

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-014327**Date Inspected:** 11-May-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:** 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 005713 to perform Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated a Ultrasonic Test report for this date. The member is identified as Traveler Rail & Floor beam. The weld tested is identified as follows:

(10TR2-002-006,013,014)

(10TR1-018-006,013,014)

(10TR2-015-006,013,014)

(10TR1-010-005,007,014)

(11TR1-022-006,013,014)

(11TR2-018-005,007,014)

(11TR1-025-006,013,014)

(11TR2-017-005,007,014)

(FB3184-001-004R1)

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

This QA Inspector randomly observed the following work in progress:

OBG # BAY 1

This QA observed ZPMC qualified welding personnel identified as 219188 perform Flux Cored Arc Weld (FCAW) Process on weld joint 20TR1-044-001. ZPMC Quality Control Personnel (QC) identified as Mr. Xiang Feng Feng 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-B-T-2232-TC-U5-F.

This QA observed ZPMC qualified welding personnel identified as 216872 perform Flux Cored Arc Weld (FCAW) Process on weld joint 20TR1-042-003. ZPMC Quality Control Personnel (QC) identified as Mr. Xiang Feng Feng 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-B-T-2232-TC-U5-F.

OBG # BAY 3

This QA observed ZPMC qualified welding personnel identified as 050502 perform Submerged Arc Weld (SAW) Process on weld joint FB3122-001-008. ZPMC Quality Control Personnel (QC) identified as Mr. Zhang yaxu 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-B-T-2221-B-U3C-S-2.

This QA observed ZPMC qualified welding personnel identified as 062406 perform Submerged Arc Weld (SAW) Process on weld joint FB3135-001-002. ZPMC Quality Control Personnel (QC) identified as Mr. Zhang yaxu 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-B-T-2221-B-L2C-S-2.

This QA observed ZPMC qualified welding personnel identified as 050977 perform Flux Cored Arc Weld (FCAW) Process on weld joint FB3119-001-024,025. ZPMC Quality Control Personnel (QC) identified as Mr. Zhang yaxu 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-B-T-2132-3.

This QA observed ZPMC qualified welding personnel identified as 206386 perform Flux Cored Arc Weld (FCAW) Process on weld joint FB3132-001-001,006. ZPMC Quality Control Personnel (QC) identified as Mr. Zhang yaxu 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-B-T-2132-3.

During in-process visual inspection of the Lift13E Floor beam identified as FB3121-001, This QA inspector witnessed that ZPMC Ultrasonic Testing (UT) technician Mr.xu wei appears to have rejected three (3) weld joints. The weld designation as identified on the material is FB3121-001-008, FB3121-001-006 and FB3121-001-005. See attached picture.

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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



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.

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| Inspected By: | Sukanthan,Dhanasingh | Quality Assurance Inspector |
| Reviewed By: | Hall,Steven | QA Reviewer |
