

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-008875**Date Inspected:** 22-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 #2

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:

-(FB3037-001-023, 050, 026)

-(FB3010-001-023, 031, 026)

-(FB3002-001-023, 050, 026)

-(FB3100-001-023, 031, 026)

-(FB3041-001-023, 031, 026)

-(FB3087-001-023, 031, 026)

-(FB3028-001-023, 050, 026)

-(FB3052-001-023, 050, 026)

This QA inspector observed the following work in progress:

Bay#2

FCAW welding of weld joint FB3088-003-005~012 located on FB3088-003. Welder is identified as 045203 (3G). ZPMC QC-CWI is identified as Zhan Hai Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

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FCAW welding of weld joint FB3088-003-013~020 located on FB3088-003. Welder is identified as 045209 (3G). ZPMC QC-CWI is identified as Zhan Hai Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint FB3088-004-005~012 located on FB3088-004. Welder is identified as 045203 (3G). ZPMC QC-CWI is identified as Zhan Hai Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint FB3088-004-013~020 located on FB3088-004. Welder is identified as 045209 (3G). ZPMC QC-CWI is identified as Zhan Hai Feng. 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.

Cross Beams Update:

CB007-Bay#1- Welding of Floor Beam splices is in progress

FCAW welding of weld joint FB204-013-053, 054 and FB204-014-053, 054 located on CB-007. Welder is identified as 054460 (1G). ZPMC QC-CWI is identified as Tian Lie. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint FB204-015-053, 054 and FB204-016-053, 054 located on CB-007. Welder is identified as 216575 (1G). ZPMC QC-CWI is identified as Tian Lie. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint FB205-013-029, FB205-014-029, FB205-015-029 and FB205-016-029 located on CB-007. Welder is identified as 216575 (3G). ZPMC QC-CWI is identified as Tian Lie. The welding variables recorded by QC appeared to comply with the Applicable WPS.

CB015-Bay#1- Welding of Side Plate splice is in progress

FCAW welding of weld joint CB202F-015-001, 002 and CB202E-015-001, 002, 003 located on CB-015. Welder is identified as 059450 (1G). ZPMC QC-CWI is identified as Zhang Yaxu. The welding variables recorded by QC appeared to comply with the Applicable WPS.

SAW welding of weld joint CB202F-015-001, 002 located on CB-015. Welder is identified as 207345 (1G). ZPMC QC-CWI is identified as Zhang Yaxu. The welding variables recorded by QC appeared to comply with the

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Applicable WPS.

CB008-Bay#6- Welding of side plate to Deck plate (Corner Joint).

FCAW welding of weld joint CB202A-008-002 located on CB-008. Welder is identified as 058174 (1G). ZPMC QC-CWI is identified as Meng Linnan. The welding variables recorded by QC appeared to comply with the Applicable WPS.

CB012-Bay#8- Welding of Bottom Plate splices is in Progress

SAW welding of weld joint CB201-012-002 located on CB-012. Welder is identified as 207463 (1G). ZPMC QC-CWI is identified as Zhang Jing Xin. The welding variables recorded by QC appeared to comply with the Applicable WPS.

CB010- Out side yard- Welding of side plate to Bottom plate (Corner Joint).

FCAW welding of weld joint CB202A-010-005 located on CB-010. Welder is identified as 044830 (1G). ZPMC QC-CWI is identified as Guo Yuan Ting. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint CB202A-010-017 located on CB-010. Welder is identified as 044830 (1G). ZPMC QC-CWI is identified as Guo Yuan Ting. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Caltrans Quality Assurance Inspector observed on cross beam-010 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)(2G) and WPS-B-T-2233-Tc-U4c-F-1 (with steel backing bar)(3G). 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:-CB202G-025-043~062, 001~004, 111~114, 039, 040, 087, 088.

CB202G-026-047~054, 001, 004, 031, 032, 039, 040, 026, 025, 061, 062, 043, 044.

CB202G-027-039~044, 051~062, 001~004.

CB202G-028-021~024, 017, 018, 051, 052, 043, 044, 007, 008, 053, 054, 057, 058, 059, 060, 001~004.

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
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Reviewed By:	Prue,Erik	QA Reviewer
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