

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-011887**Date Inspected:** 04-Feb-2010**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:	N/A	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.

Ultrasonic Testing (UT)

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as Segment 9AE Butt and "T" joint.

The Weld Designations are as follows

SEG050C-012,002,003,004,017,018
CSD7-PP72-041,021,023

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as Tower Strut "T" joint.

The Weld Designation is as follows

ED1-STSA3-2-109M-2-24 A/B

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During the Quality Assurance (QA) random in-process visual inspection of Segment 9AW, this QA inspector discovered that the ZPMC welding personal is excavating on weld repair area by using Carbon Arc Gouging at Counter weight side corner weld joint joining between Deck plate to Edge plate. The weld joint is identified as CA055-004. The weld repair report is B-WR1199.

This QA Inspector observed ZPMC personnel performing Heat straightening on traveler Rail at bay#14. The Traveler rail is identified as 11TR1-002.

This QA Inspector observed ABF personnel performing Ultrasonic Testing (UT) on the Edge Plate to Deck Plate corner CJP weld at Segment 9BW cross beam side .

After Blast Inspection

This Quality Assurance (QA) Inspector performed random visual inspection of OBG segment 7EW internal side panel, bottom panel, floor beam and longitudinal diaphragms surfaces from the panel point 59 to 60 after grit blasting. Areas that marked for repair were recorded for future repair. Areas requiring additional grinding were marked by QA and repaired by ZPMC personnel.

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



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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
