

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-007428**Date Inspected:** 12-Jun-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:** Chen Xi**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.

Bay 2:

1AAE

This Caltrans QA inspector monitored activities related to end and strand stiffener replacement for Partial Joint Penetration (PJP) welds exceeding Welding Procedure Specification root gap tolerance on OBG segments 1AAW and 1AAE.

The following base excavation areas that were tested and accepted by ZPMC MT technicians were verified and by Caltrans QA.

A04 - SEG 2E-378, 296, 420, 338
SEG 2D-103, 101

A00 - SEG 2E- 083, 124, 334, 416
SEG 1F- 022, 023, 024, 043, 044, 025, 026, 027
SEG 2D- 002, 004, 171

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A13- SEG2E-429, 387, 137, 227
SEG2D-129, 130, 044, 184

FCAW welding of weld joint SEG1F-022 stiffener. ZPMC welder was identified as 201583. ZPMC QC is identified as Chen Xi. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2333-TC-P4-F.

1AAW

Joint Fit-up of stiffeners verified by ZPMC ABF and CT:

1. Weld joints SEG1E-216, 126, SEG1D-009 located on A2
2. Weld joints SEG1E-337, 295, SEG1D-096 located on A3
3. Weld joints SEG1E-416, SEG1F-006, SEG1D-088 located on A0
4. Weld joints SEG1E-380, 422, SEG1D-107 located on A6
5. Weld joints SEG1E-027, 022, SEG1E-415, 214, SEG1C-001, 090 located on A41

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
