DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-012217
Date Inspected: 23-Feb-2010

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 645
OSM Departure Time: 1845
Location: Shanghai, China

CWI Name:	Chen Xi, Li Jia.	**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: Orthotropic Box Girder(OBG)

Summary of Items Observed:

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

This QA Inspector observed the following work in progress:

Subassembly, Bay 06, Traveler rail.

During random Inprocess Visual inspection this QA inspector observed ZPMC personal performing Heat straightening on the traveler rail 11TR3-010. ZPMC have Heat straightening Report (HSR)# HSR1(B)-8087. The attached photographs provide additional detail.

Subassembly, Bay 03, Traveler rail.

FCAW welding of weld joint 20TR2-016-013; located on Subassembly, Bay 03. Welder is identified as 044824; ZPMC Quality Control Inspector (QC) is identified as Chen Xi. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2231-TC-U5-F. The attached photographs provide additional detail.

Subassembly, Bay 01, Traveler rail.

FCAW welding of weld joint 20TR1-024-003, 005, 007; located on Subassembly, Bay 01. Welder is identified as 219188; ZPMC Quality Control Inspector (QC) is identified as Chen Xi. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2231-TC-U5-F.

Subassembly, Bay 05, Traveler rail.

FCAW Repair welding (build up about 15-27mm)of weld joint 10TR3-033 & 11TR3-015 (CWR # B-CWR1102); located on Subassembly, Bay 05. Welders are identified as 217185, 215248; ZPMC Quality Control Inspector (QC) is identified as Li Jia. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-345-FCAW-1G(1F)-REPAIR-1. The attached photographs provide additional detail.

Subassembly, Bay 05, Traveler rail.

SMAW Repair welding of weld joint 10TR4-002-014(WWR # B-WR10136, Y LOCATION = 6060 to 6200mm); located on Subassembly, Bay 05. Welders are identified as 215248; ZPMC Quality Control Inspector (QC) is identified as Li Jia. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-345-SMAW-2G(2F)-REPAIR.

Subassembly, Bay 03, Traveler rail.

FCAW welding of weld joint 20TR2-010-009; located on Subassembly, Bay 03. Welder is identified as 044774; ZPMC Quality Control Inspector (QC) is identified as Chen Xi. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2231-TC-U5-F.

Subassembly, Bay 03, Traveler rail.

FCAW welding of weld joint 20TR2-013-011; located on Subassembly, Bay 03. Welder is identified as 044824; ZPMC Quality Control Inspector (QC) is identified as Chen Xi. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2231-TC-U5-F.

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

WELDING INSPECTION REPORT

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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 Serge Sinevod, 13482570045, who represents the Office of Structural Materials for your project.

Inspected By:	Juvekar,Amit	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer