

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-007971**Date Inspected:** 23-Jul-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:** XU XIAN PING**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 and Tower COMPONENT**Summary of Items Observed:**

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

In process Inspection

BAY #3

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 3F position of the OBG Cross Beam assembly weld No. CB-202G-025-161&143 . Welders are identified as #051359 & #058102. The welding variables recorded by QC appear to comply with WPS- B – T-2113.

Flux Cord Arc Welding (FCAW) in the 1G position of the OBG longitudinal Diaphragm assembly weld No. LD-001-039-011&012. The welder is identified as #044790. The welding variables recorded by QC appear to comply with WPS- B – T-2233-Tc-U4-F.

Flux Cord Arc Welding (FCAW) in the 2F position of the OBG longitudinal Diaphragm assembly weld No. LD-003-053-001~006. The welder is identified as #208035. The welding variables recorded by QC appear to comply with WPS- B – T-2132-3.

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Shielded Metal Arc Welding (SMAW) in the 3F position of the OBG Cross Beam assembly weld No. CB-202G-025-139&157 . Welders are identified as #051359 & #058102. The welding variables recorded by QC appear to comply with WPS- B – T-2113.

Out side Trial Assembly

This QA Inspector performed Ultrasonic testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as the FL3 horizontal stiffener attachment weld to the edge plate.

The Weld Designations are as follows

SEG013D-074,128,137,164,173

SEG013E-031,049

SSD012A-PP22-183

SSD010A-PP20-180,170

SSD011A-PP21-178,168

FB017-001-128

FB021-001-128

FB025-001-128

Bay #2

This QA Inspector performed Ultrasonic testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as Floor Beam component welds.

The Weld Designations are as follows

FB010-030-043

FB015-037-043

FB015-038-045

Bay #3

This QA Inspector performed Ultrasonic testing (UT) of approximately 10% of the area previously tested and

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accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as Floor Beam component welds.

The Weld Designations are as follows

FB020-009-146

FB003-193-034,046

FB003-196-010,022

SSD19-PP096-137

SSD19A-PP096-132

SSD11-PP099-132

SSD11A-PP099-006

This Quality Assurance Inspector (QA) performed 10% verification Ultrasonic Testing (UT) on weld joints were identified as SEG013D-083 & SSD012A-PP22-169 for OBG Segment 3AW near the Cross Beam at outside Trail assembly Yard area. This QA Inspector discovered two class "A" rejectable indication measuring approximately 35 mm and 30 mm in length respectively. See incident report on this date.

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 Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Bera,Subhasis	Quality Assurance Inspector
Reviewed By:	Prue,Erik	QA Reviewer
