

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-008234**Date Inspected:** 03-Jul-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 Jia			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:

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

TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress

This QA Inspector observed LD at PP28-29 in segment 4BE south side not rewelded.

This QA Inspector observed ZPMC gouged the splice weld between side panel to bottom panel at PP29 in segment 5AE south side at short LD and not rewelded.

This QA Inspector observed ZPMC performing buttering on the flame cut edge of LD @PP 28-29 in segment 4 BE south side.

This QA Inspector observed ZPMC performed Heat straitening on LD @PP25-26 of segment 4AE south side.

This QA Inspector observed ZPMC performed Heat straitening on LD @PP18 of segment 2BE south side.

This QA Inspector observed ZPMC performed Heat straitening on LD @PP17-16 of segment 2BW North side.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

This QA Inspector observed ZPMC performed Heat straitening on LD @PP19 of segment 3AW south side.

This QA Inspector observed ZPMC performed Heat straitening on LD @PP22 of segment 3AW North side.

This QA Inspector observed ZPMC performed Heat straitening on short LD @PP29 of segment 5AW south side.

This QA Inspector observed the continued drilling of road barrier holes in the deck plate of 1AE on cross beam side of the segment at PP9-10. ZPMC has used template to start drilling of holes with another crew coming behind through drilling started holes.

This QA Inspector observed ZPMC gouged the splice weld between counter weight connection plate to deck panel at PP12-13 on segment 1BW.

This QA Inspector observed ZPMC performing Heat straitening on cantilever at PP11 in segment 1BE.

This QA Inspector observed ZPMC gouged the splice weld between deck panel to side panel at PP10-11 of segment 2BE south side.

This QA Inspector observed the continued drilling of road barrier holes in the deck plate of 1AW on cross beam side of the segment at the PP9-10. ZPMC has used template to start drilling of holes with another crew coming behind through drilling started holes.

FCAW welding process of weld joint 031 located on PCMK SEG020A. Welder is identified as 053609 ZPMC QC is identified as Wang Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231T

Unless otherwise noted, all work observed on this dated 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 Jim Simonis - 134-7246-3441, who represents the Office of Structural Materials for your project.

Inspected By:	Utekar,Shrikant	Quality Assurance Inspector
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Reviewed By:	Clifford,William	QA Reviewer
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