

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-009408**Date Inspected:** 19-Sep-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:** 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 Components**Summary of Items Observed:**

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

Bay #2

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 member is identified as OBG Components. The weld designations reviewed are as follows:

-(FB3064-001-013)

-(FB3035-001-013)

-(FB3008-001-004, 022)

-(FB3067-001-013, 008)

-(FB3067-002-013, 008)

Bay #3

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 member is identified as OBG Components. The weld designations reviewed are as follows:

-(CB202E-014-001)

Cross Beam-007

This QA inspector observed that following weld# were rejected by ZPMC UT technician on Cross Beam-007. ZPMC QC is identified as Tian Lei and ABFJV is identified as Wang Win Ben.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

- (CB201G-013-049, 043)
- (CB201G-014-119, 167, 131, 067, 089, 099)
- (CB201G-015-063, 065, 067, 097, 043)
- (CB201G-016-067, 069, 107, 101, 103, 097, 043)

This QA inspector observed the following work in progress:

Bay#6 CB-009

FCAW welding of weld joint FB204-024-088 located on CB-009. Welder is identified as 220688 (3G). ZPMC QC is identified as Meng Linnan. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint FB204-022-069 located on CB-009. Welder is identified as 053609 (2G). ZPMC QC is identified as Meng Linnan. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint CB202A-009-014 located on CB-009. Welder is identified as 048625 (2G). ZPMC QC is identified as Meng Linnan. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Bay#3

FCAW welding of weld joint LD002-046-012 located on LD002-046. Welder is identified as 051356 (1G). ZPMC QC is identified as Guo Yuan Ting. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint LD002-056-012 located on LD002-056. Welder is identified as 051356 (1G). ZPMC QC is identified as Guo Yuan Ting. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Unless otherwise noted, all observed on this date 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 Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Patel,Hiranch	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
