

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-015256**Date Inspected:** 25-Jul-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 10

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

ZPMC worker backgouging weld joint SSD1-SPSA5-13-4B located on PCMK south tower, lift 5, internal splice plate assembly, which was mounted on an A-frame support with the weld joint in the flat position.

Bay 11

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

ZPMC worker backgouging weld joint SSD1-SPSA5-12-2A located on PCMK south tower, lift 5, internal splice plate assembly, which was mounted on an A-frame support with the weld joint in the flat position.

SMAW layered repair welding on the plate edge of PCMK LD5-4, thickness = 70mm. ZPMC CWI Gao Zhi Chun (QC1) presented this QA Inspector with ZPMC Critical Weld Repair Report CWR649 displaying the item name as East west tower 5 lifting transverse diaphragm and the drawing number as LD5-4. Welders were identified as follows: 251194 on the west diaphragm and 041271, 040667 on the east diaphragm. QC was identified as 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. Welding variables recorded by QC1's assistant appeared to comply with

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WPS-485-SMAW-2G-(2F)-repair as listed on ZPMC Critical Weld Repair Report CWR649.

OBG Trial Assembly Area

This QA Inspector randomly observed the following work in progress in the OBG Trial Assembly Area:

SMAW welding of temporary alignment plates located outside the OBG at PCMK 9BE/9CE transverse joint, and at the bottom plate to side plate longitudinal joint which had been separated by cutting or gouging and was open. Some of the alignment plates were being used with jacking equipment to achieve proper alignment of bottom plate to side plate. Welder was identified as 062092. QC was identified as ZPMC CWI Liu Hua Jie (QC2). Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Wang Li Yang, who was not a CWI. Welding variables recorded by QC2's assistant appeared to comply with WPS-B-P-2114-FCM-1. Also present at this location and appearing to be monitoring the welding operation was ABF Representative Zhang Xiao Ming.

Heavy Dock

This QA Inspector observed no welding related work was being performed on the heavy dock. All 4 tower lifts 2 were erect with north, south and east lifts 3 attached above, respectively. West tower, lift 3 appeared to be in position atop west tower, lift 2 and still connected to the rigging hanging from the ZPMC floating crane. The worker access tower elevator was dark. ABF Representative Kang Yi acknowledged that no work was being performed on the Heavy Dock.

Bay 9 – PMT

This QA Inspector monitored OBG Production Monitoring Test (PMT) #3086 for deck panels DP3086(PL3182A/B)-001 and DP3089(PL3185A/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 Cai Xin Xin on 6/23/10. The visual inspection of tack welds and root gaps was performed by ABF Representative Huang Wen Guang (PABF), ZPMC CWI Yang Baiqiang (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 23°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 2–12mm x 20mm specimens was approximately 0011 hours on 6/26/10 and the finish time was approximately 0039 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 4 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 four welds were acceptable and after random inspection this QA Inspector concurred. This QA inspector randomly witnessed ZPMC ultrasonic testing (UT) inspector, identified as Xue Hai Rong, perform UT on each of the 500 mm test welds for depth of penetration and conformance. This QA Inspector selected ten designated locations for macroetch sampling per contract requirements. Each macroetch sample location was stamped by ZPMC personnel with the number 3086, a number 2, chosen randomly by this QA Inspector as a verification mark, and an individual progressive macroetch

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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 ten 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 6/26/2010 for additional information.

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

Summary of Conversations:

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
