

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-014879**Date Inspected:** 26-Apr-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:	Sun Bo.			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, 12AE, Corner Assembly, Deck plate to Edge plate.

FCAW Repair welding of weld joint CA6051-004 (CWR # B-CWR1431); located on assembly, Bay 14, 12AE. Welder is identified as 200113; 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-345-SMAW-2G(2F)-FCM-REPAIR-1.

Assembly, Bay 14, 10BW, X37 Stiffener.

SMAW welding of weld joint CA073-031, 032; located on assembly, Bay 14, 11BW. Welder is identified as 047864; ZPMC Quality Control Inspector (QC) is identified as Xu Tao. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-P-4113-2.

Assembly, Bay 14, 11DE, SEG072, Lifting Lug.

FCAW welding of weld joint SSD16-PP104-223; located on assembly, Bay 14, 11DE. Welder is identified as 066258; 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-T-2212-TC-U4B-FCM-1.

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Assembly, Bay 14, 09DE.

During the Quality Assurance (QA) random in-process visual inspection, this QA inspector observed ZPMC Personnel performing Ultrasonic Testing (UT) of Cross Beam Corner Diaphragm identified as SSD27-PP81-191. The attached photographs provide additional detail.

Assembly, Bay 14, 12CW, FL2-1 TO Longitudinal Diaphragm.

SMAW welding of weld joint SEG3006H-008; located on assembly, Bay 14, 12CW. Welder is identified as 066326; ZPMC Quality Control Inspector (QC) is identified as Xu Tao. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-P-2114-FCM-1.

This QA Inspector carried out NDE on following

Assembly, Bay 14, 12AW.

This QA inspector performs Random Ultrasonic Testing (UT) of approximately 10% area previously tested and accepted by ZPMC Quality Control personnel(Notification # 005605). This QA Inspector generated an UT report(TL-6027) for this date. The members are identified as

- 1) DP3043-001-331, 334.
- 2) DP3045-001-331, 334.

Assembly, Bay 14, 12AE.

This QA inspector performs Random Ultrasonic Testing (UT) of approximately 10% area previously tested and accepted by ZPMC Quality Control personnel(Notification # 005606). This QA Inspector generated an UT report(TL-6027) for this date. The members are identified as DP3007-001-031.

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



Summary of Conversations:

No relevant conversations.

Comments

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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:	Hall,Steven	QA Reviewer
