

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-010509**Date Inspected:** 30-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 Material (OSM) Quality Assurance (QA) Inspector, D.Sukanthan was present during the time noted above for observations relative to the work being performed.

OBG # BAY 2

This QA inspector received ZPMC Non Destructive Testing (NDT) notification 004763 to perform Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel (QC). This QA Inspector generated a Magnetic Particle Test report for this date. The member is identified as Floor Beam. The weld tested is identified as follows:

(FB3072-001-001,002) Green Tag # 11311
(FB3070-001-001,002) Green Tag # 11307
(FB3070-002-001,002) Green Tag # 11308
(FB3070-003-001,002) Green Tag # 11309
(FB3070-004-001,002) Green Tag # 11310
(FB3015-001-001,002) Green Tag # 11302
(FB3015-002-001,002) Green Tag # 11303
(FB3015-003-001,002) Green Tag # 11304
(FB3015-004-001,002) Green Tag # 11305
(FB3016-001-001,002) Green Tag # 11306

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

This QA Inspector randomly observed the following work in progress:

OBG # BAY 2

Submerged Arc Welding Process:

Welding of weld joints – LD3022-001-018,021. Welder is identified as 045270. ZPMC Quality Control Personnel (QC) is identified as Yang qing feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-B-L2C-S-2.

Welding of weld joints – LD3013-001-007,008. Welder is identified as 045270. ZPMC QC is identified as Zhan hai feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-B-L2C-S-2.

OBG # CROSS BEAM CB08

This QA observed that no significant work was being performed on this crossbeam during the time QA was present.

OBG # CROSS BEAM CB09

This QA observed that no significant work was being performed on this crossbeam during the time QA was present.

OBG # CROSS BEAM CB10

This QA observed that no significant work was being performed on this crossbeam during the time QA was present.

OBG # CROSS BEAM CB11

This QA observed that no significant work was being performed on this crossbeam during the time QA was present.

OBG # CROSS BEAM 12

This QA observed ZPMC qualified welding personnel identified as 066179 perform Shield Metal Arc Welding Process (SMAW) welding on base metal repair after removing lifting lugs. ZPMC QC identified as Sun yan fei was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-3G (3F)-FCM-Repair. Critical weld repair (CWR) number B-CWR 911 (Rev no: 1). See attached picture below.

OBG # CROSS BEAM CB13

This QA observed that no significant work was being performed on this crossbeam during the time QA was

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

present.

OBG # CROSS BEAM CB14

This QA observed that ZPMC is continuing to fit the bottom panel to side panel. No other significant work was being performed on this crossbeam during the time QA was present.

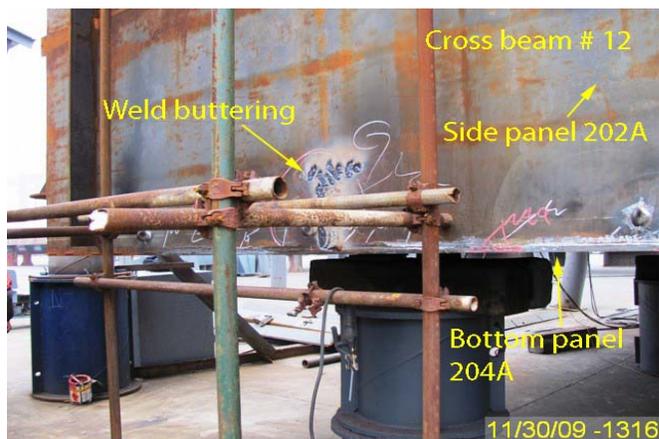
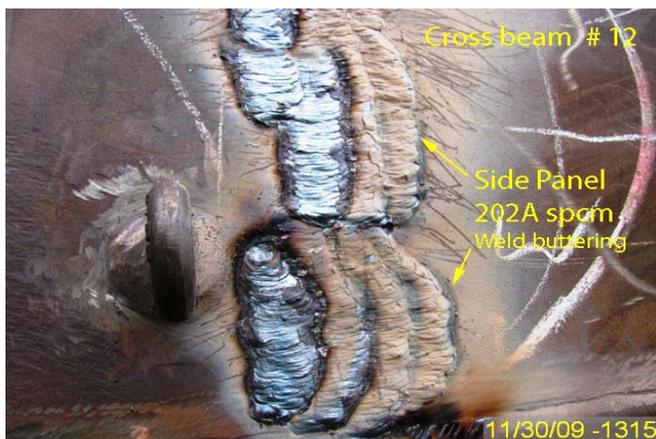
OBG # CROSS BEAM CB15

This QA observed that ZPMC is continuing to fit the bottom panel to side panel. No other significant work was observed on this crossbeam during the time QA was present.

OBG # CROSS BEAM CB16

This QA observed that no significant work was being performed on this crossbeam during the time QA was present.

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