

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-012392**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:** As identified 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:**

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

West of Blast Bay 1-

This QA Inspector observed the following work in progress: Shielded Metal Arc Welding (SMAW) of OBG Segment 8CE side panel WT stiffener Complete Joint Penetration (CJP) weld, SP541-001-018. ZPMC welder was identified as 043661. ZPMC CWI was identified as Zhu Zhong Hai. The WT stiffener weld was removed and rewelded to correct misalignment. The welding appeared to be in conformance with welding procedure specification, WPS-345-SMAW-3G(3F)-Repair and Weld Repair Report B-WR10632

North of Bay 19-

Caltrans QA inspector observed: ZPMC personnel performing air carbon arc gouging on OBG Segment 9AW corner assembly weld CA056-044 to remove indications found with Ultrasonic Testing. ZPMC personnel appear to be performing repair work as per Critical Weld Repair Report # B-CWR 1199.

ZPMC QC performing MT on Segment 9BW FL3 manway exterior.

Blast Bay 1-

WELDING INSPECTION REPORT

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Caltrans Quality Assurance (QA) Inspectors performed random visual inspection of OBG segment 7EW Lower section between the east side of panel point 59 and panel point 60.5. Areas requiring light grinding were marked for ZPMC personnel. The location of areas requiring weld repair were recorded and placed on on the punchlist for future repair.

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



Summary of Conversations:

Only general conversation between QA and QC occurred this date.

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:	Viars,Larry	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
