

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-007563**Date Inspected:** 28-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:** Shen fu you / Liu fa wen**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:** Shi Lin**Component:** OBG Components**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#14

Ongoing SMAW Welding of Weld Joint Fit-up 1G-009 Located on SEG061A of 10BW Welder no identified as 0207464 and the welding variables recorded by QC ZMPC Mr. Li Wan Ning to comply with the WPS-B-2211-B-U2-F.

Ongoing FCAW Welding of Weld Joint 3G-009 Located on SSD12-009 Welder no identified as 058245 and The welding variables recorded by QC ZMPC Mr. Xu Tao to comply with the WPS-B-T-2233-B-U2-F.

Ongoing FCAW Welding of Weld Joint 1G-008 Located on SEG055A of 9DW Welder no identified as 058245 and The welding variables recorded by QC ZMPC Mr. Liu Wan Ning to comply with the WPS-B-T-2231-B-U2-F.

Ongoing FCAW Welding of Weld Joint 2F-096 & 2G-095 Located on CA077 Welder no identified as 0203871 and The welding variables recorded by QC ZMPC Mr. Li Ming Yang to comply with the WPS-B-T-2132 & WPS-B-T-2232-Tc-U4b-F.

During random in process visual inspection on the Segment 7EW this Quality Assurance Inspector observed a Fillet weld joint root open in excess of the tolerances specified in AWS D1.5 2002. The joint in question is a Corner section and Floor beam to Side plate Fillet weld joint on Segment identified as SSD-PP59-067,068 and

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

CSD3-PP59-061,062. The root opening measures approximately 15mm and 11 mm respectively. For further information please see the Incident report

040120F4_TL015_B255_06-28-09_7EW_Excessive Root opening

BAY#19

On going SMAW Welding of Weld Joint Fit-up 2F-009,010 Located on BP-025-008 Welder no indentified as 062798 and The welding variables recorded by QC ZMPC Mr. Liu Fu wen to comply with the WPS-B-P-2112-FCM-1.

BAY#3

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an UT report for this date. The member is identified as a Floor Beam. The weld designations reviewed as follows:

FB003-196-105.

FB003-182-105.

FB003-188-104,105.

FB003-199-104.

Unless otherwise noted, all 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:	Kumar, Chadra	Quality Assurance Inspector
----------------------	---------------	-----------------------------

Reviewed By:	Clifford, William	QA Reviewer
---------------------	-------------------	-------------