

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-010556**Date Inspected:** 18-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:** See Below**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**Summary of Items Observed:**

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

Blast Bay 1-

This QA Inspector performed visual inspection after blast of OBG segment 7AW deck panel and the east side of PP49 upper section. Caltrans QA observed that areas had been ground and were marked on the exterior deck panel.

This area was tested by Caltrans QA with Magnetic Particle Testing and two linear indications were found (5mm and 13 mm in length). The indications and location were recorded by Caltrans QA for repair and added to punch list.

Bay 14-

This QA Inspector observed the following work in progress: Flux Cored Arc Welding (FCAW) of OBG segment 10BE floor beam to bottom panel fillet welds, SSD012A-PP100-078 and 080. ZPMC welder was identified as 044774. ZPMC QC is identified as Zhang Qiao. ZPMC CWI was identified as Zhu Zhong Hai. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2132.

Shielded Metal Arc Welding (SMAW) of OBG segment 11BE Side Panel to FL3 Floor beam welds, SEG068A-024 and 026. ZPMC welders were identified as 044772 and 067752. ZPMC QC is identified as Zhang Qiao. ZPMC CWI was identified as Zhu Zhong Hai. The welding appeared to be in conformance with welding

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

procedure specification, WPS-B-P-2214-TC-U4b-FCM-1.

North of Bay 14-

This QA Inspector performed Magnetic Particle Testing (MT) verification of welds previously tested and accepted by ZPMC for OBG Segment 7DE Corner assembly welds. For additional information see the TL-6028 MT report generated this date. The following welds were tested:

SSD24-127, 128, 131, 132, 143, 144, 117, 119, 149 and 150

CSD2-PP56-058, 048, 010, 008, 026 and 030

CA042-025~030

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

Summary of Conversations:

As identified within the contents of this report.

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.

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| Inspected By: | Viars,Larry | Quality Assurance Inspector |
| Reviewed By: | Dawson,Paul | QA Reviewer |
