

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-009467**Date Inspected:** 30-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**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**Summary of Items Observed:**

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

Bay 9-

This Caltrans QA Inspector performed Magnetic Particle Testing verification of OBG Deck Panel DP3052-001-001 through 008 and DP 3064-001-001 through 008 tack welds after ZPMC initial MT inspection. ZPMC personnel have made repairs of areas found unacceptable. ZPMC has not performed the final MT of the repair areas. No relevant indications were found during this in process inspection.

Bay 13-

This QA Inspector observed the following work in progress: SMAW tack welding of OBG Side Panel SP140A to SP167A Butt splice weld SEG065-003. ZPMC welder was identified as 049861. ZPMC QC is identified as Lv Li Qing. The welding appeared to be in conformance with welding procedure specification, WPS-B-P-2211-B-U2.

Bay 14-

This QA Inspector observed the following work in progress: FCAW welding of OBG Segment 9CW Deck Panel DP232A to DP259A Butt splice weld SEG053-007. ZPMC welder was identified as 050316. ZPMC QC is identified as Shen Fu You. The welding appeared to be in conformance with welding procedure specification,

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WPS-B-T-223(2)1T-2.

FCAW welding of OBG segment 10AW FL3 floor beam to side panel panel complete joint penetration welds SEG059A-027 and 028 at panel point 86. ZPMC welders were identified as 066401 and 202122 . ZPMC QC is identified as Shen Fu You. The welding appeared to be in conformance with welding procedure specifications, WPS-B-T-2233-TC-U4b-F.

SMAW repair welding of OBG segment 9BW lower floor beam to FL3 splice weld SSD12A-014. ZPMC welder was identified as 045246 . ZPMC QC is identified as Shen Fu You. The welding appeared to be in conformance with welding procedure specifications, WPS-345-SMAW-3G (3F).

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

Summary of Conversations:

Only general conversation occurred between QC and QA this date.

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.

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| Inspected By: | Viars,Larry | Quality Assurance Inspector |
| Reviewed By: | Dawson,Paul | QA Reviewer |
