

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-007605**Date Inspected:** 18-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:

This Caltrans QA inspector verified fit up on the following Fill Plates located on OBG Segment 1AAW.

A06 (Side Plate side)

A28 (Deck Plate side)

A39 (Side Plate side)

The following stiffener welds that were tested and accepted by ZPMC MT technicians were verified and accepted by QA.

A13- SEG2E-429, 387

SEG2D-129

A21- SEG2E-355, 313

SEG2C-148

Bay 3-

This QA Inspector observed the following work in progress: FCAW welding of weld joint 039 located on

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FB003-170-039. ZPMC welder was identified as 215676. ZPMC QC is identified as Chen Xi. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2132-3.

FCAW welding of weld joint 131 located on SSD17A-PP093. ZPMC welder was identified as 203871. ZPMC QC is identified as Chen Xi. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2233-TC-U4b-F.

Bay 7-

This QA Inspector observed the following work in progress: SAW welding of weld joint 001 located on BP3027-001. ZPMC welder was identified as 046830. ZPMC QC is identified as Zhu Liu Hai. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2221-B-L2C-S-2.

Bay 9-

This QA inspector performed conventional Ultrasonic (A scan) Inspection of tack welds on deck panels. Indications located within the area of interest were marked and recorded for phased array evaluation. This QA inspector performed UT on deck panel DP156-001 (10CW). The following summary below shows total of tack weld locations scanned, amount of indications and the percentage of indications for tack welds inspected on the panel.

DP156-001:

Weld 1, 28 tacks scanned with 1 indication
Weld 2, 28 tacks scanned with 2 indications
Weld 3, 28 tacks scanned with 1 indication
Weld 4, 28 tacks scanned with 4 indications

112 tack weld areas scanned with 8 indications (7.14%)

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

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Reviewed By: Carreon,Albert

QA Reviewer