

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-008428**Date Inspected:** 06-Jul-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**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 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 Temporary attachment removal and grinding of 6CW carried out as per specification

Verified by ZPMC QC Mr. Yin hai peing.

Ongoing SMAW Repair Welding of Weld Joint 4G-031 Located on SEG027* of 6AW Welder no indentified as 068917 and The welding variables recorded by QC ZMPC Mr. Yin Hai Peing to comply with the WPS-345-SMAW-4G(4F)-FCM-Repair-1 .

Ongoing FCAW Welding of Weld joint 1G-006 Located on SEG064A Welder no indentified as 050988 and the welding variables recorded by QC ZMPC Mr. Zhong guo hui to comply with the WPS-B-T-2231-B-U2-F.

BAY#19

Ongoing FCAW Welding of Weld Joint 2F-011 & 2G-45 Located on BP26-009 Welder no indentified as 062749 & 062737 and The welding variables recorded by QC ZMPC Mr. Zhou cheng to comply with the WPS-B-T-2132-3 & WPS-B-T-2232-Tc-U4b-F.

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Wrong Consumables used for the Tack weld of Weld joint fit-up of Cross Beam Bottom plate BP025-010-003. Bottom plate material is ASTM A709M-Gr 345-F2 .Approved WPS for the Tack welding is WPS-B-P-2211-B-U2-FCM-1 and the consumable is TL-508(H4). But during fit-up used consumable was TL-508. For further information please see the Incident report 04-0120F4_TL-0015_B255_07-06-09__ Bay19 wrong consumables used.

Unless otherwise noted, all observed on this date appeared to generally comply with applicable contract documents

Summary of Conversations:

No Relevant Conversation.

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:	Kumar,Chadra	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
