

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-015109**Date Inspected:** 02-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**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:** Tower and OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA Inspector) George Goulet was present during the times noted above for observations relative to the work being performed.

Bay 11

This QA Inspector randomly observed the following work in progress in Bay 11:

FCAW visual testing repair welding of weld joint WD1-A25B/E-17 located on PCMK west tower, base shear plate assembly. Welder was identified as 205649. QC was identified as ZPMC CWI An Qing Xiang (QC1). Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Liu Dao Feng, who was a CAWI. The welding variables recorded by QC1's assistant appeared to comply with WPS-345-SMAW-3G(3F)-repair. Also present at this location and appearing to be monitoring the welding operations was ABF Representative Zhao Ying Sheng.

Bay 10

This QA Inspector randomly observed the following work in progress in Bay 10:

SMAW welding of temporary brace for staging platform located on north tower, lift 3, skin A. Welder was identified as 056364. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Yuan Hui Gang, who was not a CWI. The welding variables recorded by QC1's assistant appeared to comply with WPS-B-P-2114. Also present at this location and appearing to be monitoring the welding operations was ABF Representative Li Nan.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Heavy Dock

This QA Inspector randomly observed the following on the Heavy Dock:

South tower, lift 3 had been lifted above south tower, lift 2 and appeared to still be connected to the floating crane moored to the foot of the Heavy Dock. North tower, lift 1 and east tower, lift 3 were laying horizontally at the foot of the Heavy Dock.

Bay 9 – PMT

This QA Inspector monitored OBG Production Monitoring Test (PMT) #3133 for deck panels DP3133(PL3329A/B)-001 and DP3132(PL3328A/B)-001 at Gantry #2. Prior to the start of the PMT, this QA Inspector observed the root openings to be within the 0.0 to 0.5mm tolerance. The magnetic particle test (MT) of the tack welds was noted on the test panel as having been performed by ZPMC MT Inspector Wang Wei on 6/2/10.

The visual inspection of tack welds and root gaps was performed by ABF Representative Wang Wan Cheng (PABF), ZPMC CWI Chen Shigang (PQC), and this QA Inspector. The tack welds and root gaps appeared to be within prescribed tolerances. This QA Inspector observed that the deck plate of the test panel was 20mm thick and the deck plate of the production panels were 20mm thick. This QA Inspector observed that the test panel was generally representative of the production panels. The ambient temperature was above 19°C. ZPMC personnel used an oxy-fuel torch to preheat the specimens to above 60°C and the interpass temperature was still above 60°C without additional heating in conformance with WPS-B-T-2342-U1-(U-rib)-5. The start time for welding of the 3–12mm x 20mm specimens was approximately 0131 hours on 6/3/10 and the finish time was approximately 0204 hours. This QA Inspector randomly verified and documented the welding amperage, voltage, and travel speed during the gas metal arc welding (GMAW) and submerged arc welding (SAW) processes, welds 1 thru 6 at the completion of both the GMAW root pass and SAW cover pass. The welding variables recorded by PQC appeared to comply with WPS-B-T-2342-U1-(U-rib)-5. The welds were visually inspected by PABF, PQC and this QA Inspector. PQC and PABF informed this QA Inspector that all six welds were acceptable and after random inspection this QA Inspector concurred. This QA inspector randomly witnessed ZPMC ultrasonic testing (UT) inspector, identified as Tang Xingshan, perform UT on each of the 500 mm test welds for depth of penetration and conformance. This QA Inspector selected fifteen designated locations for macroetch sampling per contract requirements. Each macroetch sample location was stamped by ZPMC personnel with the number 3133, a letter M laid sideways, chosen randomly by this QA Inspector as a verification mark, and an individual progressive macroetch identifying number for each macroetch. After removal from each of the weld test specimens, polishing, and acid etching of the selected end, the macroetches were evaluated with a 7X optical magnifier and accepted by PQC, PABF, and this QA Inspector.

All fifteen sample macros appeared to meet requirements and were noted to appear acceptable. See Caltrans U-ribs PMT Inspection Sheet, ZPMC production monitoring test plate inspection report, and Caltrans Macro Etch Log - all dated 6/3/2010 for additional information.

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

Summary of Conversations:

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

As noted 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, 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet,George	Quality Assurance Inspector
Reviewed By:	Dawson,Paul	QA Reviewer
