

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-010374**Date Inspected:** 23-Nov-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Xi**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 COMPONENT**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance(QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

Cross Beam At Ship

SMAW in the 2G position of the OBG crossbeam CB3 corner joint at side plate to bottom plate , weld No. CB205A-001-017 at Y location 7710. The welder is identified as #062745. ZPMC QC is identified as Mr.Zhon Cheng. The welding variables recorded by QC appear to comply with WPS- 345-SMAW-2G(2F)-FCM-REPAIR-1 and repair procedure B-CWR914.

SMAW in the 2G position of the OBG crossbeam corner joint at side plate to deck plate , weld No. CB205A-001-001,002 and 003 at Y locations are 50,1985,2740 and 6165 east side. The welder is identified as #062810. ZPMC QC is identified as Mr.Zhon Cheng. The welding variables recorded by QC appear to comply with WPS- 345-SMAW-2G(2F)-FCM-REPAIR-1 and repair procedure B-CWR914.

SMAW in the 2G position of the OBG crossbeam corner joint at side plate to deck plate , weld No. CB205A-001-014 at Y locations 7770 West side. The welder is identified as #062810. ZPMC QC is identified as Mr.Zhon Cheng. The welding variables recorded by QC appear to comply with WPS- 345-SMAW-2G(2F)-FCM-REPAIR-1 and repair procedure B-CWR914.

SMAW in the 2G position of the OBG crossbeam corner joint at side plate to deck plate , weld No. CB204A-001-014 at Y location 5740 West side. The welder is identified as #043661. ZPMC QC is identified as

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Mr.Zhon Cheng. The welding variables recorded by QC appear to comply with WPS-345-SMAW-2G(2F)-FCM-REPAIR-1 and repair procedure B-CWR909.

SMAW in the 2G position of the OBG crossbeam corner joint at side plate to deck plate , weld No. CB204A-001-001 at Y location 7905 East side. The welder is identified as #043661. ZPMC QC is identified as Mr.Zhon Cheng. The welding variables recorded by QC appear to comply with WPS-345-SMAW-2G(2F)-FCM-REPAIR-1 and repair procedure B-CWR909.

During random in-process visual inspection, Quality Assurance (QA) Inspector observed ZPMC welding personal (ID#043661) carrying out welding repairs of transverse cracks without the prior approval of the engineer or an approved CWR. The weld repair of these noted cracks was performed at weld CB-204A-001-002 located at the eastern side plate to deck plate splice weld connection at the Y location 6810 and 7105 respectively .

This QA Inspector generated an incident report for this date.

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

Summary of Conversations:

No relevant conversations

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 Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Bera,Subhasis	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
