

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-007659**Date Inspected:** 27-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:** Liu wei wei**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 Cross Beam**Summary of Items Observed:**

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

This QA Inspector randomly observed the following work in progress:

OBG # Cross Beam 12 – Bay 08

Flux Cored Arc Welding Process:

Welding of weld joint –046,040 located on PCMK FB204-034. Welder is identified as 066687. ZPMC QC is identified as Sunwei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-TC-U4b-F.

Welding of weld joint –037 located on PCMK FB204-033. Welder is identified as 066687. ZPMC QC is identified as Sunwei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-TC-U4b-F.

OBG # Bay 01

Flux Cored Arc Welding Process:

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Welding of weld joint –002,003 located on PCMK CW001B-PP72. Welder is identified as 054460. ZPMC QC is identified as Zhang yaxu. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-TC-U4b-F.

Welding of weld joint –002,003 located on PCMK CW001B-PP80. Welder is identified as 251246. ZPMC QC is identified as Zhang yaxu. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-TC-U4b-F.

Welding of weld joint –023 located on PCMK CW001B-PP54. Welder is identified as 054460. ZPMC QC is identified as Zhang yaxu. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

OBG # Cross Beam 05 – Open Yard

This QA inspector observed that ZPMC has deviated from the weld joint design on welds by changing the fillet weld detail to a complete joint penetration (CJP) without the approval of the Engineer. The weld designations reviewed are as follows:

CB202G-005-043, 044, 051, 052, 053, 054, 055, 056, 057, 058, 059, 060, 061, 062.

CB202G-006-043, 044, 045, 046, 047, 048, 049, 050, 051, 052, 055, 056, 057, 058, 059, 060, 061, 062.

CB 202G-007-043, 044, 051, 052, 055, 056, 057, 058, 059, 060, 061, 062.

CB 202G-008-043, 044, 051, 052, 053, 054, 055, 056, 057, 058, 059, 060, 061, 062.

OBG # Cross Beam 07 – Bay 01

This QA inspector observed Deck plate Stiffener / Side plate Stiffener penetrating to Floor beam weld fit up that Fillet weld Root Gap observed more than 5mm. The weld designations reviewed are as follows:

CB201G-014-067.

CB201G-015-065, 067.

CB201G-016-067, 069.

CB201G-014-168, 120.

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

Summary of Conversations:

The QA Inspector informed ZPMC QC Mr. Liu wei wei (Cross Beam 05) that the weld joint design on welds by changing the fillet weld detail to a complete joint penetration (CJP) without the approval of the Engineer. The QA Inspector informed that the QA Inspector will be issuing incident report.

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 150-00422372, who represents the Office of Structural Materials for your project.

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Inspected By:	Sukanthan,Dhanasingh	Quality Assurance Inspector
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Reviewed By:	Prue,Erik	QA Reviewer
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