

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-008241**Date Inspected:** 25-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Hu Wei Qing**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, Utekar Shrikant was present during the times noted above for observations relative to the work being performed.

BAY # 7

Ultrasonic Inspection

This QA Inspector performed Ultrasonic Testing 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 Side Plate Designation are as follows.

SP3015-001-097, 098

SP3013-001-097, 098

SP3014-001-097, 098

BAY # 5

Ultrasonic Inspection

This QA Inspector performed Ultrasonic Testing 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

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identified as the Side Plate Designation are as follows.

CB202B-011-01, 02, 03, 04

BAY # 5

Welder Qualification

This Q.A Inspector performed ZPMC Welder Qualification of the Welder Mao Shuai (217294) for FCAW in 4G Position with Back strip as per the WPS- B-T 2334-B-U2A-F on 25mm thickness plate. During the observation this QA noted the travel speed of the welder was less than the requirement. Other parameter found satisfactory to the requirement.

This QA Inspector randomly observed the following work in progress

BAY#07

FCAW welding process of weld joint 172 located on PCMK SP3003-001. Welder is identified as 054459 ZPMC QC is identified as Shen Jian Gua. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

FCAW welding process of weld joint 176 located on PCMK SP3003-001. Welder is identified as 053742 ZPMC QC is identified as Shen Jian Gua. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

FCAW welding process of weld joint 180 located on PCMK SP3003-001. Welder is identified as 051246 ZPMC QC is identified as Shen Jian Gua. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

BAY#01

FCAW welding process of weld joint 006 located on PCMK CW001B-PP080. Welder is identified as 251246 ZPMC QC is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133.

FCAW welding process of weld joint 005 located on PCMK CW001B-PP072. Welder is identified as 059450 ZPMC QC is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133

BAY#02

FCAW welding process of weld joint 11 located on PCMK LD003-044. Welder is identified as 215676 ZPMC QC is identified as Wang Liang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

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FCAW welding process of weld joint 05 located on PCMK LD011-017. Welder is identified as 048433 ZPMC QC is identified as Wang Liang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

BAY#06

FCAW welding process of weld joint 018 located on PCMK WSD1-DPSA4-4B/B. Welder is identified as 066478 ZPMC QC is identified as Zou Liu Hai. The welding variables recorded by QC appeared to comply with the WPS-B-T-3312-TC-P5.

FCAW welding process of weld joint 019 located on PCMK WSD1-DPSA4-4B/B. Welder is identified as 066459ZPMC QC is identified as Zou Liu Hai. The welding variables recorded by QC appeared to comply with the WPS-B-T-3312-TC-P5

FCAW welding process of weld joint 02 located on PCMK SSD1-DPSA4-7B/B. Welder is identified as 220061 ZPMC QC is identified as Zou Liu Hai. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P4-F.

Unless otherwise noted, all work observed on this dated 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 Jim Simonis - 134-7246-3441, who represents the Office of Structural Materials for your project.

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| Inspected By: | Utekar,Shrikant | Quality Assurance Inspector |
| Reviewed By: | Clifford,William | QA Reviewer |
