

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-010312**Date Inspected:** 01-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:** 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

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an UT report for this date. The members are identified as OBG Segment. The weld designations reviewed are as follows:

SEG061A-007.

SEG057A-007 – Rejected. Incident report written for that, for more information please see the Incident report 04-012-F4_TL-15_B255_10-02-09_Seg_9EW_Rejectable_UT_Indication.

FCAW welding of weld joint 2F-020 located on PCMK DP150-001 of 9BW welder is identified as 050316.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 3G-017 located on PCMK DP234-001 welder is identified as 0207465.ZPMC QC is identified as Mr. Li ming yang. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2233-Tc-U4b-F.

SMAW welding of weld joint 4G-079 located on PCMK SP492-001 of 9BW welder is identified as 066413.

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ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2214-B-U2-FCM-1.

SAW welding of weld joint 1G-007 located on PCMK SEG061* of 10BW welder is identified as 045265.ZPMC QC is identified as Mr. Liu wan ning. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2221-B-L2c-S-2.

BAY#13

FCAW welding of weld joint 1G-003 located on PCMK SEG065 welder is identified as 050988.ZPMC QC is identified as Mr.Lv liqiang. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2231-B-U2-F.

OUTSIDE SEGMENTS

Increasing Fillet weld size to 24 mm of Pedestal lift in Segment 7EW SMAW weld no identified as SSD13A-PP60-10,108,109,110 and SSD13-PP60-111,110,109,108, the welding variables recorded by QC Mr. Wang xian pin appeared to comply with the WPS-B-P-2112.

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

Summary of Conversations:

No relevant Conservation.

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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