

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-005891**Date Inspected:** 28-Feb-2009**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:** Zhao Chen Sun**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 Component**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the time noted above for observations relative to the work being performed.

BAY#6

This QA inspector performed 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 member is identified as Edge & Side Plates .The weld designations reviewed as follows:

EP169-001-001,003 Green Tag no-004747.

EP116-001-001,004 Green Tag no- 004750.

SP352-001-013,018,019,024,Green Tag no-004521.

SP139-001-13,15,19,21 Green Tag no-004748.

SP379-001-13,14,18,24 Green Tag no-004746.

ESD1-DPSA3-16B/B-1,7,4,5,9,10,13,14. ZPMC Not completed.

ESD1-DPSA3-16B/B-21to 26. ZPMC Not completed.

ESD1-DPSA3-16B/B-2,3,8,6,11,12,15,16. ZPMC Not completed.

ESD1-DPSA3-12B/B-1,4,5,7,9,10,13,14. ZPMC Not completed.

ESD1-DPSA3-12B/B-21 to 26. ZPMC Not completed.

ESD1-DPSA3-12B/B-3,2,6,8,11,12,15,16. ZPMC Not completed.

@On going SAW Welding of Weld Joint 1G- 7B Located on NSD1-DPSA3-1 A/B Welder no identified as 053748 and The welding variables recorded by QC ZMPC to comply with the WPS-B-T-3221-B-U3C-S-1.

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@On going FCAW Welding of Weld Joint 3G- 6-6B,6-7B Located on NSD1-DPSA3 Welder no indentified as 053609 and The welding variables recorded by QC ZMPC to comply with the WPS-B-T-2233-B-U3-F.

Fit-Up Inspection of following weld joints Carried out

WSD1-DPSA3-15- 01A(B),03A(B),06A(B).

Offset-0 to 0.5 mm

Root Gap-0.5 mm max.

BAY#07

@On going FCAW(semi-auto) Welding of Weld Joint 2F- 003,004 Located on EP135-001 Welder no indentified as 054459 and The welding variables recorded by QC ZMPC to comply with the WPS-T-2132-3.

BAY#05

@On going SAW Welding of Weld Joint 1G- 003 Located on CB201B-004-003 Welder no indentified as 0217185 and The welding variables recorded by QC ZMPC to comply with the WPS-B-T-2231-B-U2-F.

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

Inspected By:	Kumar,Chadra	Quality Assurance Inspector
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Reviewed By:	Clifford,William	QA Reviewer
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