

**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-008176**Date Inspected:** 26-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:** Zhu Tian Shu / 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 Components**Summary of Items Observed:**

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

**BAY#3**

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an MT report for this date. The member is identified as a Floor Beams. The weld designations reviewed as follows:

FB003-200-05,03,61,62,66,101,102.Side B only.Green Tag no -009703.

FB003-186-02,04,55,56,99,100. Side B only. Green Tag no -009705.

FB003-177-03,05,74,77,97,101. Side B only. Green Tag no -009704.

FB003-198-02,04,75,76,83,84. Side B only. Green Tag no -009702.

FB003-195-03,05,73,66,102,81. Side B only. Green Tag no -009701.

FB003-191-03,05,86,85,65,66. Side B only. Green Tag no -009700.

FB011-038-04,10,23,30,36,61.

FB009-038-01,03,11,20,33,42.

FB028-011-86,111,139,126,127,129.

FB011-039-09,12,15,20,33,41.

FB009-037-10,14,23,36,47.

FB010-036-03,15,20,24,31.

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## WELDING INSPECTION REPORT

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BAY#2

Ongoing SAW Welding of Weld Joint 1G-80 Located on FB081-001 Welder no indentified as 250050 and The welding variables recorded by QC ZMPC Mr.Zhan Hai feng to comply with the WPS-B-T-2221-B-L2c-S-2.

During in-process visual inspection of the fabrication of Floor Beam this Quality Assurance Inspector observed that a Repair welding of wrong drilled holes 7 location in FL3 was not carried out as per approved CWR And SMAW Electrode used for that repair was TL-508 instead of TL-508-H4.

For more information , please see the Incident report

040120F4\_TL015\_B255\_07-26-09\_CWR not followed for repair of wrong Drilled holes in FB25

BAY#3

Ongoing FCAW Welding of Weld Joint 1G-012 Located on LD010-008 Welder no indentified as 0208035 and The welding variables recorded by QC ZMPC Mr.Zhang ya xu to comply with the WPS-B-T-2231-Tc-P4-F.

Ongoing FCAW Welding of Weld Joint 2F-011 Located on LD004-052 Welder no indentified as 044790 and The welding variables recorded by QC ZMPC Mr .Zhang ya xu to comply with the WPS-B-T-2132-3.

Ongoing FCAW Welding of Weld Joint 3G-006 Located on SSD10A-PP104 Welder no indentified as 044830 and The welding variables recorded by QC ZMPC Mr .Shi Lei to comply with the WPS-B-T-2233-Tc-U4b-F.

Green Tag issued for the following items after NDT carried out successfully.

FB023-009- 009709.

FB027-010-009712.

FB019-006-009706.

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

**Summary of Conversations:**

No Relevant Converstaion.

**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 Jim Simonis - 134-7246-3441, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Kumar,Chadra	Quality Assurance Inspector
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<b>Reviewed By:</b>	Clifford,William	QA Reviewer
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