

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-008020**Date Inspected:** 28-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:** Chen xi**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 date Caltrans OSM Quality Assurance (QA) Inspector, D.Sukanthan was present during the time noted above for observations relative to the work being performed.

OBG # BAY 06 – Cross Beam

This QA inspector performed Ultrasonic Test of approximately 10% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an Ultrasonic Test report for this date. The member is identified as Floor Beam. The weld designations reviewed are as follows:

(FB204-021-040,046)

(FB204-022-009,006,018,024)

(FB204-023-012,006)

(FB204-024-031,025)

(FB205-021-019,013)

(FB205-022-019,013)

(FB205-023-022,016)

(FB205-024-012,006)

This QA Inspector randomly observed the following work in progress:

OBG # BAY 01

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Flux Cored Arc Welding Process:

Welding of weld joint –002,003 located on PCMK CW001B-PP054. Welder is identified as 054460. ZPMC QC is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-TC-U4b-F-1.

Welding of weld joint –002 located on PCMK CW001B-PP076. Welder is identified as 219188. ZPMC QC is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-TC-U4b-F-1.

Welding of weld joint –001 located on PCMK CW001B-PP052. Welder is identified as 054460. ZPMC QC is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-TC-U4b-F-1.

OBG # BAY 02

Submerged Arc Welding Process:

Welding of weld joint –026 located on PCMK FB3037-001. Welder is identified as 207237. ZPMC QC is identified as Zhan hai feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-B-L2C-S-2.

Flux Cored Arc Welding Process:

Welding of weld joint –023 located on PCMK FB3004-001. Welder is identified as 045209. ZPMC QC is identified as Zhan hai feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-B-U2-F-1.

OBG # BAY 03

Flux Cored Arc Welding Process:

Welding of weld joint –037,038 located on PCMK CB202G-028. Welder is identified as 044794. ZPMC QC is identified as Yin dong hai. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-TC-U4b-F-1.

Welding of weld joint –037,038 located on PCMK CB202G-026. Welder is identified as 044794. ZPMC QC is identified as Yin dong hai. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-TC-U4b-F-1.

Shield Metal Arc Welding Process:

Welding of weld joint –144,162 located on PCMK CB202G-028. Welder is identified as 085102. ZPMC QC is

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identified as Yin dong hai. The welding variables recorded by QC appeared to comply with the WPS-B-P-2113.

Welding of weld joint –182,183 located on PCMK CB202G-025. Welder is identified as 051359. ZPMC QC is identified as Yin dong hai. The welding variables recorded by QC appeared to comply with the WPS-B-P-2113.

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

Summary of Conversations:

No Relevant Conversation

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.

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