

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-010584**Date Inspected:** 04-Dec-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:** Lu Li Qing**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, Hiranch Patel, was present during the times noted above for observations relative to the work being performed.

During random visual inspection of OBG Segment 11AE, this QA inspector observed that ZPMC has deviated from the joint design and used steel backing where it is not specified. The steel backing bar used to rectify excessive root opening in Corner Assembly to Deck Plate open ribs. For further information, see attached pictures below.

Weld# having root opening more than 5mm are as below.

-CSD6-PP96-063, 064, 065, 066, 067, 068.

-CSD6-PP97-065, 066, 067, 068.

For further information, please see the attached pictures below.

Bay#13

SMAW welding of weld joint SSD19-PP95-003 located on Segment 11AE. Welder is identified as 067589 (4G).

ZPMC QC is identified as Guo Xing Hai. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-Tc-U4b-FCM-1.

SMAW welding of weld joint SSD19-PP96-003 located on Segment 11AE. Welder is identified as 067589 (4G).

ZPMC QC is identified as Guo Xing Hai. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-Tc-U4b-FCM-1.

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FCAW welding of weld joint SSD19-PP95-009, 002 located on Segment 11AE. Welder is identified as 044801 (3G). ZPMC QC is identified as Guo Xing Hai. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-B-U2-F.

FCAW welding of weld joint SSD19-PP96-009, 002 located on Segment 11AE. Welder is identified as 044774 (3G). ZPMC QC is identified as Guo Xing Hai. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-B-U2-F.

FCAW welding of weld joint SSD19-PP97-009, 002 located on Segment 11AE. Welder is identified as 050242 (3G). ZPMC QC is identified as Guo Xing Hai. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-B-U2-F.

FCAW welding of weld joint Seg066*-001 located on Segment 11AE. Welder is identified as 048038 and 058100 (1G). ZPMC QC is identified as Guo Xing Hai. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-T-2.

FCAW welding of weld joint SSD19A-PP95-007 located on Segment 11AE. Welder is identified as 055564 (3G). ZPMC QC is identified as Guo Xing Hai. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-B-U2-F.

FCAW welding of weld joint SSD14A-PP101-245, 235, 244, 234 located on Segment 11CW. Welder is identified as 058551 (3G). ZPMC QC is identified as Guo Xing Hai. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-Tc-U5-F.

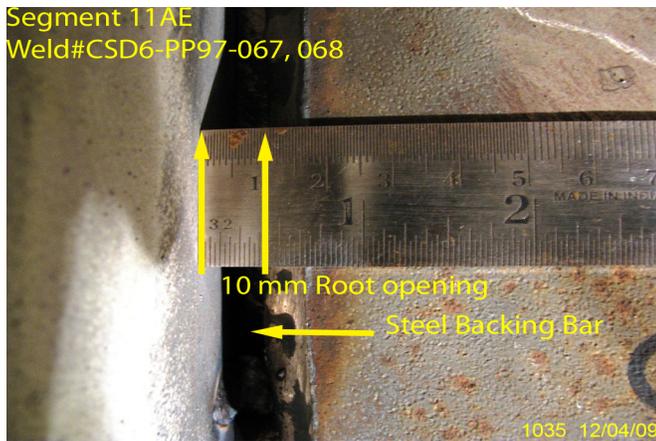
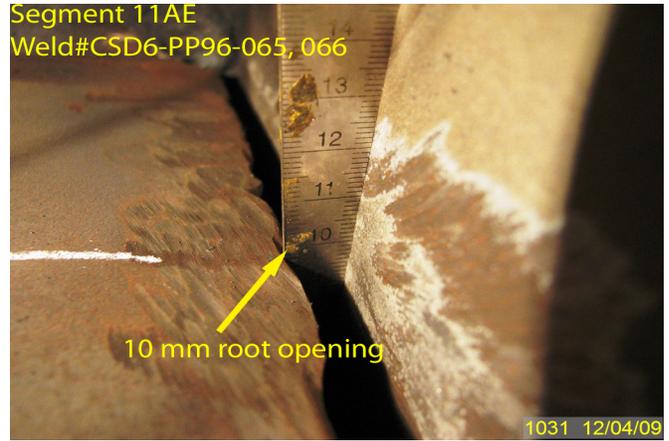
FCAW welding of weld joint SSD14A-PP101-236, 246 located on Segment 11CW. Welder is identified as 055491 (2G). ZPMC QC is identified as Guo Xing Hai. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232-Tc-U5-F.

FCAW welding of weld joint SSD14-PP101-235 located on Segment 11CW. Welder is identified as 055491 (3G). ZPMC QC is identified as Guo Xing Hai. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-Tc-U5-F.

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

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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: Patel, Hiranch

Quality Assurance Inspector

Reviewed By: Patterson, Rodney

QA Reviewer
