

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-013719**Date Inspected:** 16-Apr-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: Zhou Zhonhai
Inspected CWI report: Yes No N/A
Electrode to specification: Yes No N/A
Qualified Welders: Yes No N/A
Approved Drawings: Yes No N/A

CWI Present: Yes No
Rod Oven in Use: Yes No N/A
Weld Procedures Followed: Yes No N/A
Verified Joint Fit-up: 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, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

BAY#14

SMAW welding of weld joint 4G-022 located on PCMK SEG3004AL of segment 12AW welder is identified as 066361.ZPMC QC is identified as Mr.Tao wei . The welding variables recorded by QC appeared to Comply with the WPS-B-P-2214-Tc-U4b-FCM-1.

FCAW welding of weld joint 3G-009 located on PCMK SEG071* welder is identified as 202122.ZPMC QC is identified as Mr. Tao wei . The welding variables recorded by QC appeared to Comply with the WPS-B-T-2233-B-U2-F.

SMAW welding of weld joint 3G-038 located on PCMK SEG072D of segment 11DE welder is identified as 216086.ZPMC QC is identified as Mr.Zhong guo hui . The welding variables recorded by QC appeared to Comply with the WPS-B-P-2213-Tc-U4b-FCM.

SMAW welding of weld joint 3G-136 located on PCMK SEG072D of segment 11DE welder is identified as 215553.ZPMC QC is identified as Mr.Zhong guo hui . The welding variables recorded by QC appeared to Comply with the WPS-B-P-4213-Tc-U4b-2.

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The following weld joint after fit-up root gap measured 7mm of SEG3005M-055/056 of segment 12BW. This is informed to ZPMC QC Mr. Li ming yang. He agreed and get approval from engineer before welding.

During in process inspection of weld joint fit-up of Deck panel diaphragm to floor beam flange of segment 12BE the weld is identified as SEG3002J-009/010 the fillet weld root gap found 7mm in three locations at PP113. This one checked with ZPMC CWI Mr.Geng wei. He recorded and will get approval from engineer before welding.

BLAST SHOP 1

Caltrans Quality Assurance (QA) Inspectors performed random visual inspection of Segment 9CE internal Bottom panel , Side panel , Floor beam connecting to Longitudinal diaphragm from panel point PP77 to PP79 after grit blasting. Areas that marked for repair were recorded for future repair. Areas requiring additional grinding were marked by QA and repaired by ZPMC personnel.

SP625-001-022 @ PP77.5 , 3mm Porosity found and taped for future repair.

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

Summary of Conversations:

No relevant Conversation.

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-15--0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Chadra	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
