

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-007262**Date Inspected:** 14-Jun-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:** Huang Wen pang**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 Components**Summary of Items Observed:**

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

BAY 2

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #132 located on SSD13A – PP091. Welder is identified as 048433. ZPMC QC is identified as Zhang Hai Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2233 – Tc – u4b – F.

FCAW process welding of weld joint #137 located on SSD13 – PP091. Welder is identified as 203871. ZPMC QC is identified as Zhang Hai Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2233 – Tc – u4b – F.

BAY 3**Ultrasonic Testing**

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows:

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1. FB009 – 040 – 045
2. FB016 – 045 – 045
3. FB009 – 035 – 045

This QA Inspector observed the following work in progress:

SAW process welding of weld joint #003 located on Cross Beam CB202E - 010. Welder is identified as 044780. ZPMC QC is identified as Yin Dong Hai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2221 – B – L2C – S – 2.

BAY 5

This QA Inspector observed the following work in progress:

FCAW process welding of a weld joint #006 located on TR5L – PP019. Welder is identified as 217291. ZPMC QC is identified as Xu Hong Min. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – Tc – U4c – F – 1.

BAY 7

This QA Inspector observed the following work in progress:

SMAW process Tack welding of weld joint #053 located on SP3048 – 001. Welder is identified as 215259. ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2112 (FCM).

SMAW process Tack welding of weld joint #053 located on SP3046 – 001. Welder is identified as 250833. ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2112 (FCM).

BAY 8

This QA Inspector observed the following work in progress:

SAW process welding of weld joint #003 located on Cross Beam CB201E - 012. Welder is identified as 207463. ZPMC QC is identified as Zhong Jing Xin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2221 – B – L2C – S – 2.

This QA Inspector observed the following work not in compliance:

During random in-process visual inspection at Bay # 08 on cross beam CB201B – 012 - 004, observed welder # 219414 FCAW tack welding being performed, without the qualification of FCAW process for the project (SFOBB), where as the WPS used is WPS – B – T – 22331 – B – u2 – F.

For further details, please see the Incident report (040120F4_TL015_B227_06-14-09_Welder Qualification).

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

Summary of Conversations:

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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:	Kumar,Sandeep	Quality Assurance Inspector
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Reviewed By:	Prue,Erik	QA Reviewer
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