

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-010156**Date Inspected:** 24-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:** Shen 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-010 located on PCMK SEG053A of 9CW welder is identified as 066673.ZPMC QC is identified as Mr. Li ming yang. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2231T-2.

SMAW welding of weld joint 4G-024 located on PCMK SEG059A of 10AW welder is identified as 051348. ZPMC QC is identified as Mr. Li ming yang. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2214-Tc-U4b-FCM-1.

FCAW welding of weld joint 3G-055* located on PCMK SEG055 of 9DW 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-B-U2-F.

SMAW welding of weld joint 4G-004 located on PCMK SP779-001 of 10CW welder is identified as 066361. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2214-B-U2-FCM-1.

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SMAW welding of weld joint 4F-039 located on PCMK SP779-001 of 10CW welder is identified as 205718. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2114-FCM-1.

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 OBG Segment 11AE. The weld designations reviewed are as follows:
SEG066A-007.

This Quality Assurance Inspector (QA) observed that the contractor appears to have produced stress concentrations during fit-up on assembly 10AW – PP88 by applying total 53 tons of weights in order to achieve the required root opening between Deck Panel Diaphragms and Floor Beam.

For further information, please see the Incident report.

0719-04-0120F4_TL-15_B247_10-24-09_10AW_Stress_Concentration_DP_to_[FB]

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

Summary of Conversations:

As per 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
