

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-009340**Date Inspected:** 28-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**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:** Chen 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 times noted above for observations relative to the work being performed.

BAY#14

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 members are identified as OBG Segment. The weld designations reviewed are as follows:

SEG055A-031.

SEG057A-004.

SEG059A-004.

SEG061A-004.

SEG063A-032.

SSD13-PP85-135.

SSD13A-PP85-131.

SSD13-PP84-135.

SSD13A-PP84-131.

SSD13-PP83-135.

SSD13A-PP83-131.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

FCAW welding of weld joint 3G-133 located on PCMK SSD12-PP88 of 10AW welder is identified as 066401. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2233-B-U2-F.

FCAW welding of weld joint 3F-023 located on PCMK DP154-001 welder is identified as 045175. ZPMC QC is identified as Mr. Liu wan ning. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2133.

FCAW welding of weld joint 1F-035 located on PCMK SP776-001 of 10AW welder is identified as 050316. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2131.

SMAW welding of weld joint 4G-005 located on PCMK SEG055A of 9DW welder is identified as 058242. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2214-B-U2-FCM-1.

SAW welding of weld joint 1G-007 located on PCMK SEG061* of 10BW welder is identified as 045265. ZPMC QC is identified as Mr. Liu wan ning. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2221-B-L2c-S-2.

OUTSIDE SEGMENTS

During visual inspection it is found that in Segment 8AE Corner assembly X37 plate the weld no Identified as CA048-049,050,051,052,053,054 , it needs Tight fit but in actual the gap between Deck plate and X37 is 4mm and 5mm. this is informed to ABF QA-Mr.Tang youqing. ZPMC QC-Mr.Wang xian pin.

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



Item Description

WBS

Dwg No.

Status

1

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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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