

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-013456**Date Inspected:** 06-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu hua ji**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, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

BAY#14

SMAW welding of weld joint 4G-045 located on PCMK SEG072* of 11DE welder is identified as 049339.ZPMC QC is identified as Mr.Guo xing hui . The welding variables recorded by QC appeared to Comply with the WPS-B-P-2214-Tc-U4b-FCM-1.

FCAW welding of weld joint 3F-130/131 located on PCMK CSD4-PP106 of 11DE welder is identified as 048047. ZPMC QC is identified as Mr.Guo xing hui . The welding variables recorded by QC appeared to Comply with the WPS-B-T-4113-2.

FCAW welding of weld joint 3F-198 located on PCMK CA3009C of 12BW welder is identified as 045175.ZPMC QC is identified as Mr.Li ming yang . The welding variables recorded by QC appeared to Comply with the WPS-B-T-2133.

During in process visual inspection it is observed that segment 11DE , fit up of the weld is identified as SSD17-PP105-004 this complete joint penetration weld has 1mm root gap.

ZPMC is going to use steel backing bar but the tack weld has slag and sharp notches. This is Observed and informed to ZPMC QC Mr.Zhong guo hui.

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This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an UT report for this date. The members are identified as X37 bracket plate. The weld designations reviewed are as follows:

CA74-059,060.

CA77-091,092.

CA59-021,022.

This QA inspector performed VT of the X37 bracket plate's area previously tested and accepted by ZPMC Quality Control personnel. The members are identified as X37 bracket plate. The weld designations reviewed are as follows:

CA74-113 to 120.

CA74-057 to 064.

CA77-089 to 096.

SEG51D-001 to 006,009,010.

CA55-015 to 020,065,066.

CA59-019 to 024,101,102.

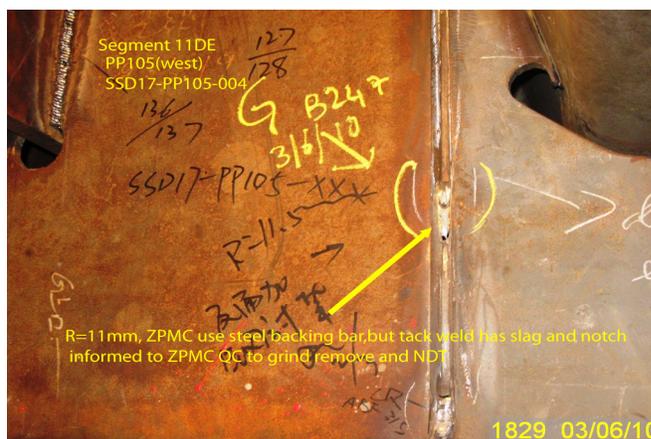
CA62-067 to 072,109,110.

CA65-033,034,057,058.

OUTSIDE SHOP

ZPMC welders doing repair welding of the locations in segment 9CW where ZPMC and ABF QC personnel marked after Visual testing, the welder ID identified as 067589 and consumables, pre heat checked with ZPMC QC Mr. Wang wei ming is appeared to comply with WPS-345-SMAW-2G(2F)-repair.

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



Summary of Conversations:

No relevant Conversation.

Comments

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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-15--0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Chadra	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
