

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-008847**Date Inspected:** 09-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

On going SMAW weld buttering of cut pipe area at A40 in segment 1AAW, welder no identified as 045196 and the welding variables recorded by the QC ZPMC Mr. Wang Liang to comply with the WPS-345-SMAW-4G(4F)-Repair and B-WR-6138.

Cutting and removal of Temporary plates after HSR is on going to comply with the approved HSR report.

Grouting is started at 9.45 am and is on-going in segment 1AAW. Still some of (Grouting area) inside stiffener area debris and loose particles present there, but ZPMC is doing their grouting.

Please see the attached photos.

Ongoing SMAW Welding of Weld Joint 4G-042 Located on SEG035D of 7BW Welder no identified as 067610 and The welding variables recorded by QC ZPMC Mr. Li Ming Yang to comply with the WPS-B-P-2214-Tc-U4b-FCM-1.

Weld joint Fit-up and dimension checked with ZPMC QC Mr. Liu wan ning of SEG059A-017.

WELDING INSPECTION REPORT

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This Quality Assurance Inspector observed that a Deck Plate was damaged approximately 65mm into the edge of the plate and a width of 40 mm in length. This damage was caused by Gas Flame Cutting and the plate was identified as DP673A of CA065 in Segment 9DW. For further information Please see the Incident report 040120F4_TL-15_B255_07-09-09_SEG_9DW_Damaged_Deck_Plate

BAY#19

Ongoing FCAW Welding of Weld Joint 2F-060 Located on SB017-082 Welder no identified as 062738 62749 and The welding variables recorded by QC ZMPC Mr. Zhou zhon hai to comply with the WPS-B-T-2132.

BAY#2

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an MT report for this date. The member is identified as a Floor Beam. The weld designations reviewed as follows:

FB010-032-01,09,39,46.

FB012-032-03,15,24,16.

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
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Reviewed By:	Clifford,William	QA Reviewer
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