pass 1

Current 350 ~ 366 Amps
Voltage 30.5 ~ 30.8 Volts
Travel Speed 526 mm/min

Pass 2

Current 360 ~ 385 Amps
Voltage 30.4 ~ 31.0 Volts
Travel Speed 528 mm/min

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

Pass 1

Current 680 ~ 698 Amps
Voltage 24.7 ~ 25.1 Volts
Travel Speed 510 mm/min

Pass 2

Current 675 ~ 691 Amps
Voltage 24.7 ~ 25.1 Volts
Travel Speed 512 mm/min

ZPMC and ABF QC were present during the welding process and identified as Zhu Zhong Jie and Cao Hai Zhou respectively. The ZPMC CWI was present during the welding process and identified as Chen Shi Gang.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the 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:	Dsouza,Christopher	Quality Assurance Inspector
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Reviewed By:	Carreon,Albert	QA Reviewer
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