

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-007212**Date Inspected:** 08-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Zhi jiang/SunWei**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 Components**Summary of Items Observed:**

On this date Caltrans Quality Assurance (QA) Inspector, Lonnie Whitehead, was present during the times noted above for observations relative to the work being performed.

BAY#9

This QA Inspector observed the following work in progress:

S.M.A.W. welding of the open root Closed Rib panel repair procedure for root openings up to 12mm using WPS-345-SMAW-2G-repair-1. Verified 11.5mm root opening and minimum pre-heat of 60 degrees Celsius. Welding was performed by Duan Yangang-number 066422. Inter-pass cleaning was observed and noted. After pass number 9, the opening had been closed off. The area was then ground and 100% Magnetic Particle (MT) testing was performed by Z.P.M.C. QC personnel with no relevant discontinuities discovered. A total of 17 weld bead passes were required to finish the repair area. The weld was then ground smooth and tested using Phased Array Ultrasonic Testing (PAUT) with no rejectable discontinuities noted.

This QA inspector was then directed to lay out cut areas for the macro-etch specimens. See photographs. A TL 6032 will be generated for this.

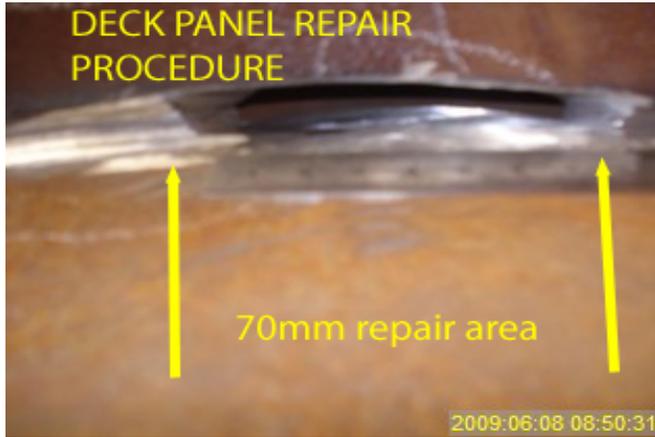
WELD LAB

This QA inspector was present to witness the welding of the A709-50-2 steel to 2G230-450 casting for Procedure Qualification Record (PQR) HP2009270. A TL6032 was generated for this date.

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Unless otherwise noted, all work observed on this date appeared to generally comply with 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 (15000422372), who represents the Office of Structural Materials for your project.

Inspected By: Whitehead,Lonnie

Quality Assurance Inspector

Reviewed By: Carreon,Albert

QA Reviewer
