

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-007608**Date Inspected:** 21-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**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**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Larry Viars was present during the times noted above for observations relative to the work being performed.

Bay 2:

1AAE

This Caltrans QA inspector monitored activities related to internal stiffener replacement for Partial Joint Penetration (PJP) welds exceeding Welding Procedure Specification root gap tolerance on OBG segment 1AAE.

The following fill plate base metal excavation and repair areas were tested and accepted by ZPMC MT technicians were verified and accepted by QA.

A24- (Deck Plate Side)

A38- (Deck Plate Side)

Caltrans QA observed ZPMC welder, 200569 perform SMAW welding of A24 and A38 fill plate base metal repairs. ZPMC QC was identified as Chen Xi. Welding appeared to be in conformance with the applicable Welding Procedure Specification.

The following stiffener welds were tested and accepted by ZPMC MT technicians were verified and accepted by

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Caltrans QA.

SEG2E- 369, 327, SEG2C- 026 at location A35
SEG2E- 323, 365, SEG2C- 116 at location A31
SEG2E- 362, 320, 152, 242, SEG2C- 127, 150 at location A28
SEG2E- 362, 320, 151, 241, SEG2C- 136, 041 at location A27
SEG2E- 150, 240, SEG2C- 045 at location A26
SEG2E- 347, 305, 137, 227, SEG2D- 130, 044 at location A13

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

Summary of Conversations:

Only general conversation between QA and QC occurred this date.

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.

Inspected By:	Viars,Larry	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
