

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-005579**Date Inspected:** 13-Feb-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Shen Fu You**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**Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Erik Prue was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA Inspector observed and/or found the following:

OBG Bay 14 & outside paint shop: QA Inspector performed ultrasonic verification testing of OBG Floor Beams FB004-002-042 flange splice and FB004-002 SSD13 PP24 butt splice Complete Joint Penetration (CJP) butt joints.

The Ultrasonic Testing (UT) was performed to verify that 10% of the weld meets the requirements of the contract documents and AWS D1.5-2002 after ZPMC QC UT acceptable inspection. The welds and base metal were scanned utilizing a Krautkramer Branson USN 58L #01WK8K. QA Inspector performed a base metal lamination check using a 25mm diameter 2.25 MHz transducer and a shear wave scan using a 20mm x 15mm 2.25 MHz transducer on a 70 degree angle wedge from face A. For details please see the ultrasonic testing report TL-6027 dated 13 February, 2009. QA Inspector found the welds inspected to be in compliance with AWS D1.5- 2002 Table 6.3 and the contract documents.

Bay 14: QA Inspector randomly observed ZPMC qualified welder ID#045265 welding bottom plate BP92A to side plate SP154A segment 39A. Welder was observed welding in the 1G (flat) position utilizing Submerged Arc Welding (SAW) process. QA Inspector observed the ZPMC QC Inspector Wu Bin verifying welding parameters and pre-heat were in accordance with the Welding Procedure Specification (WPS). QA Inspector with QC Inspector observed parameters as follows: preheat temperature to be at 115°C and measured the welding parameters to be 596 amps, 33.2 volts, a travel speed of 506 mm/min. Welding parameters verified by QA Inspector appear to be in general compliance with the approved WPS-B-T-2221-B-12C-S-2.

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

Summary of Conversations:

No significant conversations this day.



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:	Prue,Erik	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
