

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-010728**Date Inspected:** 02-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:	Wu Zhi Cheg	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.

Trial Assembly area

SMAW in the 4G position of the OBG segment 4AW corner joint at side plate to bottom plate, weld No. SEG-017A-007 at BK side. The welders are identified as #067571 and #066258. ZPMC QC is identified as Mr. Shen Jian Bo. The welding variables recorded by QC appear to comply with WPS-345-SMAW-4G(4F)-FCM-Repair-1.

Witness of Magnetic Particle Testing

This QA inspector was Witnessing of Magnetic Particle Testing which was carried by ABF QC Technicians at corner Weld between deck plate to edge plate at 4AE and 4BE at BK side. This inspector observed the ABF QC did not find any indication on the weld area.

The weld designations reviewed are as follows:

CA008-002,004 and 006

CA012-002,004 and 006

Ultrasonic Testing

QA Verification UT performed after repair on portion of deck plate to edge plate corner joint of 3AE and 3BE at

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Bike path side. This Inspection was performed after ABF UT Inspectors performed UT of this joint. The result were recorded onto a data sheet that Caltrans QA and ABF QA have jointly filled out on this date.

The Weld Designations are as follows

CA002-002,004 and 006

CA004-002,004 and 006

QA Verification UT performed after repair on portion of bottom plate to side plate corner joint of 3AE and 3BE at Bike path side. This Inspection was performed after ABF UT Inspectors performed UT of this joint. The result were recorded onto a data sheet that Caltrans QA and ABF QA have jointly filled out on this date.

The Weld Designation is as follows

SEG016A-008

QA Verification UT performed after repair on portion of bottom plate to side plate corner joint of 3AE and 3BE at Crossbeam side. This Inspection was performed after ABF UT Inspectors performed UT of this joint. The result were recorded onto a data sheet that Caltrans QA and ABF QA have jointly filled out on this date.

The Weld Designation is as follows

SEG016A-007

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
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Reviewed By:	Patterson,Rodney	QA Reviewer
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