

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-010699**Date Inspected:** 10-Nov-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**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:** Tower and OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector George Goulet was present during the times noted above for observations relative to the work being performed.

Bay 10

This QA Inspector randomly observed the following work in progress in Bay 10:

SMAW welding of weld joints ND1-A6002-2-32, 14 located on PCMK north tower, strut. Welder was identified as 040288. ZPMC QC was identified as Wan Wen Zhong (QC1). The welding variables recorded by QC1 appeared to comply with WPS-B-T-4112-2. Also present at this location and appearing to be monitoring the welding operation was ABF Representative Kong Xian Hui.

SAW welding of weld joint SSSL4-1B/L-4A located outside PCMK south tower, lift 4, skin A to skin B, between approximately 121.5M and 128M elevations. Welder was identified as 0503060. ZPMC QC was identified as CWI Li Ming (QC2). The welding variables recorded by QC2 appeared to comply with WPS-B-T-2221-C-U2b-S-2. Also present at this location and appearing to be monitoring the welding operation was ABF Representative Yang Ye Heng.

SAW welding of weld joint SSSL4-1B/L-4A located outside PCMK south tower, lift 4, skin A to skin B, between approximately 138M and 144M elevations. Welder was identified as 040252. ZPMC QC was identified as QC2. The welding variables recorded by QC2 appeared to comply with WPS-B-T-2221-C-U2b-S-2. Also present at this location and appearing to be monitoring the welding operation was ABF Representative Yang Ye Heng.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

SAW welding of weld joint SSTL4-1B/L-5A located outside PCMK south tower, lift 4, skin B to skin C, between approximately 114.5M and 120M elevations. Welder was identified as 040460. ZPMC QC was identified as QC2.

The welding variables recorded by QC2 appeared to comply with WPS-B-T-2221-C-U2b-S-2. Also present at this location and appearing to be monitoring the welding operation was ABF Representative Yang Ye Heng.

SAW welding of weld joint SSTL4-1B/L-5A located outside PCMK south tower, lift 4, skin B to skin C, between approximately 128M and 136M elevations. Welder was identified as 207745. ZPMC QC was identified as QC2.

The welding variables recorded by QC2 appeared to comply with WPS-B-T-2221-C-U2b-S-2. Also present at this location and appearing to be monitoring the welding operation was ABF Representative Yang Ye Heng.

FCAW welding of weld joint SSTL4-1B/L-5A located outside PCMK south tower, lift 4, skin B to skin C, between approximately 114M and 114.5M elevations. Welder was identified as 052075. ZPMC QC was identified as QC2. The welding variables recorded by QC2 appeared to comply with WPS-B-T-2231-C-U2-F. Also present at this location and appearing to be monitoring the welding operation was ABF Representative Yang Ye Heng.

FCAW welding of weld joint SSTL4-1B/L-5A located outside PCMK south tower, lift 4, skin B to skin C, between approximately 121.5M and 122M elevation. Welder was identified as 050041. ZPMC QC was identified as QC2. The welding variables recorded by QC2 appeared to comply with WPS-B-T-2231-C-U2-F. Also present at this location and appearing to be monitoring the welding operation was ABF Representative Yang Ye Heng.

FCAW welding of weld joint SSTL4-1B/L-5A located outside PCMK south tower, lift 4, skin B to skin C, between approximately 137.5M and 138.5M elevations. Welder was identified as 057244. ZPMC QC was identified as QC2. The welding variables recorded by QC2 appeared to comply with WPS-B-T-2231-C-U2-F. Also present at this location and appearing to be monitoring the welding operation was ABF Representative Yang Ye Heng.

Bay 9 – PMT

This QA Inspector monitored OBG Production Monitoring Test (PMT) #3004 for deck panels DP3004-001 and DP3048-001 at Gantry #2. Prior to the start of the PMT, this QA Inspector observed the root openings to be within the 0.0 to 0.5mm tolerance. The magnetic particle test (MT) of the tack welds was noted on the test panel as having been performed by ZPMC MT Inspector Li Zhenhua on 11/6/09. The visual inspection of tack welds and root gaps was performed by ABF Representative Cao Hai Zhou (ABF), ZPMC CWI Guo Yanfei (QC), and this QA Inspector. The tack welds and root gaps appeared to be within prescribed tolerances. This QA Inspector observed that the deck plate of the test panel was 14mm thick and the deck plate of the production panels were 14mm thick. The start time for welding of the 3–12mm x 14mm specimens was approximately 0012 hours on 11/11/09 and the finish time was approximately 0038 hours. This QA Inspector randomly verified and documented the welding amperage, voltage, and travel speed during the gas metal arc welding (GMAW) and submerged arc welding (SAW) processes, welds 1 thru 6 at the completion of both the GMAW root pass and SAW cover pass. The welding variables recorded by QC appeared to comply with WPS-B-T-2342-U1-(U-rib)-4. The welds were visually inspected by ABF, QC and this QA Inspector. QC and ABF informed this QA Inspector that all six welds were acceptable and this QA Inspector concurred. This QA inspector randomly witnessed ZPMC

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

ultrasonic testing (UT) inspector, identified as Ma Jilong, perform UT on each of the 500mm test welds for depth of penetration and conformance. This QA Inspector selected fifteen designated locations for macroetch sampling per contract requirements. Each macroetch sample location was stamped by ZPMC personnel with the number 3004, a number or letter, chosen randomly by this QA Inspector as a verification mark, and an individual progressive macroetch identifying number for each macroetch. After removal from each of the weld test specimens, polishing, and acid etching of the selected end, the macroetches were evaluated with a 7X optical magnifier and accepted by QC, ABF, and this QA Inspector.

All fifteen sample macros appeared to meet requirements and were noted to appear acceptable. See Caltrans U-ribs PMT Inspection Sheet, ZPMC production monitoring test plate inspection report, and Caltrans Macro Etch Log - all dated 11/11/2008 for additional information.

Summary of Conversations:

As noted 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 Serge Sinevod, 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet,George	Quality Assurance Inspector
Reviewed By:	Dawson,Paul	QA Reviewer
