

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-009567**Date Inspected:** 02-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**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 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 3G-017 located on PCMK DP150-001 of 9BW welder is identified as 045775.ZPMC QC is identified as Mr.Li ming yang. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2233-Tc-U4b-F.

SAW welding of weld joint 1G-007 located on PCMK SEG035* of 9CW welder is identified as 045265.ZPMC QC is identified as Mr.Li ming yang. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2221-B-L2c-S-2.

SMAW welding of weld joint 4F-030 located on PCMK SP769-001 of 9BW welder is identified as 066413.ZPMC QC is identified as Mr. Li ming yang. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2214-FCM-1.

FCAW welding of weld joint 3G-026 located on PCMK SEG059 of 10AW welder is identified as 066401.ZPMC QC is identified as Mr.Li ming yang. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2233-Tc-U4b-F.

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Fit up of weld joint 1G-007 located on PCMK SEG053* of dimension and ceramic backing checked with ZPMC QC Mr. Xu tao and variables recorded to Comply with the WPS-B-T-223(2)1T-2.

Witnessed Pre production stud welding and testing before Production welding of Corner assembly CA65 of 9DW with ZPMC QC Mr. tao to comply with AWS D1.5.

During random verification Ultrasonic Testing (UT) of the bottom to side plate weld identified as SEG057A-007 in OBG segment 9EW, Caltrans Quality Assurance (QA) Inspector discovered a total of (1) one, reject able indication that measured 20mm in length. This weld has been previously tested and accepted by ZPMC Quality Control (UT) Technicians. For further information, please see the incident report 04-012-F4_TL-15_B255_10-02-09_Seg_9EW_Rejectable_UT_Indication

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



Item	Description	WBS	Dwg No.	Status
1				

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.

Inspected By:	Kumar,Chadra	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
