

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-010164**Date Inspected:** 07-Nov-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:** Li yang**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.

TRAIL ASSEMBLY YARD

SMAW repair welding on weld joint 003 located at OBE2A side plate (external). Welder is identified as 049769. ZPMC QC is identified as Mr. Wu zhi cheng and CWI is identified as Mr. Li yang. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-3G (3F)-FCM-Repair-1. ZPMC is using old CWR repair procedure for this repair #BCWR-859. This is informed to CT SMR Mr. Jim simonis.

Y Location of excavation by above noted welder 049769 is located at approximately 6440 mm and is 220 mm in length.

Witnessed ongoing post weld heat treatment of repair weld joint 003 located at OBE2A side plate (external). The temperature and holding time recorded by QC appeared to comply with WPS-345-SMAW-3G (3F)-FCM-Repair-1.

Y Location of PWHT excavation by above is located at approximately 6720 mm.

FCAW Repair welding of on weld joint 005,007 located at BK001-020 of Segment 6AW. Welder is identified as 220066. ZPMC QC is identified as Mr. Wang zhu. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-3G(3F)-repair and repair welding report B-WR8428.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

FCAW welding of on weld joint 008 located at SEG026A of Segment 5CE. Welder is identified as 220063. ZPMC QC is identified as Mr. Wang zhu. The welding variables recorded by QC appeared to comply with WPS-B-T-223T-2.

SMAW welding of on hold back weld joint 009 located at DP631-001 of Segment 5CE. Welder is identified as 66326. ZPMC QC is identified as Mr. Wang zhu. The welding variables recorded by QC appeared to comply with WPS-B-T-4114-1.

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
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Reviewed By:	Patterson,Rodney	QA Reviewer
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