

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-020046**Date Inspected:** 02-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:	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, 12CW, PP115.5, Deck Panel Diaphragm.

FCAW welding of weld joint DP3070-001-106, 107, 116, 117, 126, 127; located on assembly, Bay 14, 12CW. Welder is identified as 058245; ZPMC Quality Control Inspector (QC) is identified as Liu Hua Jie. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: 1) WPS-B-T-2133 2) WPS-B-T-2132.

Assembly, Bay 14, 12CW, Edge Beam.

FCAW welding of weld joint EB3006A-001, 002; located on assembly, Bay 14, 12CW. Welder is identified as 045175; ZPMC Quality Control Inspector (QC) is identified as Liu Hua Jie. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2132.

Assembly, Bay 14, 12CE, CA3005.

During Random Visual in process Inspection, this QA inspector observed fit-up of Corner assembly Side panel SP3024A of Corner Assembly CA3005. The attached photographs provide additional detail.

Assembly, Bay 14, 12AE.

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FCAW welding of weld joint SEG3001P-096, 135; located on assembly, Bay 14, 12AE. Welder is identified as 058551; ZPMC Quality Control Inspector (QC) is identified as Geng Wei. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2133.

Assembly, Bay 14, 12AW, PP109, LD Stiffener to FL1.

SMAW welding of weld joint SEG3004W-010; located on assembly, Bay 14, 12AE. Welder is identified as 200113; ZPMC Quality Control Inspector (QC) is identified as Liu Hua Jie. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-P-2214-TC-U4B-FCM-1.

Assembly, Bay 13, Traveler rail.

FCAW Repair welding of weld joint 20TR2-012-015(WRR # B-WR11065); located on assembly, Bay 13. Welders are identified as 044830; ZPMC Quality Control Inspector (QC) is identified as Chen Xi. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-345-FCAW-1G(1F)-REPAIR-1.

This QA Inspector carried out NDE on following

Assembly, Bay 14, Traveler rail.

This QA inspector performs Random Ultrasonic Testing (UT) of approximately 10% area previously tested and accepted by ZPMC Quality Control personnel(Notification # 005464), FOR GREEN TAG. This QA Inspector generated an UT report(TL-6027) for this date. The members are identified as

- 1) 10TR3-011-007, 013.
- 2) 11TR3-014-007, 013.
- 3) 10TR3-037-007, 013.
- 4) 10TR3-009-007, 013.
- 5) 11TR2-007-007, 013.
- 6) 11TR1-005-007, 013.
- 7) 11TR1-002-007, 013.
- 8) 10TR3-024-007, 013.
- 9) 11TR2-005-007, 013.
- 10)11TR1-007-007, 013.
- 11)10TR3-020-007, 013.
- 12)11TR1-009-007, 013.
- 13)11TR2-008-007, 013.

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
