

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-008701**Date Inspected:** 18-Aug-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:	Zhan Hai Feng/ Guo Yuan Ting	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, Hiranch Patel, was present during the times noted above for observations relative to the work being performed.

Bay #3

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

- (CB202F-014-001~002)
- (CB202D-014-001~002)
- (FB024-010-078~081, 101, 108, 117, 112)
- (FB003-177-020, 008)
- (FB003-198-020, 008)
- (SSD19-PP108-137)
- (SSD16-PP104-006)

Bay #6

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

- (CB202C-009-003~004)

Bay#6

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC

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Quality Control personnel. This QA Inspector generated an MT report for this date. The member is identified as OBG Components. The weld designations reviewed are as follows:

-(CB202C-009-003~004)

This QA inspector observed the following work i-n progress:

Bay#1

FCAW welding of weld joint CB201G-013-089~095, 073~088 and CB201G-014-089~095, 073~088 located on CB007. Welder is identified as 216575 (3G). ZPMC QC-CWI is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint CB201G-015-089~095, 073~088 and CB201G-016-089~095, 073~088 located on CB007. Welder is identified as 054466(3G). ZPMC QC-CWI is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint CW00113-PP062-003 located on CW00113-PP062. Welder is identified as 059450(3G). ZPMC QC-CWI is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint CW00213-PP080-003 located on CW00213-PP080. Welder is identified as 251246 (3G). ZPMC QC-CWI is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Root Pass performed by FCAW welding of weld joint CB202F-015-001/002 located on CB015. Welder is identified as 054460 (1G). ZPMC QC-CWI is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS.

SAW welding of weld joint CB202F-015-001 located on CB015. Welder is identified as 207345 (1G). ZPMC QC-CWI is identified as Zhang Jing Xin. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Bay#2

Root Pass performed by FCAW welding of weld joint FB3006-001-079, 078 located on FB3006-001. Welder is identified as 045203 (1G). ZPMC QC-CWI is identified as Zhan Yaxu. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Root Pass performed by FCAW welding of weld joint FB3054-001-079, 078 located on FB3054-001. Welder is identified as 066164 (1G). ZPMC QC-CWI is identified as Zhan Yaxu. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Root Pass performed by FCAW welding of weld joint FB3081-001-101 located on FB3081-001. Welder is identified as 062708 (1G). ZPMC QC-CWI is identified as Zhan Yaxu. The welding variables recorded by QC appeared to comply with the Applicable WPS.

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SAW welding of weld joint FB3081-001-078, 079, 081 located on FB3081-001. Welder is identified as 250050 (1G). ZPMC QC-CWI is identified as Zhan Yaxu. The welding variables recorded by QC appeared to comply with the Applicable WPS.

SAW welding of weld joint FB3031-001-078, 081, 101 located on FB3031-001. Welder is identified as 207237 (1G). ZPMC QC-CWI is identified as Zhan Yaxu. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Bay#3

FCAW welding of weld joint FB205-041-003, 014, 010, 011, 006, 012 located on FB205-041. Welder is identified as 044830 (3G). ZPMC QC-CWI is identified as Yin Dong Hai. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint FB205-042-014, 015, 020, 021, 013, 019 located on FB205-042. Welder is identified as 044830 (3G). ZPMC QC-CWI is identified as Yin Dong Hai. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint FB205-043-020, 021, 014, 015, 019, 013, 003, 004, 010, 011, 009, 005, 006, 012 located on FB205-043. Welder is identified as 044830 (3G). ZPMC QC-CWI is identified as Yin Dong Hai. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Bay#5

Joint fit-up verified by SMAW welding process of weld joint CB202A-009-005 located on CB009. Welder is identified as 215672 (1G). ZPMC QC-CWI is identified as Liu Chuan Gang. The welding variables recorded by QC appeared to comply with the Applicable WPS

Cross Beams Update:

CB007-Bay#1- Welding of Floor Beam to Side Plate joints in progress

CB009-Bay#6- Fit Up of Bottom Plate in Progress

CB012-Bay#8- Fit Up of Bottom Plate in Progress

Unless otherwise noted, all observed on this date 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 Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

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Inspected By: Patel,Hiranch

Quality Assurance Inspector

Reviewed By: Prue,Erik

QA Reviewer