

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-011602**Date Inspected:** 16-Dec-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:** Li Yan Hua**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 COMPONENT**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance(QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

In process Inspection

Outside Yard

This QA Inspector observed the following work in progress:

SMAW in the 4G position for the OBG Segment 9AW ,Side plate to Bottom plate , weld No. SEG-049A-007. The welder is identified as #067183. ZPMC QC is identified as Mr. Li Ping. The welding variables recorded by QC appear to comply with WPS-B-P-2214-Tc-U4b-FCM-1 .

SMAW in the 4G position for the OBG Segment 9BW ,Side plate to Bottom plate , weld No. SEG-051A-031. The welder is identified as #068097. ZPMC QC is identified as Mr. Li Ping. The welding variables recorded by QC appear to comply with WPS-B-P-2214-Tc-U4b-FCM-1 .

FCAW in the 2G position for the OBG Segment, Deck Plate Diaphragm to Stiffeners , weld No. SSD13-PP59-004. The welders are identified as #048693, #048432 and #204730. ZPMC QC is identified as Mr. Xu Tao. The welding variables recorded by QC appear to comply with WPS-345-FCAW-2G(2F)-FCM-Repair-1 .

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SAW in the 1G position for the OBG segment 12CE, Bottom plate BP3010A to Bottom plate BP3007A , weld No. SEG-3003A-007. The welder is identified as #044771. ZPMC QC is identified as Mr.Zhong Gao Hui. The welding variables recorded by QC appear to comply with WPS-B-T-2221-B-L2c-S-2 .

During a random visual inspection of Shielded Metal Arc Welding (SMAW 4G) on Segment 9BW, the Caltrans Quality Assurance (QA) Inspector observed ZPMC personnel in-process of welding a complete joint penetration (CJP) weld without achieving the required preheat temperature of 60 degree C as per approved welding procedure specification (WPS).

This QA Inspector generated an incident report for this date.

During a random in-process visual inspection at Segment 9AW of Side Panel (SP) temporary attachment removal areas, the Caltrans Quality Assurance (QA) Inspector observed ZPMC personnel performing un-approved excavations and Shielded Metal Arc Welding (SMAW) for approximately fifty (50) base metal repairs on SP's without prior approval of the Engineer.

This QA Inspector generated an incident report for this date.

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

Summary of Conversations:

No relevant conversations

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 Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Bera,Subhasis	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
