

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-010167**Date Inspected:** 11-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:** 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 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 3G-007 located on PCMK SSD13A-PP84 of 9EW welder is identified as 201215. ZPMC QC is identified as Mr.Wang xu. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2233-B-U2-F.

SMAW welding of weld joint 4G-040 located on PCMK SEG055A of 9DW welder is identified as 037723.ZPMC QC is identified as Mr. Wang Xu. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2214-Tc-U4b-FCM.

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 OBG corner assembly. The weld designations reviewed are as follows:

CSD3-PP106-095,096,099,103

CSD3-PP104-095,096,097,098

CSD9-PP105-033,035,039,141,142,63

CSD3-PP107-033,035,096,099

CSD6-PP107-033,035

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CSD6-PP108-033,036

BAY#13

SAW welding of weld joint 1G-005 located on PCMK SEG069* of 11CW welder is identified as 044771.ZPMC QC is identified as Mr. Zhang guo hui. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2221-B-L2C-S-2.

FCAW welding of weld joint 1G-006 located on PCMK SEG065* of 11AW welder is identified as 050988.ZPMC QC is identified as Mr. Zhang guo hui. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2231-B-U2-F.

FCAW welding of weld joint 3F-129/130 located on PCMK SSD13-PP95 of 11AW welder is identified as 055564. ZPMC QC is identified as Mr. guo xing hui. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2133.

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 OBG Base metal repair of Corner assembly diaphragm. The weld designations reviewed are as follows:

X151A.

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

Summary of Conversations:

No relevant 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
