

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-012225**Date Inspected:** 12-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:** Li Yang.**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:

Segment# 7BW + 7CW-PP53

SMAW welding of weld joint CA035-002, 006; located on Segment# 7BW + 7CW-PP53. Welder is identified as 069683, 068917; ZPMC Quality Control Inspector (QC) is identified as Li Yang. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2214-TC-U4b-FCM-1.

Segment# 7BW + 7CW- PP53

FCAW welding of weld joint SP430-001-034; located on Segment# 7BW + 7CW- PP53. Welder is identified as 066746; ZPMC Quality Control Inspector (QC) is identified as Li Yang. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2233-B-U2-F.

Segment# CB4 Hold back Welds.

During random inprocess inspection this QA Inspector observed AB/F performing Magnetic Particle Testing (MT) on Cross Beam 4, I-ribs hold back welds. The attached photographs provide additional detail.

Segment# 7AW Counterweight connection Plate.

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SMAW welding of weld joint OBW7N-001; located on Segment# 7AW. Welder is identified as 066179; ZPMC Quality Control Inspector (QC) is identified as Li Yang. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2214-TC-U4B-FCM-1.

Segment# 6CW Counterweight connection Plate.

SMAW welding of weld joint OBW6-011; located on Segment# 6CW. Welder is identified as 066361; ZPMC Quality Control Inspector (QC) is identified as Li Yang. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2214-TC-U4B-FCM-1.

Segment# 6AE- PP37.

During random inprocess inspection this QA Inspector observed ZPMC Personnel Performing Heat-straightening on Traveler Rail Bracket Attached to bottom Plate on 6AE Panel Point 37 Bike path side. The attached photographs provide additional detail.

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 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