

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-009514**Date Inspected:** 04-Oct-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:** Li zhi jiang**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, D.Sukanthan was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

OBG # BAY 01

Flux Cored Arc Welding Process:

Welding of weld joint -001 located on PCMK CW001A-PP054. Welder is identified as 054460. ZPMC QC is identified as Tian lie. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3 / WPS-B-T-2133.

OBG # BAY 02

Flux Cored Arc Welding Process:

Welding of weld joint -045 located on PCMK FB3002-001. Welder is identified as 058245. ZPMC QC is identified as Yang Qing fang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-TC-U4b-F.

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Welding of weld joint –043 located on PCMK FB3053-001. Welder is identified as 058245. ZPMC QC is identified as Yang Qing fang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-TC-U4b-F.

Welding of weld joint –043 located on PCMK FB3051-001. Welder is identified as 045209. ZPMC QC is identified as Yang Qing fang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-TC-U4b-F.

OBG # BAY 06

Shield Metal Arc Welding Process:

Welding of weld joint –083,084,079,080 located on PCMK CB202G-017. Welder is identified as 070007. ZPMC QC is identified as Zhou jie. The welding variables recorded by QC appeared to comply with the WPS-B-P-2112.

Flux Cored Arc Welding Process:

Welding of weld joint –148,166 located on PCMK CB202G-017. Welder is identified as 053609. ZPMC QC is identified as Zhou jie. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132.

Welding of weld joint –020 located on PCMK CB202A-008. Welder is identified as 222396. ZPMC QC is identified as Zhou jie. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132.

OBG # Cross Beam 12

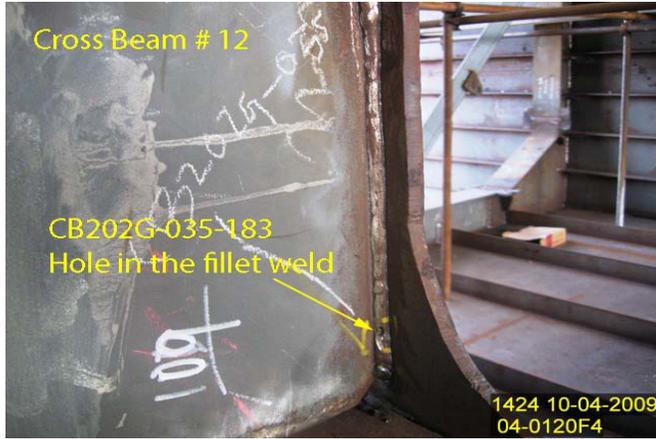
During random in process Visual inspection of crossbeam #12 this QA discovered poor weld profile, Undercut and hole in the FCW fillet welds. The weld designations reviewed are as follows: CB202G-034-183, CB20G-035-183. See attached pictures

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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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 Eric Tsang 150-00422372, who represents the Office of Structural Materials for your project.

Inspected By: Sukanthan,Dhanasingh

Quality Assurance Inspector

Reviewed By: Hall,Steven

QA Reviewer