

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-020062**Date Inspected:** 12-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Liu Hua Jie, Lu Li Qing, Geng W			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:

Assembly, Bay 14, Traveler rail.

During the Quality Assurance (QA) random in-process visual inspection of OBG traveler rail Heat Straightening, this Caltrans Quality Assurance Inspector (QA) observed the following:

- Temperature of the heat straightened traveler rail was above 1100 Degree Celsius.
- Metal which being heat straightened observed getting "cherry red" in color.
- "Y" location of the spot identified was 3890mm as shown in Photograph.
- Per ZPMC heat straightening report (HSR) maximum temperature limit is 650 Degree Celsius.
- The Traveler Rail is identified as 10TR3-022.
- Please refer to video of on the sever "SharedDocs on Team China Server (192.168.0.2)".

The attached photographs provide additional detail.

Assembly, Bay 14, 12AE, Corner assembly.

During the Quality Assurance (QA) random in-process visual inspection, this QA inspector ZPMC Personnel performing fit up of Side plate-SP3016A of Corner assembly CA3001A. The attached photographs provide additional detail.

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Assembly, Bay 14, 11EE, SEG074.

SMAW welding of weld joint SEG074A-010; located on assembly, Bay 14, 11EE. Welder is identified as 20913, 049339; ZPMC Quality Control Inspector (QC) is identified as Lu Li Qing. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-P-2214-B-U2-FCM-1.

Assembly, Bay 14, 11DE, SEG072.

SMAW welding of weld joint SSSD17A-PP105-002; located on assembly, Bay 14, 11DE. Welder is identified as 068764; ZPMC Quality Control Inspector (QC) is identified as Lu Li Qing. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-P-2214-B-U2-FCM-1.

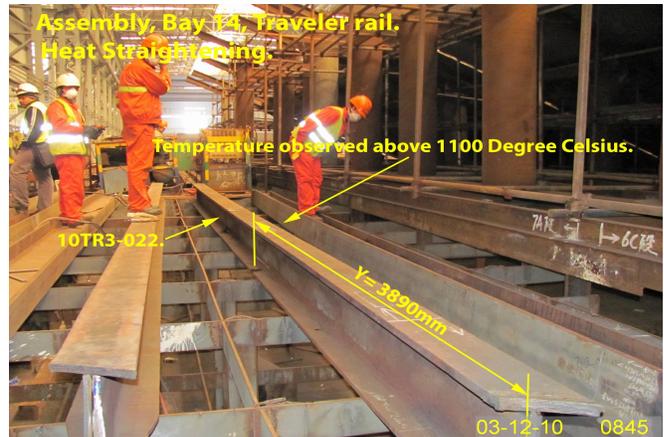
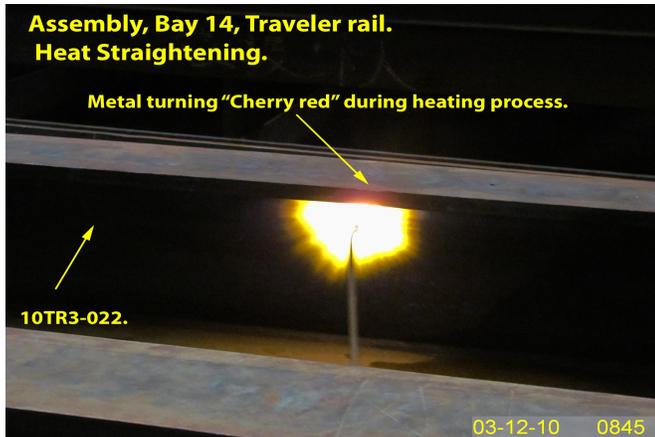
Assembly, Bay 14, 11DE, SEG072.

SMAW welding of weld joint SEG072A-032; located on assembly, Bay 14, 11DE. Welder is identified as 200113, 049339; ZPMC Quality Control Inspector (QC) is identified as Lu Li Qing. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-P-2214-B-U2-FCM-1.

Training for Phased Array Ultrasonic Testing.

This QA inspector attended Training for Phased Array Ultrasonic Testing (PAUT) from 1600Hrs. to 1900Hrs.

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, 1500.042.2372, who represents the Office of Structural Materials for your project.

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