

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-010327**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 #1

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:

-(CB201C-007-002)

Bay #3

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:

-(CB202C-014-004)

-(CB202B-014-001, 003, 004)

Bay#6

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member is identified as OBG Components. The weld designations reviewed are as follows:

-(TRLE-PP28-009)- Green Tag#005471

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

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.

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:

CB015-Bay#1- Welding of Floor Beam is in progress

FCAW welding of weld joint FB204-047-051, 052 located on CB-015. Welder is identified as 054460 (3F). ZPMC QC-CWI is identified as Zhang Yaxu. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint FB204-046-051, 052 located on CB-015. Welder is identified as 216575 (3F). ZPMC QC-CWI is identified as Zhang Yaxu. The welding variables recorded by QC appeared to comply with the Applicable WPS.

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

FCAW welding of weld joint CB202A-008-008 located on CB-008. Welder is identified as 048625 (1G). ZPMC QC-CWI is identified as Meng Linnan. The welding variables recorded by QC appeared to comply with the Applicable WPS.

WELDING INSPECTION REPORT

(Continued Page 3 of 4)

CB009-Bay#6- Welding of bottom plate splice (root pass).

FCAW welding of weld joint CB202C-009-002 located on CB-009. Welder is identified as 019006 (1G). ZPMC QC-CWI is identified as Liachuan Gang. The welding variables recorded by QC appeared to comply with the Applicable WPS.

During random visual inspection of CB-009, Caltrans Quality Assurance (QA) Inspector discovered the excessive root opening on weld joint listed below. According to approved WPS-B-T-2232-3 (2G/2F) and WPS-B-T-2233-(3G/3F), root opening is 0~3mm (+2, -0mm). The recorded root opening is 6mm~12mm. Please see incident report on this date.

Weld Number	Root Opening
CB202G-024-021, 022	8mm
CB202G-024-023, 024	8mm
CB202G-024-035, 036	8mm
CB202G-023-021, 022	7mm
CB202G-023-023, 024	8mm
CB202G-023-039, 040	11mm
CB202G-023-041, 042	9mm
CB202G-022-021, 022	9mm
CB202G-022-023, 024	10mm
CB202G-022-039, 040	12mm
CB202G-022-041, 042	10mm
CB202G-021-021, 022	6mm
CB202G-021-023, 024	6mm
CB202G-021-039, 040	7mm
CB202G-021-041, 042	7mm

CB12-Bay#8- Welding of Bottom Plate splices is in Progress

FCAW welding of weld joint CB201G-033-141, CB201G-034-141, CB201G-035-141 and CB201G-036-141 located on CB-012. Welder is identified as 066687 (3F). ZPMC QC-CWI is identified as Zhang Jiang Xin. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint CB201G-033-159, CB201G-034-159, CB201G-035-159 and CB201G-036-159 located on CB-012. Welder is identified as 0069118 (3F). ZPMC QC-CWI is identified as Zhang Jiang Xin. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint CB201A-012-019 located on CB-012. Welder is identified as 066687 (3F). ZPMC QC-CWI is identified as Zhang Jiang Xin. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint CB201A-012-019 located on CB-012. Welder is identified as 069118 (3F). ZPMC QC-CWI is identified as Zhang Jiang Xin. The welding variables recorded by QC appeared to comply with the Applicable WPS.

WELDING INSPECTION REPORT

(Continued Page 4 of 4)

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

FCAW welding of weld joint CB202G-028-031~138 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 CB202G-027-031~138 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.

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

Note:- This report is the revision of date 22-Aug-2009.

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:	Patel,Hiranch	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
