

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-010068**Date Inspected:** 18-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.

OBG # BAY 02

This QA inspector performed Ultrasonic Test of approximately 10% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an Ultrasonic Test report for this date. The member is identified as Floor Beam. Inspection Notification number- 004414. The weld designations reviewed are as follows:

(FB3059-003-095,096) Green Tag # 10726

(FB3003-003-095,096)

(FB3003-001-095,096)

(FB3060-001-022,023) Green Tag # 10539

OBG # BAY 05

This QA inspector performed Ultrasonic Test of approximately 10% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an Ultrasonic Test report for this date. The member is identified as Bike Path. Inspection Notification number- 004414. The weld designations reviewed are as follows:

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(BK001-036-067,068)
(BK001-035-067,068)
(BK001-034-067,068)
(BK001-033-067,068)
(BK001-032-067,068)
(BK001-031-067,068)

This QA Inspector randomly observed the following work in progress:

OBG # BAY 1

Flux Cored Arc Welding Process:

Welding of weld joint –001 located on PCMK CW001A-PP070. Welder is identified as 219189. ZPMC QC is identified as Tian lei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3 / WPS-B-T-2133.

OBG # BAY 3

Flux Cored Arc Welding Process:

Welding of weld joint –012 located on PCMK LD001-049. Welder is identified as 208035. ZPMC QC is identified as yin dong hai. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-TC-P4-F.

Welding of weld joint –100,101 located on PCMK CSD5-PP105. Welder is identified as 0448305. ZPMC QC is identified as yin dong hai. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

OBG # BAY 5

Flux Cored Arc Welding Process:

Welding of weld joint –010,014 located on PCMK 10TR3-007. Welder is identified as 215689. ZPMC QC is identified as Zhong chong biao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-TC-U5-F.

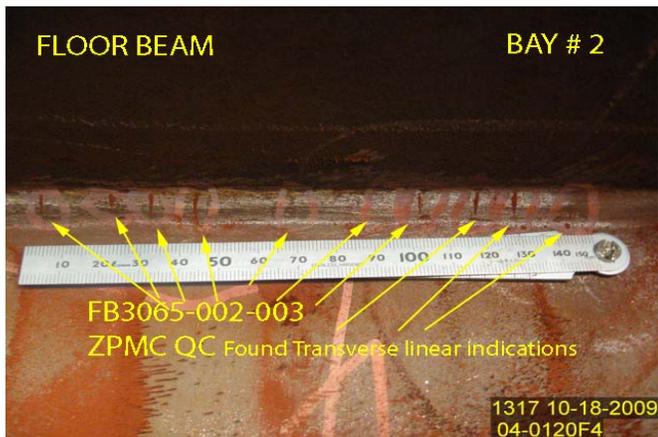
OBG # BAY 2

During in-process visual inspection of OBG floor beam components in Bay 2, This QA inspector observed that ZPMC MT Technician Magnetic particle Testing (MT) Technician identified as Mr. Yu hua xing appears to have rejected thirty seven (37) transverse and longitudinal linear indications. The weld designation as identified on the material is FB3065-002-003,005. See attached picture.

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



Summary of Conversations:

As mention above

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
