

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-008874**Date Inspected:** 20-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:** Chen Xi/ Sun Wei**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 #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:

-(BP3026-001-002, 003)

-(SP3023-001-057, 058, 080, 081)

-(SP3023-001-001~005)

-(BP3025-001-002, 003)

Bay #9

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:

-(DP3005-001-048, 049, 058, 059)

-(DP3047-001-061, 062)

-(DP3051-001-025, 026, 047, 048, 067, 068)

Bay #9

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

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OBG Components. The weld designations reviewed are as follows:

-(TR1F-PP11-11, 12)

Bay#5

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 OBG Components. The weld designations reviewed are as follows:

-(TR1F-PP11-11, 12)

-(TR5E-PP11-09, 10)

-(TR5F-PP11-11, 12)

-(TR6D-PP10-07, 08)

Bay#6

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 OBG Components. The weld designations reviewed are as follows:

-(BP3025-002-008, 009, 010, 011, 012, 013, 051, 052, 053, 054, 055)- Green Tag#10401

-(BP3026-002-008, 009, 010, 011, 012, 013, 051, 052, 053, 054, 055)- Green Tag#10399

-(SP3023-001-027~036, 076, 077, 089, 090)- Green Tag#10400

-(SP3034-001- 093, 094, 095, 096, 097, 098)- Green Tag#10398

-(SP3001-001-021, 022, 023, 024)- Green Tag#10395

-(SP3034-001-163, 164, 061, 062, 063, 064)- Green Tag#10397

-(SP3001-001-041, 042, 043, 044)- Green Tag#10396

Bay#6

This QA inspector performed Final VT on Cable Tray Supports welds of the area previously tested and accepted by ZPMC Quality Control personnel. The member is identified as OBG Components. The drawing number reviewed is as follows:

Drawing Number- CTS1D (A, B, C, D, E, F, G, H, I, J, K, L, M)

Quantity- 13 Numbers

This QA inspector observed the following work in progress:

Cross Beams Update:

CB-007, Bay#1

FCAW welding of weld joint CB201A-007-005, 017 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 CB201A-007-005, 017 located on CB007. Welder is identified as 054460 (3G). ZPMC QC-CWI is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS.

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Quality Assurance Inspector observed on cross beam-007 ZPMC QC change the joint designs of the weld numbers listed below. According to approved drawing these welds are 8mm fillet weld with the approved WPS-B-T-2132-3, because of an excessive root opening (more than 5mm) on these joints, ZPMC QC change it to CJP welds (Complete joint penetration) with WPS-B-T-2232-Tc-U4c-F-1 (with steel backing bar). The joint design has been changed from a fillet weld to a CJP weld without prior approval of the engineer. See incident report on this date.

Weld numbers#

BOTTOM PLATE CB201G-013-049, CB201G-014-043, 061, CB201G-015-043, CB201G-016-043,

EAST WEB PLATE CB201G-014-119, 167, 131,

MIDDLE WEB PLATE CB201G-014-089, 099 CB201G-15-097, 101,131, CB201G-016-017, 101, 103, 097

WEST WEB PLATE CB201G-14-067 CB201G-15-063, 065, 067 CB201G-016-067, 069

CB-015

SAW welding of weld joint CB202D-015-002 located on CB-015. Welder is identified as 207345(3G). ZPMC QC-CWI is identified as Zhang Yaxu. The welding variables recorded by QC appeared to comply with the Applicable WPS.

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.

Inspected By:	Patel,Hiranch	Quality Assurance Inspector
Reviewed By:	Prue,Erik	QA Reviewer
