

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-005167**Date Inspected:** 12-Jan-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Jia**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:** OBG Component**Summary of Items Observed:**

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

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This QA inspector randomly observed the following work in progress:

FCAW CJP welding of I rib weld DP565-001-067B by welder identified as 067876. ZPMC QC was identified as ZPMC CWI Li Jia (QC). The welding variables recorded by QC appeared to comply with the WPS:

B-T-2232-TC-U5-F. Also present at the above location and appearing to observe the welding operation and record data was ABF Representative Chang Bao Qing (ABF).

This QA inspector monitored OBG Production Monitoring Test (PMT) #1 for deck panels DP555-001 and DP127-001 at Gantry #1. Prior to PMT #1, the magnetic particle test (MT) of the tack welds was noted on the test panel as having been performed by ZPMC MT Inspector Bo Tin Rui. The visual inspection of tack welds and root gap was performed by ABF, QC, and this QA inspector. The start time for welding of PMT #1 was approximately 0108 hours on Tuesday, 1/13/09 and the finish time was approximately 0159 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 welds were visually inspected by ABF, QC and this QA inspector. QC and ABF informed QA Inspector all six welds were acceptable and QA inspector concurred. This QA inspector witnessed ZPMC Ultrasonic Testing (UT) inspector, identified as Xue Hai Wong, perform UT on each of the welds for depth of penetration and conformance. This QA inspector selected designated locations for macroetch sampling per contract requirements. The macroetch specimens were evaluated with a 7X optical comparator and a 10X optical

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comparator and accepted by QC, ABF, 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 1/13/2008 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, and QA inspector asked QC if all the welding variables observed by him appeared to comply with the appropriate WPS, including the preheat requirements according to thickness of the thickest member being welded. QC showed this QA Inspector that he was carrying the proper temperature sticks to monitor the minimum and maximum preheat and interpass temperatures and replied that all he observed did appear to comply.

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, 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet,George	Quality Assurance Inspector
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Reviewed By:	Lindenmuth,Mahlon	QA Reviewer
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