

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-008117**Date Inspected:** 04-Aug-2009**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:** Lv Li Qing**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 Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Tim McClendon was present during the time noted above for observations relative to the work being performed.

The QA Inspector randomly observed the following work in progress:

OBG Bay No. 14

Flux Cored Arc Welding (FCAW) of weld joint SEG 050A – SSD19 - PP 73, weld numbers 109 ~ 128 for OBG Segment 9AE. ZPMC welder identified as 051357 was welding in the 2F position. ZPMC QC is identified as Zhang Xian Ji was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-T-2132.

Flux Cored Arc Welding (FCAW) of weld joint SEG 050A – SSD19 - PP 73, weld numbers 71 ~ 106 for OBG Segment 9AE. ZPMC welder identified as 051356 was welding in the 3F position. ZPMC QC is identified as Zhang Xian Ji was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-T-2133.

Flux Cored Arc Welding (FCAW) of weld joint SEG 050A – SSD19 - PP 73, weld numbers 69 ~ 104 for OBG Segment 9AE. ZPMC welder identified as 044795 was welding in the 3F position. ZPMC QC is identified as Zhang Xian Ji was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-T-2133.

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The QA inspector observed ZPMC QC marked 10 areas for weld repair on Side Panel splice on 9CW SEG053 weld number 006, and 1 area for weld repair on Side Panel splice on 9CW SEG053 weld number 005.

The QA inspector observed ZPMC QC marked 8 areas for weld repair on Side Panel splice on 9CW SEG053A weld number 002, and 1 area for weld repair on Side Panel splice on 9CW SEG053A weld number 003.

The QA inspector observed ZPMC welder was welding a fillet weld where a Complete Joint Penetration (CJP) weld was needed, on CSD3 – PP76 weld number 063 and 064 corner assembly CA59 for SEG. 9BW, due to the root opening created was greater than 5mm. An Incident Report was written on this issue.

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

Summary of Conversations:

No relevant conversations spoken on 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 (15000422372), who represents the Office of Structural Materials for your project.

Inspected By:	McClendon, Timothy	Quality Assurance Inspector
Reviewed By:	Patterson, Rodney	QA Reviewer
