

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-011397**Date Inspected:** 11-Jan-2010**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:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this date Caltrans Office of Structural Material (OSM) Quality Assurance (QA) Inspector, D.Sukanthan was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

OBG # CROSS BEAM CB01

This crossbeam is completed and was shipped.

OBG # CROSS BEAM CB02

This crossbeam is completed and was shipped.

OBG # CROSS BEAM CB03

This crossbeam is completed and was shipped.

OBG # CROSS BEAM CB04

This QA observed that no significant work was being performed on this crossbeam during the time QA was present.

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OBG # CROSS BEAM CB05

This QA observed that no significant work was being performed on this crossbeam during the time QA was present.

OBG # CROSS BEAM CB06

This QA observed that no significant work was being performed on this crossbeam during the time QA was present.

OBG # CROSS BEAM CB07

This QA observed that no significant work was being performed on this crossbeam during the time QA was present.

OBG # CROSS BEAM CB08

This QA observed that no significant work was being performed on this crossbeam during the time QA was present.

OBG # CROSS BEAM CB09

This QA observed ZPMC qualified welding personnel identified as 037779 perform Shielded metal Arc Welding (SMAW) Process welding on weld joint CB202G-022-040. ZPMC Quality Control Personnel (QC) identified as Mr. Lin Chuan Gang was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-3G (3F)-Repair.

This QA observed ZPMC qualified welding personnel identified as 037779 perform Shielded metal Arc Welding (SMAW) Process welding on weld joint CB202G-023-039. ZPMC Quality Control Personnel (QC) identified as Mr. Lin Chuan Gang was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-3G (3F)-Repair.

This QA observed ZPMC qualified welding personnel identified as 037779 perform Shielded metal Arc Welding (SMAW) Process welding on weld joint CB202G-022-039. ZPMC Quality Control Personnel (QC) identified as Mr. Lin Chuan Gang was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-3G (3F)-Repair.

OBG # CROSS BEAM CB10

This QA observed that no significant work was being performed on this crossbeam during the time QA was present.

OBG # CROSS BEAM CB 11

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This QA inspector received ZPMC Non Destructive Testing (NDT) notification 005038 to perform Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated a Magnetic Particle Test report for this date. The member is identified as Cross beam. The weld tested is identified as follows:

(CB202G-029-087R1, 139R1)

(CB202G-031-180R1)

OBG # CROSS BEAM CB12

This QA observed that no significant work was being performed on this crossbeam during the time QA was present.

OBG # CROSS BEAM CB13

This QA observed that no significant work was being performed on this crossbeam during the time QA was present.

OBG # CROSS BEAM CB14

This QA observed ZPMC qualified welding personnel identified as 204338 perform Flux Cored Arc Welding (FCAW) Process welding on weld joint FB204-044-059. ZPMC Quality Control Personnel (QC) identified as Mr. Yin Dong Hai was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-B-U2-F-1.

This QA observed ZPMC qualified welding personnel identified as 204338 perform Flux Cored Arc Welding (FCAW) Process welding on weld joint FB204-043-059. ZPMC Quality Control Personnel (QC) identified as Mr. Yin Dong Hai was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-B-U2-F-1.

OBG # CROSS BEAM CB15

This QA observed that no significant work was being performed on this crossbeam during the time QA was present.

OBG # CROSS BEAM CB16

This QA observed that no significant work was being performed on this crossbeam during the time QA was present.

OBG # CROSS BEAM CB17

This QA observed that no significant work was being performed on this crossbeam during the time QA was

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present.

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

Summary of Conversations:

As mention above

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 150-00422372, who represents the Office of Structural Materials for your project.

Inspected By:	Sukanthan,Dhanasingh	Quality Assurance Inspector
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Reviewed By:	Hall,Steven	QA Reviewer
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