

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-013698**Date Inspected:** 30-Apr-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: Zhou Zhongai
Inspected CWI report: Yes No N/A
Electrode to specification: Yes No N/A
Qualified Welders: Yes No N/A
Approved Drawings: Yes No N/A

CWI Present: Yes No
Rod Oven in Use: Yes No N/A
Weld Procedures Followed: Yes No N/A
Verified Joint Fit-up: 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 4F-124/123 located on PCMK SEG30065 of segment 12CW welder is identified as 067665. ZPMC QC is identified as Mr. Li ming yang . The welding variables recorded by QC appeared to Comply with the WPS-B-P-2114-FCM-1.

FCAW welding of weld joint 2F-099/100 located on PCMK SEG30065 of segment 12CW welder is identified as 37723. ZPMC QC is identified as Mr. Tao wei . The welding variables recorded by QC appeared to Comply with the WPS-B-T-2132.

FCAW welding of weld joint 1G-007 located on PCMK SEG3003* of segment 12CE welder is identified as 048038. ZPMC QC is identified as Mr. Wang xu . The welding variables recorded by QC appeared to Comply with the WPS-B-T-223(2)1T-2.

Fit-up of following weld joint SEG3006C-146 longitudinal diaphragm connecting to floor beam of segment 12CW , it is found that CJP weld has root gap of 18mm . So ZPMC going to make welding repair report before welding. ZPMC QC Mr. Li ming yang informed this.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Green tag issued to the following sub-assembly components after NDT inspection satisfactorily completed. NWIT -005639.

SEG3006B-131,002,004- green tag no 12671.

SEG3006D-127,002,004-green tag no-12676.

SEG3006C-148,002,004-green tag no-12672.

SEG3006G-151,002,004-green tag no-12674.

SEG3006F-145,003,001-green tag no-12675.

SEG3006E-137,002,004-green tag no-12673.

EB3005-001-001-004 -green tag no-12677.

EB3006-001-001-004 -green tag no-12678.

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
