

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-012194**Date Inspected:** 08-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:** Chen Xi/Liu Fa Wen**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, Hiranch Patel, was present during the times noted above for observations relative to the work being performed.

Bay#5

During random visual inspection, this QA inspector observed deep grinding mark on traveler's rail TR1B-PP029. According to approved drawing the distance between the center of bolt hole and TR bracket is 30 mm and according to approved weld detail WD270M, the size of reinforcing fillet weld is 4mm. After welding ZPMC QC-CWI Inspector found the reinforcing fillet is more than 4 mm and that creates an obstacle in bolt. ZPMC personal grind excessive fillet and make it proper size and during this grinding ZPMC personal grind deep fillet weld less than 4mm. ZPMC personal need to repair this deep grinding and make fillet weld to 4mm size according to approved weld detail drawing WD270M.

For further information, please find attached pictures.

Bay#1

FCAW welding of weld joint 21TR4-003-003 located on Traveler Rail 21TR4. Welder is identified as 219188 (1G). ZPMC QC is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-Tc-U5-F.

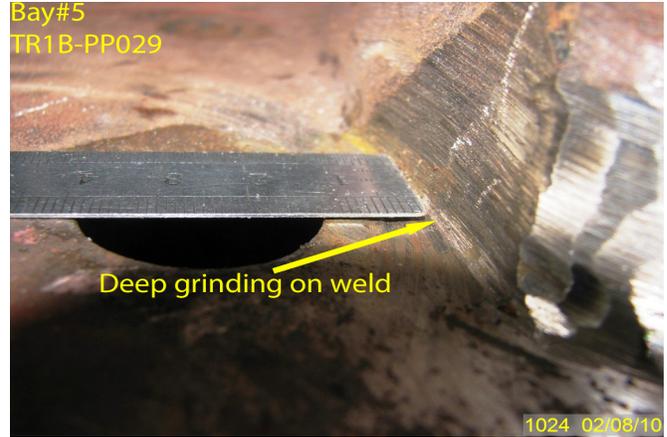
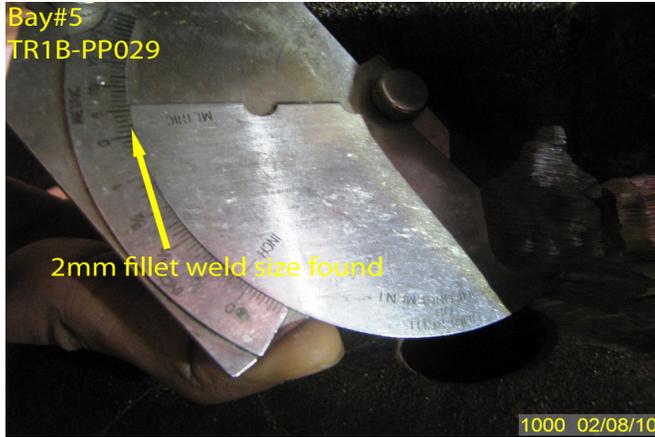
FCAW welding of weld joint 21TR2-001-003 located on Traveler Rail 21TR2. Welder is identified as 219188 (1G). ZPMC QC is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Applicable WPS-B-T-2231-Tc-U5-F.

Unless otherwise noted, all 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:	Patel,Hiranch	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
