

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-007413**Date Inspected:** 17-Jun-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:** WU ZHI CHENG**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, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

In process Inspection

OUTSIDE SEGMENT ASSEMBLY AREA

This QA Inspector randomly observed ZPMC welding personnel performing fillet welding of weld joint SP-394A-001-029~42 filler passes at segment 1BE. The personnel were observed welding in the 2F position utilizing a FCAW process. Welder is identified as 053609. The welding variables recorded by QC appeared to comply with the WPS- B – T – 2132.

This QA Inspector randomly observed ZPMC welding personnel performing groove welding of repair weld joint OBW1A-008 filler passes at segment between 1AW&1BW. The personnel were observed welding in the 4G position utilizing a SMAW process. Welder is identified as 068917. The welding variables recorded by QC appeared to comply with the WPS- 345-SMAW-4G(4F)-FCM-REPAIR-1.

This QA Inspector randomly observed ZPMC welding personnel performing groove welding of weld joint OBW1A-11 filler passes at segment 1BW. The personnel were observed welding in the 4G position utilizing a SMAW process. Welder are identified as 067572&066261. The welding variables recorded by QC appeared to comply with the WPS- B – P-2214-B-U2-FCM-1.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Magnetic Particle Testing

This Quality Insurance Inspector (QA) performed 15% verification Magnetic Particle Testing (MT) for segment 4AE & 4BE at X37A to I-rib after rectification the weld joint area. This weld was previously tested and accepted by ZPMC QC MT technicians.

The weld designations reviewed are as follows:

For Segment 4AE

CA-010-22,24,34,36,46,48,58&60

For Segment 4BE

CA-28,40,52,64,76,88

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

Inspected By:	Bera,Subhasis	Quality Assurance Inspector
----------------------	---------------	-----------------------------

Reviewed By:	Prue,Erik	QA Reviewer
---------------------	-----------	-------------