

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-010158**Date Inspected:** 31-Oct-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:** Xu yun min**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.

1AAE+1AE

SMAW repair welding on weld joint 001 located at OBE1 Deck Panel (external). Welder is identified as 045138. ZPMC QC is identified as Zheng Hai Tao. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-1G (1F)-FCM-Repair-1 and CWR repair procedure #BCWR-868.

Y Location of excavation by above noted welder 045138 is located at approximately 7269 mm and is 150 mm in length.

SMAW repair welding on weld joint 001 located at OBE1 Deck panel (external). Welder is identified as 045138. ZPMC QC is identified as Zheng Hai Tao. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-1G (1F)-FCM-Repair-1 and CWR repair procedure #BCWR-868.

Y Location of excavation by above noted welder 045138 is located at approximately 9660 mm and is 165 mm in length.

SMAW repair welding on weld joint 001 located at OBE1 Deck panel (external). Welder is identified as 045196. ZPMC QC is identified as Zheng Hai Tao. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-1G (1F)-FCM-Repair-1 and CWR repair procedure #BCWR-868.

Y Location of excavation by above noted welder 045196 is located at approximately 11440 mm and is 200 mm in length.

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Witnessed ongoing post weld heat treatment of repair weld joint 001 located at OBE1 deck panel (external). The temperature and holding time recorded by QC appeared to comply with WPS-345-SMAW-1G (1F)-FCM-Repair-1 and CWR repair procedure #BWCR-868.

Y Location of PWHT excavation by above is located at approximately 17595 mm and is 565 mm in length.

Witnessed of Flush grinding of repair weld area of repair weld joint 001 located at OBE1 deck panel (external). Y location of grinded area is located at approximately 2420,2770,3170,4310.

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

Summary of Conversations:

No relevant Conversation.

Item	Description	WBS	Dwg No.	Status
1				

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:	Patterson,Rodney	QA Reviewer
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