

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-008202**Date Inspected:** 09-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Lin, An Qing Xing**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 components**Summary of Items Observed:**

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

Bay# 11- Tower Assembly:

This QA Inspector randomly observed the following work in progress:

Final VT:

This QA inspector performed Final Visual Testing (FVT) of entire welded area, previously tested and accepted by ZPMC Quality Control personnel of the member and weld designated are as follows:

Sl # Section # Weld # Green Tag # Location

1. WSD1- TL 6 C/L 6, 7, 15, 16, 97, 98 NA NA

SAW Process:

Welding of weld joint# 81B located on PCMK WSTL3-4 B/K. Welder is identified as 044558. ZPMC QC is identified as Li Lin. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2221-C-U2b-S-2.

Welding of weld joint# 81B located on PCMK WSTL3-4 B/K. Welder is identified as 044560. ZPMC QC is identified as Li Lin. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2221-C-U2b-S-2.

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Welding of weld joint# 81B located on PCMK WSTL3-4 B/K. Welder is identified as 044550. ZPMC QC is identified as Li Lin. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2221-C-U2b-S-2.

Welding of weld joint# 81B located on PCMK WSTL3-4 B/K. Welder is identified as 056975. ZPMC QC is identified as Li Lin. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2221-C-U2b-S-2.

Welding of weld joint# 81B located on PCMK WSTL3-4 B/K. Welder is identified as 202756. ZPMC QC is identified as Li Lin. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2221-C-U2b-S-2.

SMAW Process:

Welding of weld joint# 64B located on PCMK WSD1 FESA4-4 F/F. Welder is identified as 041271. ZPMC QC is identified as Li Jun. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3211-TC-U5b-1.

FCAW Process:

Weld buttering of Part# 169 as per Weld Repair Report (WRR)# T-WR-1875 dated 07.30.09. Welder is identified as 062126. ZPMC QC is identified as Li Jun. The welding variables recorded by QC appeared to comply with the specified WPS no. WPS-345-FCAW-2(G) 2F Repair.

Weld buttering of Part# 169 as per Weld Repair Report (WRR)# T-WR-1875 dated 07.30.09. Welder is identified as 070046. ZPMC QC is identified as Li Jun. The welding variables recorded by QC appeared to comply with the specified WPS no. WPS-345-FCAW-2(G) 2F Repair.

Weld buttering of Part# 169 as per Weld Repair Report (WRR)# T-WR-1875 dated 07.30.09. Welder is identified as 066882. ZPMC QC is identified as Li Jun. The welding variables recorded by QC appeared to comply with the specified WPS no. WPS-345-FCAW-2(G) 2F Repair.

Weld buttering of Part# 171 as per Weld Repair Report (WRR)# T-WR-1875 dated 07.30.09. Welder is identified as 068865. ZPMC QC is identified as Li Jun. The welding variables recorded by QC appeared to comply with the specified WPS no. WPS-345-FCAW-2(G) 2F Repair.

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

Summary of Conversations:

Shield Metal Arc welding was being carried out by the welders were identified as 040733 and 040690 with Insufficient pre-heat temperature on Stiffener to skin Plate. The weld joint is designated as weld# 56A and 28A respectively located on PCMK WSD1 FCSEA4-4 D/D. The recorded temperature at the adjacent base material was less than 1800C. The required preheat temperature according to the approved WPS no. B-T-3211-TC-U5b-1 is 1800C. See attached pictures.

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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 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By: Chakrabarti,Dilip Kumar

Quality Assurance Inspector

Reviewed By: Clifford,William

QA Reviewer