

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-007332**Date Inspected:** 07-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Le Feng, Liu Yang**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**Summary of Items Observed:**

The Caltrans (CT) Quality Assurance (QA) Inspector Charlie Franco was present at the time requested to randomly observe welding and associated operations being performed for the Tower and Orthotropic Box Girders (OBG).

Outside Yard at Vertical Mill:

The QA Inspector randomly observed that ZPMC milling was idle and no milling work was being performed on Lift 1 or Lift 2 East.

The QA Inspector randomly observed that no contract work was being performed on the exteriors or interiors of Lift 2 East or Lift 2 South.

The QA Inspector randomly observed coating touch up being performed on the interior of Lift 1 East.

Heavy Equipment Shop Bay 10:

The QA Inspector randomly observed ZPMC welder Xia Yong ID 040625, utilizing the Submerged Arc Welding (SAW) Process in the 1G (Flat Groove) Position with ZPMC Weld Procedure Specification (WPS) WPS-B-T-2221-B-U3c-S-2 to weld the butt seam at Weld Joint (WJ) SSD1-A111B/H-1B. The QA Inspector randomly observed ZPMC QC monitoring weld parameters. The QA Inspector also randomly monitored weld parameters and recorded them as follows: 658 amps, 31.7 volts with a travel speed of 600 millimeters (mm) per

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minute. Weld parameters appeared to comply with contract requirements. The attached photograph provides additional detail.

Heavy Equipment Shop Bay 11:

The QA Inspector randomly observed ZPMC welder Cao Xiao Hua ID 056975 utilizing the SAW Process in the 1G (Flat Groove) Position with ZPMC WPS WPS-B-T-2221-C-U2b-S-2 to weld the long seam at WJ WSD1-TL6B/L-1A between Skin Plate A and Skin Plate E on Lift 2 West. The QA Inspector randomly observed ZPMC QC monitoring weld parameters. Weld parameters appeared to comply with contract requirements.

The QA Inspector randomly observed 3 ZPMC helpers utilizing angle grinders to blend the cover pass in the long seam at WJ WSD1-TL6B/L-1A between Skin Plate A and Skin Plate E on Lift 2 West.

The QA Inspector randomly observed ZPMC welder Li Xiao Qing ID 044560, utilizing the SAW Process in the 1G (Flat Groove) Position with ZPMC WPS WPS-B-T-2221-B-U3c-S-2 to weld the butt seam at WJ WSD1-FBSA4-2A/C-38A between piece marks FB4-33 and FB4-3 of Skin Plate B of Lift 4 West. The QA Inspector randomly observed ZPMC QC monitoring weld parameters. Weld parameters appeared to comply with contract requirements.

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



Summary of Conversations:

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 Serge Sinevod 13482570045, who represents the Office of Structural Materials for your project.

Inspected By: Franco,Charlie

Quality Assurance Inspector

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Reviewed By: Clifford, William

QA Reviewer