

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-010483**Date Inspected:** 26-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:** Chen Xi**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 (OBG)**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials (OSM) Quality Assurance (QA) Inspector, D.Sukanthan was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

OBG # CROSS BEAM 13 (BAY # 8)

Flux Cored Arc Welding Process:

Welding of weld joints FB204-037-049,050. Welder is identified as 215082. ZPMC Quality Control Personnel (QC) is identified as Zhao cheng jian. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-B-U2-F.

Welding of weld joint FB204-038-060. Welder is identified as 215082. ZPMC QC is identified as Zhao cheng jian. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-B-U2-F.

Shield Metal Arc Welding Process:

Welding of weld joint CB202A-013-005. Welder is identified as 067571. ZPMC QC is identified as Zhao cheng jian. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-TC-U4b.

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OBG # BAY 2

Flux Cored Arc Welding Process:

Welding of weld joint LD3020-001-011. Welder is identified as 045209. ZPMC QC is identified as Zhan hai feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-B-U2-F-1.

Welding of weld joint LD3019-001-019. Welder is identified as 045276. ZPMC QC is identified as Zhan hai feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-B-U2-F-1.

During in process inspection, this Quality Assurance Inspector (QA) observed ZPMC personnel performing weld buttering (weld build up) measured approximately 25mm in length on one (1) cope hole without an approved Critical Weld Repair (CWR) procedure. The member is identified as Stiffener X3111 of Floor beam FB3013-003. The cope hole is located at the end of Fillet weld joints 012,013, 014 and 015. The material is 12mm thick. This QA notified ZPMC Certified Welding personnel (CWI) identified as Chen Xi and ABF Quality Control personnel (QC) identified as Luo of this issue and that an incident report would be generated.

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
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Reviewed By:	Hall,Steven	QA Reviewer
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