

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-016174**Date Inspected:** 05-Aug-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:** OBG Components**Summary of Items Observed:**

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

BAY#1

This QA Inspector observed the following work in progress

Fluxcored Arc Welding (FCAW):

Weld joint # 015 located on Traveler rail 20TR2 – 051. Welder is identified as 203710. ZPMC Quality Control (QC) Inspector is identified as Ai Wei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – B – L2c – S – 2.

Weld build-up by FluxCored Arc Welding (FCAW):

Weld build up being performed located on Traveler Rail # 20TR1 – 049 as per the Critical Weld Repair report # B-CWR1568. Welder is identified as 216872. ZPMC Quality Control (QC) Inspector is identified as Ai Wei. The welding variables recorded by QC appeared to comply with the WPS – 345 – FCAW – 1G (1F) – Repair – 1.

Heat Straightening:

Heat Straightening being performed on OBG Traveler Rail identified as 20TR3 – 038 by oxy-acetylene flame method to remove the distortion that occurred after welding. ZPMC Quality Control (QC) Inspector is identified as Ai Wei present at the location. This activity appeared to comply with the Heat Straightening Report # HSR (B) –

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363. (See attached photo)

BAY#2

This QA Inspector observed the following work in progress

Fluxcored Arc Welding (FCAW):

Weld joint # 08 located on SA3180- 001. Welder is identified as 045209. ZPMC Quality Control (QC) Inspector is identified as Zhong Yong Gang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

Submerged Arc Welding (SAW):

Weld joint # 06 located on Floor Beam FB3329- 001. Welder is identified as 045265. ZPMC Quality Control (QC) Inspector is identified as Zhong Yong Gang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2221 – B – L2c – S – 2. (See attached photo)

BAY#3

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 006336

Magnetic Particle Testing (MT)

This QA inspector performed MT of the area previously tested and accepted by ZPMC Quality Control personnel.

This QA Inspector generated an MT report for this date. The member is identified as Tower Component. The weld designation reviewed as follows:

EB3021 – 002 – 1; 3; 4

EB3021 – 001 – 1; 3; 4

EB3016 – 001 – 1; 3; 4

EB3011 – 001 – 5; 7; 8

EB3017 – 002 – 5; 7; 8

EB3010 – 001 – 1; 3; 4

This QA Inspector observed the following work in progress

Fluxcored Arc Welding (FCAW):

Weld joint # 02 located on Floor Beam FB3263- 002. Welder is identified as 044815. ZPMC Quality Control (QC) Inspector is identified as Zhan Hai Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – B – U2 – F.

Submerged Arc Welding (SAW):

Weld joint # 03 located on Floor Beam FB3263- 002. Welder is identified as 062406. ZPMC Quality Control (QC) Inspector 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.

Weld joint # 16 located on Longitudinal Diaphragm LD3027- 001. Welder is identified as 055564. ZPMC

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Quality Control (QC) Inspector 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.

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



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 - 15000422372, who represents the Office of Structural Materials for your project.

Inspected By: Kumar,Sandeep

Quality Assurance Inspector

Reviewed By: Hall,Steven

QA Reviewer
