

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-015060**Date Inspected:** 20-Jun-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:****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 day CALTRANS OSM Quality Assurance (QA) Inspector Amit Juvekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

Subassembly, Bay 09, Gantry# 2, 13CW, Deck Plate to U-rib.

GMAW (Root-pass) welding of Partial Penetration weld joints DP3149-001-001/003/138/173/176/178, 002/004/139/174/177/179, 005/140/180, 006/141/181; located on Bay 09, Gantry# 2. Welder is identified as 201788, 059416, 059421, 059418; ZPMC Quality Control Inspector (QC) is identified as Chen Shi Gang. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2342-U1(U-rib)-5.

Subassembly, Bay 09, Gantry# 2, 13BE, Deck Plate to U-rib.

GMAW welding of Partial Penetration weld joints DP3088-001-171/173/001/003, 172/174/002/004, 175/177/005/007, 176/178/006/008, 179/009, 180/010; located on Bay 09, Gantry# 2. Welder is identified as 059418, 059421, 059416, 201788, 203805, 0593778; ZPMC Quality Control Inspector (QC) is identified as Chen Shi Gang. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2342-U1(U-rib)-5.

Subassembly, Bay 09, Gantry# 2, 13CW, Deck Plate to U-rib.

SAW welding of Partial Penetration weld joints DP3149-001-001/003/138/173/176/178,

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002/004/139/174/177/179, 005/140/180, 006/141/181; located on Bay 09, Gantry# 2. Welder is identified as 201788, 059416, 059421, 059418; ZPMC Quality Control Inspector (QC) is identified as Chen Shi Gang. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2342-U1(U-rib)-5.

Subassembly, Bay 09, Gantry# 2, 13BE, Deck Plate to U-rib.

SAW welding of Partial Penetration weld joints DP3088-001-171/173/001/003, 172/174/002/004, 175/177/005/007, 176/178/006/008, 179/009, 180/010; located on Bay 09, Gantry# 2. Welder is identified as 059418, 059421, 059416, 201788, 203805, 0593778; ZPMC Quality Control Inspector (QC) is identified as Chen Shi Gang. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2342-U1(U-rib)-5.

Subassembly, Bay 09, 13CE, Continuity Stiffener inside U-Rib.

FCAW welding of weld complete penetration joint DP3101-001-259, 260, 269, 270, 257, 258; located on subassembly, Bay 09, 13CE. Welder is identified as 062259, 201840; ZPMC Quality Control Inspector (QC) is identified as Chen Shigang. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2233-TC-U4B-F.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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:	Carreon,Albert	QA Reviewer
