

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-008571**Date Inspected:** 14-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:** Xu Yumin, Wang Chuangng**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 & Tower**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.

This QA Inspector randomly observed the following work in progress.

OBG SEGMENT-1AAE-1AE

FCAW welding process of weld joint 516 located on PCMK SEG2E. Welder is identified as 045276 ZPMC QC is identified as Chen Bo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U3-F.

FCAW welding process of weld joint 050 located on PCMK SEG004C. Welder is identified as 050316 ZPMC QC is identified as Chen Bo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U3-F.

FCAW welding process of weld joint 050 located on PCMK SEG004B. Welder is identified as 045280 ZPMC QC is identified as Chen Bo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U3-F.

SMAW welding process of weld joint 878 located on PCMK SEG2E. Welder is identified as 045268 ZPMC QC is identified as Chen Bo. The welding variables recorded by QC appeared to comply with the

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WPS-B-P-2114-FCM-1.

OBG SEGMENT-1AAW-1AW

FCAW welding process of weld joint 858 located on PCMK SEG1E. Welder is identified as 220067 ZPMC QC is identified as Chen Bo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2134.

FCAW welding process of weld joint 856 located on PCMK SEG1E. Welder is identified as 220069 ZPMC QC is identified as Chen Bo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2134.

FCAW welding process of weld joint 837 located on PCMK SEG1E. Welder is identified as 220066 ZPMC QC is identified as Chen Bo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2134.

OBG SEGMENT-2AW-2BW

SMAW welding process of weld joint 004 located on PCMK SSD14-PP17. Welder is identified as 048659 ZPMC QC is identified as Yang Ding. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G (2F) Repair. The critical weld report noted as B-CWR632.

This QA Inspector observed ZPMC performing base metal repair on bottom panel 'I' rib Stiffener at PP13. Welder is identified as 049769 ZPMC QC is identified as Xu Yumin. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-3G (3F) Repair.

OBG SEGMENT-2AE-2BE

This QA Inspector observed ZPMC performing base metal repair on bottom panel 'I' rib Stiffener at PP13. Welder is identified as 037743 ZPMC QC is identified as Xu Yumin. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-3G (3F) Repair.

BAY #10

FCAW welding process of weld joint 150 located on PCMK SSSL3-1I/K. Welder is identified as 057266 ZPMC QC is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS-B-T-4334-TC-P4-F.

FCAW welding process of weld joint 61 located on PCMK SSSL3-1D/K. Welder is identified as 059257 ZPMC QC is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS-B-T-3212-B-U2A-1.

FCAW welding process of weld joint 67 located on PCMK SSSL3-1I/K. Welder is identified as 056200 ZPMC QC is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS-B-T-3212-B-U2A-1.

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OBG segment 1AAE-1AE

During the random visual inspection this Caltrans Quality Assurance Inspector (QA) observed ZPMC performed welding on the weld SEG004C-050, south side longitudinal diaphragm splice weld joint between OBG segment 1AAE and 1AE, without adequate preheating of the adjacent base material. This QA Inspector observed a 65 degree Celsius Tempstick did not melt when applied to the adjacent base material. For additional information see attached photos. Incident report was send to task leader and other supervisor.

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

Inspected By: Utekar,Shrikant

Quality Assurance Inspector

Reviewed By: Clifford,William

QA Reviewer