

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-010314**Date Inspected:** 11-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen fu you**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, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

BAY#14

FCAW welding of weld joint 2F-005 located on PCMK SSD13-PP78 of 9CW welder is identified as 201215. ZPMC QC is identified as Mr. Li ming yang. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2132.

FCAW welding of weld joint 2F-004 located on PCMK SSD13-PP78 of 9CW welder is identified as 202122. ZPMC QC is identified as Mr. Li ming yang. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2132.

During random visual inspection of OBG assembly fabrication in Bay14, this Caltrans Quality assurance inspector observed that Deck panel Diaphragm tack welds have crack, ZPMC removed that crack and finished their MT before welding, but still some places tack welds have crack, those areas area not welded. ZPMC changed their welding process from FCAW to SMAW.

SMAW welding of weld joint 2F-005 located on PCMK SSD13-PP73 of 9AW welder is identified as 070007. ZPMC QC is identified as Mr. Li ming yang. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2122-FCM-1.

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During random visual inspection it is found that tack weld crack in weld joint fit up of SSD14-PP77-004 Segment 9CW. This is informed to ABF QA Mr.Liu jin ping and ZPMC QC Mr.Li wan ning.

BAY#13

SMAW welding of weld joint 4G-031 located on PCMK SEG068A of 11BE welder is identified as 049339.ZPMC QC is identified as Mr. Tang ya jun. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2214-B-U2-FCM-1.

During UT on Bottom plate and Side plate Splice weld of Segment 11BE the weld no is SEG068A-031 , ZPMC NDT technician Mr.Huang jing found rejected indication 80% of the total length of the weld joint .See attached photos.

During in process inspection of OBG segment Lift 11 fabrication in bay 13, this Caltrans Quality Assurance inspector observed that OBG component Floor Beams (FL-1) stacked in floor over one another. Some of the floor beams legs got damaged.

This is informed to ABF QA Mr.Yang chao.No incident report made for this issue.

FB010-036.

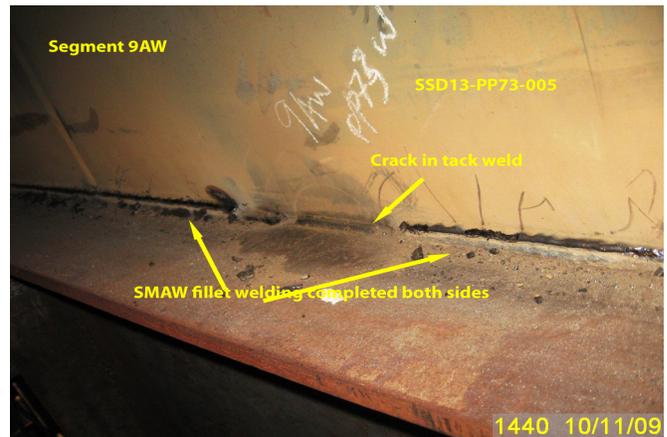
FB015-040.

FB016-007.

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

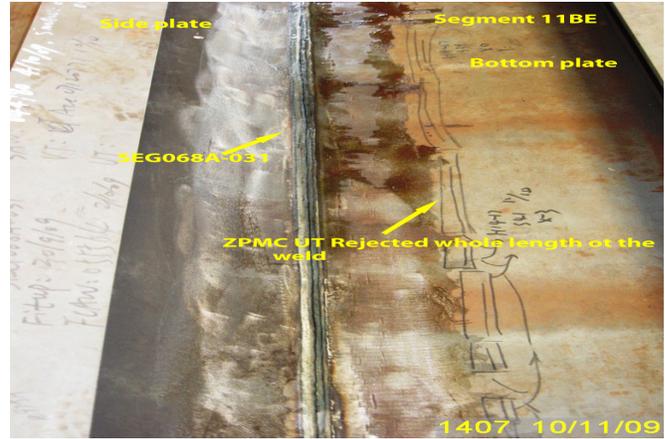
Summary of Conversations:

No relevant Conversation.



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Item	Description	WBS	Dwg No.	Status
1				

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 Jim Simonis - 134-7246-3441, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Chadra	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
