

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-013218**Date Inspected:** 08-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhou Cheng**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#19-SB023-106E

During random Quality Assurance Visual review of the suspender bracket components, this Quality Assurance Inspector (QA) discovered the following issue:

-During the Flux Cored Arc Welding (FCAW) welding Suspender bracket SB23-106E, ZPMC personal have welded over the 25mm clipped corners of sub component X64C.

-The cope holes are located in-between welds identified as: SB23-106-049 & 047 and SB23-106-049&051

- The plate X64C is identified as non SPCM.

-The Component is located in OBG fabrication Bay#19.

For further information, please see the attached pictures below.

Bay#19

FCAW welding of weld joint BP025-015-013, 012 located on BP025-015. Welder is identified as 062701 (2F).

ZPMC QC is identified as Zhou Cheng. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132.

FCAW welding of weld joint BP025-015-014 located on BP025-015. Welder is identified as 062752 (2F). ZPMC QC is identified as Zhou Cheng. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132

FCAW welding of weld joint BP025-015-015 located on BP025-015. Welder is identified as 062786 (2F). ZPMC

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QC is identified as Zhou Cheng. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132

FCAW welding of weld joint SB023-106-011, 012, 021, 022 located on SB023-106. Welder is identified as 062755 (3G). ZPMC QC is identified as Zhou Cheng. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-Tc-P5-F

FCAW welding of weld joint SB022-104-011, 012, 021, 022 located on SB023-106. Welder is identified as 062788 (3G). ZPMC QC is identified as Zhou Cheng. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-Tc-P5-F

FCAW welding of weld joint SB022-106-011, 012, 021, 022 located on SB023-106. Welder is identified as 062808 (3G). ZPMC QC is identified as Zhou Cheng. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-Tc-P5-F

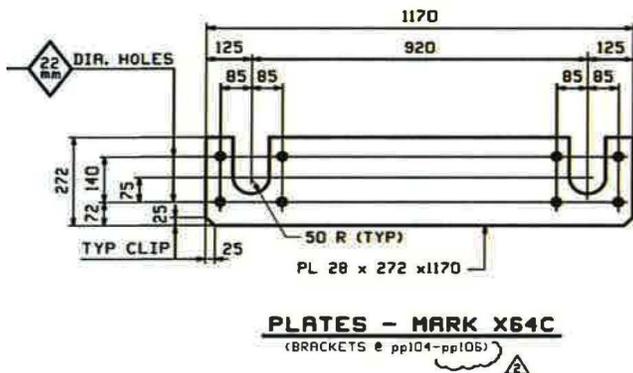
Bay#19

During random in process inspection of Bike Path, BK4A-006, this QA inspector observed that more than 2mm gap between plates X10A and X10C. According to approved drawings this joint is a tight fit. ZPMC personal has to minimize the gap between these plates and make it less than 2mm.

For further information, please see the attached pictures below.

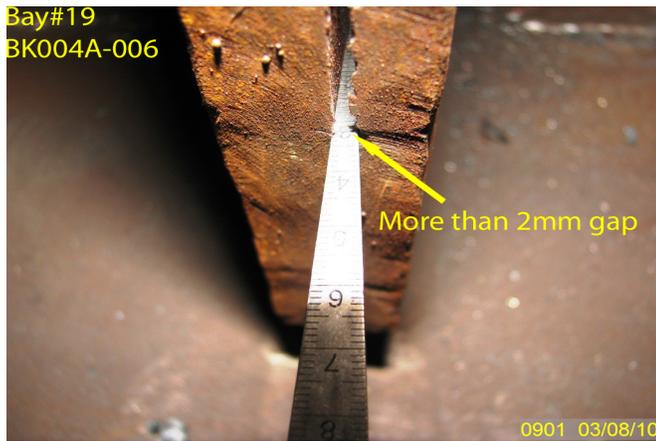
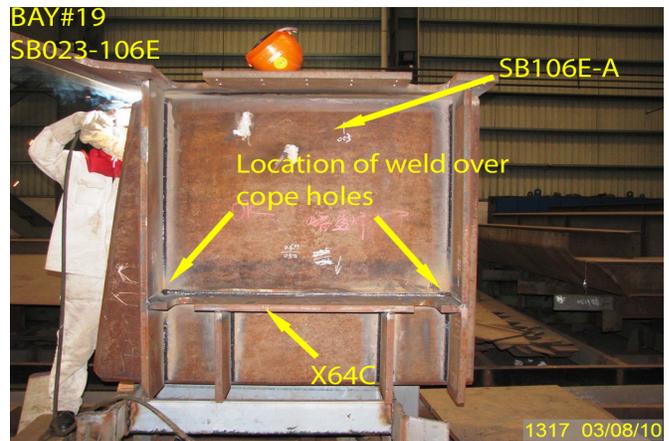
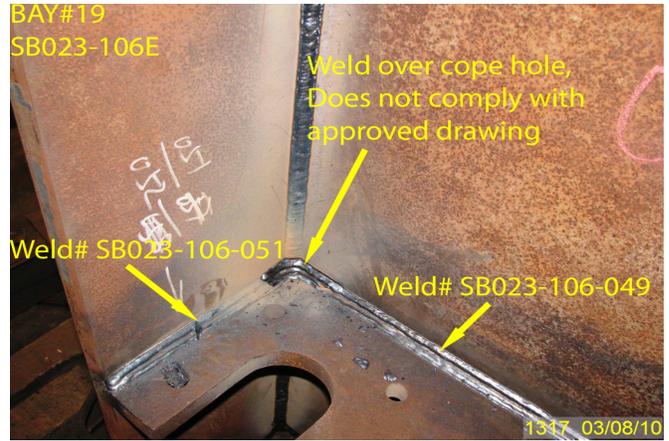
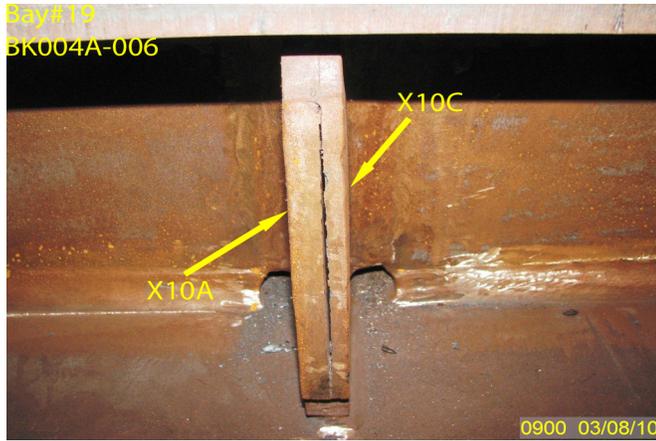
During random in process inspection of Bottom plate BP3017-001, this QA inspector observed that ZPMC personal use 2 ton weight during joint fit up of stiffeners. The bottom plate is SPCM material and stiffeners are non SPCM material. The tack welds of the stiffeners to bottom plates are performed by SMAW welding process. For further information, please see the attached pictures below.

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



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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.

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Inspected By:	Patel, Hiranch	Quality Assurance Inspector
Reviewed By:	McClendon, Timothy	QA Reviewer
