

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-009122**Date Inspected:** 10-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen fu you**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, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

BAY#14

FCAW welding of weld joint 1G-003 located on PCMK CA074 of 10BW welder is identified as 062708.ZPMC QC is identified as Mr. Li ming yang . The welding variables recorded by QC appeared to Comply with the WPS-B-T-2231-Tc-U4b-F.

FCAW welding of weld joint 2F-003 located on PCMK SSD16A-PP74 of 9BE welder is identified as 044795. ZPMC QC is identified as Mr. Wang Xu. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2132.

SMAW welding of weld joint 4G-009 located on PCMK SEG052A of 9BE welder is identified as 067656.ZPMC QC is identified as Mr. Wang xu. The welding variables recorded by QC appeared to Comply with the WPS-B-2214-Tc-U4bFCM-1.

FCAW welding of weld joint 2F-005 located on PCMK SSD20-PP77 of 9CE welder is identified as 044830. ZPMC QC is identified as Mr. Wang xu. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2132.

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC

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Quality Control personnel. This QA inspector generated an UT report for this date. The members are identified as Segment 9BW. The weld designations reviewed are as follows:

SEG051A-031.

BAY#11

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an UT report for this date. The members are identified as Tower strut part. The weld designations reviewed are as follows:

WD1-A6003-7-6 a/b.

WD1-A6003-7-5 a/b.

WD1-A6003-7-2 a/b.

WD1-A6003-7-4 a/b.

WD1-A6003-8-1 a/b.

WD1-A6003-8-3 a/b.

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an MT report for this date. The members are identified as Tower strut part. The weld designations reviewed are as follows:

WD1-A6003-7-6 a/b.

WD1-A6003-7-5 a/b.

WD1-A6003-7-2 a/b.

WD1-A6003-7-4 a/b.

WD1-A6003-8-1 a/b.

WD1-A6003-8-3 a/b.

This QA inspector performed VT of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an VT report for this date. The members are identified as Tower strut part. The weld designations reviewed are as follows:

WD1-A6003-7-6 a/b.

WD1-A6003-7-5 a/b.

WD1-A6003-7-2 a/b.

WD1-A6003-7-4 a/b.

WD1-A6003-8-1 a/b.

WD1-A6003-8-3 a/b.

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

Summary of Conversations:

No Relevant Conversation.

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 Jim Simonis - 134-7246-3441, who represents the Office of Structural Materials for your project.

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Inspected By:	Kumar, Chadra	Quality Assurance Inspector
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Reviewed By:	Clifford, William	QA Reviewer
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