

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:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019875**Date Inspected:** 17-Dec-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**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:** See Below**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**Summary of Items Observed:**

Bay 19

This Caltrans QA inspector observed Flux Cored Arc Welding (FCAW) in progress. Welder is identified as #062738, welding weld repair in the 1G position using welding procedure specification WPS-345-FCAW-1G-FCM-Repair. The weld is identified as BP025-014-003. However, during random visual inspection of bottom plate splice weld repair. The welder was observed performing weld repairs without achieving the required preheat temperature of 65 degree Celsius as per approved welding procedure specification (WPS). ZPMC QC inspectors are identified as Mr. Zhou Cheng and certified welding inspector (CWI), Mr. Zhu Zheng Hai. This QA inspector generated a Quality Assurance-Incident Report for the welding violation. See Quality Assurance-Incident Report, dated 12-17-09 for additional information.

OBG Segment Name: 8AW / North of Blast Shop

This Caltrans 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 member is identified as OBG Components. The weld designations reviewed are as follows:

-(SSD12A-PP64-232, -234, -236, -252, -254, -256, -71 and -15)

-(SSD12-PP64-222, -224, -226, -252, -254, -256, -62, -64, -123 and -125)

-(SSD22-PP63.5-63, -64, 69, -70, -71 and -72)

-(SEG043C-018 and -012)

-(SEG043B-040 and -012)

See Caltrans Magnetic Particle Test Report (TL6028), date 12-17-09 for additional information.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

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

Summary of Conversations:

“As noted within the contents of this report.”

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 , who represents the Office of Structural Materials for your project.

Inspected By:	Hasler, Mike	Quality Assurance Inspector
Reviewed By:	Riley, Ken	QA Reviewer
