

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-009586**Date Inspected:** 06-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:** Chen Li**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 COMPONENT**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance(QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

In process Inspection

Bay #2

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) in the 2F position of the OBG floor Beam assembly weld No. FB-3027-001-015/16. The welder is identified as #062438. ZPMC QC is identified as Mr. Yang Qing Feng. The welding variables recorded by QC appear to comply with WPS- B – T-2132-3.

Flux Core Arc Welding (FCAW) in the 2G position of the OBG Floor Beam assembly weld No. FB-3052-001-043. The welder is identified as #045276. ZPMC QC is identified as Mr. Yang Qing Feng. The welding variables recorded by QC appear to comply with WPS- B – T-2232-Tc-U4b-F.

Flux Core Arc Welding (FCAW) in the 2G position of the OBG Floor Beam assembly weld No. FB-6501-001-036/39. The welder is identified as #045203. ZPMC QC is identified as Mr. Yin Dong Hai. The welding variables recorded by QC appear to comply with WPS- B – T-2232-Tc-U4b-F.

Bay #5

WELDING INSPECTION REPORT

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This QA Inspector observed the following work in progress:

SAW welding in the 1G position at weld joint CB-202C-016-004 located on cross Beam assembly . Welder is identified as #215248. ZPMC QC is identified as Zhang Zhi Woi.The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-L2C-S2.

Flux Core Arc Welding (FCAW) in the 2G position of the OBG Traveler Rail assembly weld No 11TR2-014-010/14. The welder is identified as #206358. ZPMC QC is identified as Mr.Zhong Chong Bian .The welding variables recorded by QC appear to comply with WPS- B – T-2232-Tc-U5-F.

Ultrasonic Testing(Gate To Gate)

The QA Inspector performed, gate to gate Ultrasonic Testing (UT) on Orthotropic Box Girder deck plates to closed rib welds at the tack weld locations. The QA Inspector generated a field inspection UT report on this date designating areas of rejectable indications. Panel identification number is DP-3016-001.

The Y locations of indication for the panel were marked and recorded as:

DP-3016-001(12BE)

Total Number of Ribs -04

Total Number of Tack Welds -160

Total Number of Tack Welds Scanned –160

Weld 01: Tack Welds Scanned - 20, Indication Observed – 10

Weld 02: Tack Welds Scanned - 20, Indication Observed – 02

Weld 03: No Indication

Weld 04: Tack Welds Scanned - 20, Indication Observed – 03

Weld 05: Tack Welds Scanned - 20, Indication Observed – 03

Weld 06: Tack Welds Scanned - 20, Indication Observed – 01

Weld 07: Tack Welds Scanned - 20, Indication Observed – 03

Weld 08: Tack Welds Scanned - 20, Indication Observed – 02

Ultrasonic Testing(Phased Array)

The QA Inspector performed Phased Array Ultrasonic Testing (PAUT) on Orthotropic Box Girder deck plates to closed rib welds at the tack weld locations (marked for crack confirmation) which were previously tested by Caltrans QA personnel. The QA Inspector generated a field inspection UT report on this date designating areas of rejectable indications.

Panel identification number is

DP-400-001(11AE)

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

WELDING INSPECTION REPORT

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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:	Bera,Subhasis	Quality Assurance Inspector
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Reviewed By:	Patterson,Rodney	QA Reviewer
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