

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-010425**Date Inspected:** 16-Nov-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:** Liu Fawen**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:** Orthotropic Box Girder Components**Summary of Items Observed:**

On this date Caltrans Office of Structure Materials Quality Assurance (QA) Inspector, Sandeep Kumar was present during the times noted above for observations relative to the work being performed.

BAY 2

This QA Inspector observed the following work in progress:

Flux Core Arc Welding:

This process welding of weld joint # 126 located on Floor Beam FB3056 – 001. Welder is identified as 048433. ZPMC QC is identified as Zhang Hai Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – Tc – U4b – F.

This process welding of weld joint # 004 located on Longitudinal Diaphragm LD001– 050. Welder is identified as 045203. ZPMC QC is identified as Zhang Hai Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

This process welding of weld joint # 127 located on Floor Beam FB3031 – 001. Welder is identified as 045227. ZPMC QC is identified as Zhang Hai Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – Tc – U4b – F.

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This process welding of weld joint # 126 located on Floor Beam FB3039 – 001. Welder is identified as 045209. ZPMC QC is identified as Zhang Hai Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – Tc – U4b – F.

BAY 5

The following NDT inspection carried out as per the ZPMC submitted Notification No. 004649

Magnetic Particle Testing

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 members are identified as OBG Components. The weld designations reviewed are as follows:

1. 10TR1 – 006 – 001
2. 10TR1 – 017 – 001
3. 10TR1 – 018 – 001
4. 10TR1 – 019 – 001
5. 10TR1 – 023 – 001
6. 10TR1 – 024 – 001
7. 10TR1 – 025 – 001
8. 10TR1 – 028 – 001
9. 10TR1 – 029 – 001
10. 10TR1 – 026 – 002
11. 10TR1 – 027 – 002
12. 11TR3 – 016 – 002
13. 11TR3 – 019 – 002
14. 11TR3 – 020 – 002
15. 11TR3 – 021 – 002
16. 11TR3 – 022 – 002
17. 11TR3 – 023 – 002
18. 11TR3 – 025 – 002
19. 11TR3 – 005 – 002
20. 11TR3 – 015 – 002
21. 11TR3 – 014 – 001
22. 11TR3 – 017 – 001
23. 11TR7 – 002 – 001

This QA Inspector observed the following work in progress:

Flux Core Arc Welding:

This process welding of weld joint # 010 located on Traveler Rail 11TR1 – 022. Welder is identified as 215185. 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.

This process welding of weld joint # 010 located on Traveler Rail 10TR3 – 023. Welder is identified as 215078.

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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.

This process welding of weld joint # 010 located on Traveler Rail 11TR1 – 022. Welder is identified as 215185. 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.

This process welding of weld joint # 013 located on Traveler Rail 10TR3 – 026. Welder is identified as 215078. 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.

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

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 - 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Sandeep	Quality Assurance Inspector
Reviewed By:	Hall,Steven	QA Reviewer
