

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-010166**Date Inspected:** 09-Nov-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 3F-146 located on PCMK SSD10A-PP80 of 9DW welder is identified as 066401. ZPMC QC is identified as Mr. Wang xu. The welding variables recorded by QC appeared to Comply with the WPS-B-T-4133.

SMAW welding of weld joint 4G-131 located on PCMK SSD13-PP89 of 10BW welder is identified as 067610. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2214-Tc-U4b-FCM.

FCAW welding of weld joint 3G-012 located on PCMK SEG063B of 10CW welder is identified as 047866. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2233-Tc-U4b-FCM.

FCAW welding of weld joint 1G-002 located on PCMK SSD11-PP81 of 9DW welder is identified as 202122. ZPMC QC is identified as Mr. Wang xu. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2231-B-U2-F.

During in process inspection it is observed that fit up of Deck panel to Corner assembly in segment 10CW, the

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clamp used for fit up is tack welded over the U rib PJP weld in lot of locations. The weld no is identified as SEG063*-008. This is informed to ABF QA Mr.Peter Saha. ZPMC QC Mr. Xu tao to do MT and avoid in future.

Deck panel diaphragm fillet welding ZPMC has changed the welding sequence they are doing Intermittent weld in full length of the joint. This discussed with ABF QA Mr.Peter saha, he told that we have procedure , but not in his hand.

segment 10BW

SSD13A-PP90-04/05.

SSD13A-PP89-04/05.

Segment 10CW

SSD10-PP92-04/05.

SSD11-PP93-03/04.

SSD12-PP94-04/05.

BAY#11

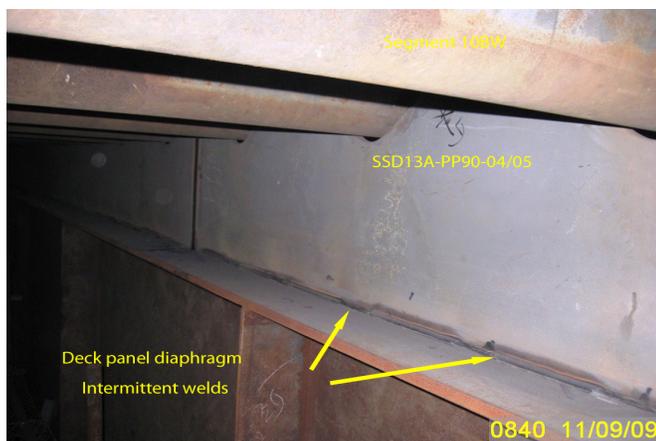
This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an UT report for this date. The members are identified as Tower strut. The weld designations reviewed are as follows:

SD1-STSA3-1-109m-1-3,6 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. The weld designations reviewed are as follows:

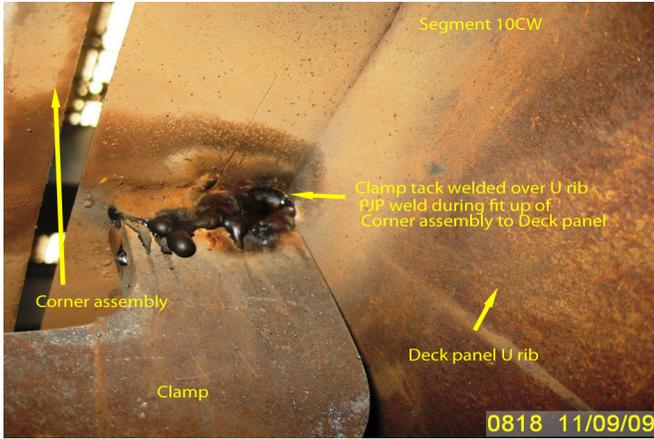
WD1-A6003-2.

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



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Item	Description	WBS	Dwg No.	Status
1				

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
