

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-010323**Date Inspected:** 12-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 3G-013 located on PCMK SEG61* of 10BW welder is identified as 045175.ZPMC QC is identified as Mr.Wang xu. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2233-B-U2-F.

SMAW welding of weld joint 4G-038 located on PCMK SEG063* of 10CW welder is identified as 066326.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-1.

FCAW welding of weld joint 2F-021 located on PCMK SSD29-PP82.5 of 9DW welder is identified as 215676. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2232.

FCAW welding of weld joint 1G-010 located on PCMK SEG057* of 9EW welder is identified as 045215.ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC appeared to Comply with the WPS-B-T-223(2)1T-2.

During in-process visual inspection of the fabrication of Segment Lift 9 west, Caltrans Quality Assurance

WELDING INSPECTION REPORT

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Inspector found that a Portion of Corner assembly components CA is identified as X37 damaged because of poor handling and storage of materials CA067, CA068, and CA070.

For more information, please see the Incident report

04-0120F4_TL-15_B247_11-12-09_Damaged CA-X37 of Lift 9 west line.

BAY#13

SMAW welding of weld joint 4G-083 located on PCMK SP742A-001 of 11BW welder is identified as 049339. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2214-B-U2-FCM-1.

FCAW welding of weld joint 2F-021 located on PCMK SEG069B of 11CW welder is identified as 214945.ZPMC QC is identified as Mr.Guo xing hui. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2132.

BAY#19

SAW welding of weld joint 1G-003 located on PCMK BP025-013 welder is identified as 062816.ZPMC QC is identified as Mr. Zhu zhong hai. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2221-B-L2C-S-2.

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.

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