

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-013459**Date Inspected:** 20-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 7000**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:	N/A	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.

OUTSIDE SHOP

Segment 9EE

-This QA inspector performed in process Visual Inspection of the below mentioned fillet welds between Floor Beam and Floor Beam Flange

1. PP83(East)- FB016-033-004
2. PP84(West)- FB016-032-003 - one porosity of 3mm dia found.
3. PP84(West)- FB003-145-004

-These welds were previously MT tested and accepted by ZPMC Quality Control (QC) personnel. As per contract documents, ZPMC QC is required to perform 25% MT of these welds.

-Some locations found some undercuts which is acceptable but need some grinding, those locations marked for further grinding.

-Visually, these welds appeared to comply with the contract documents.

The member(s) are identified as OBG components – Floor Beam & Floor Beam Flange.

During visual inspection of segment 10BE this QA inspector observed that PP84 (West) FB016-032-003, 3mm diameter Porosity from Y=830mm from CB side. This is marked on that location for future ZPMC reference

WELDING INSPECTION REPORT

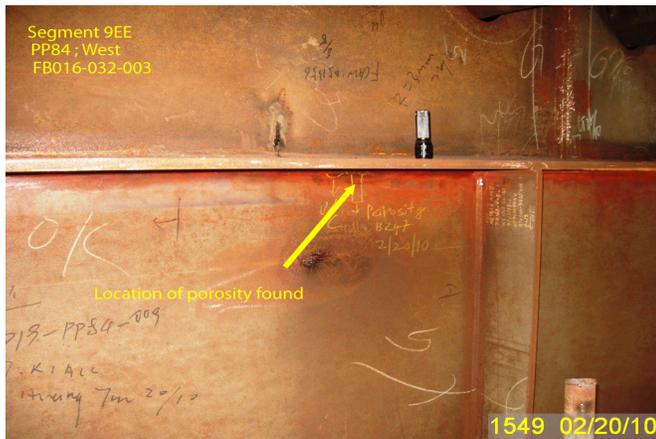
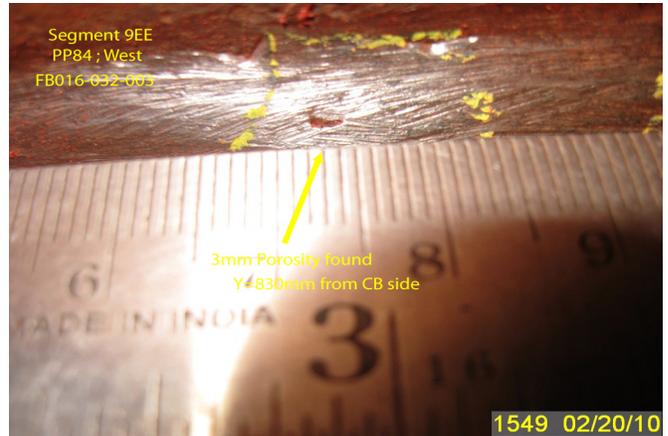
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and rectification. For more information please see the attached photos.

Segment 8AW

ABF Quality control (QC) personnel doing UT scanning pattern D as per contract documents on OBG corner assembly CA47 the weld is identified as CA047-004 which is connecting Deck plate to Edge plate

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



Summary of Conversations:

No relevant Conversation.

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-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
