

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-005678**Date Inspected:** 27-Feb-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Wei Wei**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:** OBG**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector Larry Viars was present during the times noted above for observations relative to the work being performed.

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This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as Side Plate SP166-001, Edge Plates EP118, EP163-001, EP114-001. The weld identification numbers are as follows, SP166-001-013 through 024, EP118-001 welds 001 through 004, EP163-001 welds 001 through 004 and EP114-001 welds 001 through 004.

Bay 5-

This QA inspector performed Ultrasonic Testing (UT) of approximately 100% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as a Floor beam weld. The weld identification number are as follows, FB204-002-015. Caltrans QA found a + 9 class "A" reject, 9 mm deep and 10 mm in length on the 18 mm thick T Joint. ZPMC QC Lei Tao was informed of the the UT findings. Mr Lei stated that ZPMC UT personnel reinspect the weld.

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WELDING INSPECTION REPORT

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This QA Inspector observed the following work in progress: FCAW welding of weld joint 029 located on PCMK FB210-004. ZPMC welder is identified as 044790. ZPMC QC is identified as Liu Wei Wei. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2333-TC-U4b-f.

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

Summary of Conversations:

As identified within the contents of this report.

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 150 0042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Viars,Larry	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
