

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-010313**Date Inspected:** 03-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:

SSD10-PP80-130.

SSD10A-PP80-013.

SSD11-PP81-130.

SSD11A-PP81-013.

SSD12-PP82-130.

SSD12A-PP82-014.

SMAW welding of weld joint 4F-014 located on PCMK SP772-001 of 9DW welder is identified as 067829.ZPMC QC is identified as Mr. Li ming yang. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2114-FCM-1.

FCAW welding of weld joint 3G-023 located on PCMK SEG059A welder is identified as 066401.ZPMC QC is identified as Mr.Li ming yang. The welding variables recorded by QC appeared to Comply with the

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WPS-B-T-2233-Tc-U4b-F.

SMAW welding of weld joint 4G-026 located on PCMK SEG051A of 9BW welder is identified as 045246.ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2214-Tc-U4b.

SMAW welding of weld joint 4F-049 located on PCMK SP670-001 of 9BW welder is identified as 0205718. ZPMC QC is identified as Mr. Li ming yang. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2221-B-L2c-S-2.

During Visual inspection it is found that the following weld joints fit up root gap was not as per WPS-B-T-2231-Tc-U4b-F. Root gap is 10mm, the weld joints are SEG051B-003 , SEG051B-005. of 9BW. SEG055B-003 of 9DW. This is informed to ZPMC QC Mr.Xu tao.

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



Item	Description	WBS	Dwg No.	Status
1				
2				

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.

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Inspected By:	Kumar, Chadra	Quality Assurance Inspector
Reviewed By:	Patterson, Rodney	QA Reviewer