

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-009564**Date Inspected:** 11-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 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

FCAW welding of weld joint 2F-110 located on PCMK SSD13-PP84 of 9EW welder is identified as 0203871. ZPMC QC is identified as Mr. Xu tao . The welding variables recorded by QC appeared to Comply with the WPS-B-T-2132.

FCAW welding of weld joint 3F-109 located on PCMK SSD13-PP83 of 9EW welder is identified as 0207465. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2133.

FCAW welding of weld joint 1G-006 located on PCMK SEG055* of 9DW 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-2231-B-U2-F.

On going heat straightening of following weld joint temperature, dimension checked with ZPMC QC Mr. Liu wan ning and recorded.

FCAW welding of weld joint 1G-182 located on PCMK SSD16-PP62 of 8AE welder is identified as 066683.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

ZPMC QC is identified as Mr. Wang wei ning. The welding variables recorded by QC appeared to Comply with the WPS-B-T2231-B-U2-F.

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 members are identified as Segment 2AW. The weld designations reviewed are as follows:

FB037-001-01,03,04,05,09,11,13,16,19.

FB025-001-02,03,06,07,10,14,17,18,20.

SEG007F-017.

SEG007F-016-One Longitudinal indication found, rejected.

During verification of Magnetic Particle Testing of the at OBG Segment 2AW. Caltrans Quality Assurance (QA) Inspector discovered one (1) Longitudinal indication 20 mm in length in the weld metal location identified as SEG007F-016. For more information please see the incident report.

04-0120F4_TL-15_B255_09-11-09__Seg_2AW_MT_Longitudinal_Indication.

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

Summary of Conversations:

as per 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:	Patterson,Rodney	QA Reviewer
---------------------	------------------	-------------