

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-012280**Date Inspected:** 24-Feb-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, Li Jia.**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 OSM Quality Assurance (QA) Inspector, Amit K. Juvekar, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Subassembly, Bay 05, Traveler rail.

SMAW Repair welding (build up about 15-27mm) of weld joint 11TR3-015 (CWR # B-CWR1102); located on Subassembly, Bay 05. Welders are identified as 215248; ZPMC Quality Control Inspector (QC) is identified as Li Jia. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-345-SMAW-1G(1F)-REPAIR-1.

Subassembly, Bay 05, Traveler rail.

FCAW Repair welding (build up about 15-27mm) of weld joint 11TR1-016 (CWR # B-CWR1102); located on Subassembly, Bay 05. Welders are identified as 204342; ZPMC Quality Control Inspector (QC) is identified as Li Jia. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-345-FCAW-1G(1F)-REPAIR-1.

Subassembly, Bay 02, Longitudinal Diaphragm.

During random Inprocess Visual inspection this QA inspector observed ZPMC NDT personal performing Magnetic Particle Testing (MT) on weld identified as LD3021-001-011/010 & LD3021-001-018/017. The attached photographs provide additional detail.

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Subassembly, Bay 01, Support Brackets.

FCAW welding of weld joint 13TB1-206-002 & 13TB1-209-002 & 13TB1-213-002 & 13TB1-211-002 & 13TB1-214-002; located on Subassembly, Bay 01. Welder is identified as 251246; ZPMC Quality Control Inspector (QC) is identified as Chen Xi. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2231-TC-U4B-F. The attached photographs provide additional detail.

Subassembly, Bay 02, Traveler rail.

FCAW Repair welding (build up about 15-27mm) of weld joint 11TR1-022 & 10TR2-021 (CWR # B-CWR1096); located on Subassembly, Bay 02. Welders are identified as 045268, 201912; ZPMC Quality Control Inspector (QC) is identified as Chen Xi. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-345-FCAW-1G(1F)-REPAIR-1. The attached photographs provide additional detail.

Subassembly, Bay 06, Traveler rail.

During random Inprocess Visual inspection this QA inspector observed ZPMC personal performing Heat straightening on the traveler rail 11TR3-006. ZPMC have Heat straightening Report (HSR)# HSR1(B)-8087. The attached photographs provide additional detail.

Subassembly, Bay 03, Traveler rail.

FCAW welding of weld joint 20TR2-010-004 & 20TR2-016-004; located on Subassembly, Bay 03. Welder is identified as 044774, 044824; ZPMC Quality Control Inspector (QC) is identified as Chen Xi. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2231-TC-U5-F.

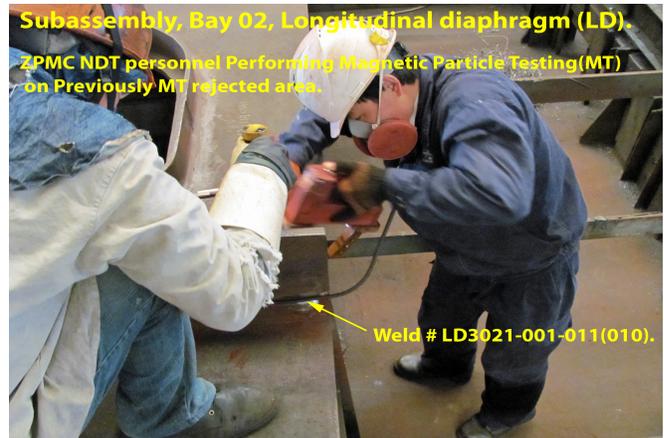
Subassembly, Bay 01, Traveler rail.

FCAW welding of weld joint 20TR1-025-003; located on Subassembly, Bay 01. Welder is identified as 219188; ZPMC Quality Control Inspector (QC) is identified as Chen Xi. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2231-TC-U5-F.

Unless otherwise noted, all work 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 Serge Sinevod, 13482570045, who represents the Office of Structural Materials for your project.

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Inspected By: Juvekar,Amit

Quality Assurance Inspector

Reviewed By: Miller,Mark

QA Reviewer