

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-013714**Date Inspected:** 28-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 / Li yuan hua	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 UT of critical weld repair areas previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an UT report for this date. The members are identified as Segment 9EE. The weld designations reviewed are as follows: NWIT-005618.

SSD19A-PP84-131,105.

SSD19-PP83-135.

This QA inspector performed MT of critical weld repair areas previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an MT report for this date. The members are identified as Segment 9EE. The weld designations reviewed are as follows: NWIT-005618.

DP477-001-137.

DP369-001-082.

SSD19-PP085-004.

Segment 10AE

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SMAW repair welding of misaligned T-ribs weld joint 3G-019 located on PCMK SP544-001 @PP86 of segment 10AE welder is identified as 50232.ZPMC QC is identified as Mr.Tang ya jun . The welding variables recorded by QC appeared to Comply with the WPS-345-SMAW-3G(3F)-Repair and WR-12216.

SMAW repair welding of misaligned T-ribs weld joint 2F-020 located on PCMK SP629-001 @PP86 of segment 10AE welder is identified as 50232.ZPMC QC is identified as Mr.Tang ya jun . The welding variables recorded by QC appeared to Comply with the WPS-345-SMAW-2G(2F)-FCM-Repair and WR-12216.

Segment 10CE

SMAW welding of weld joint 4F-090,089 located on PCMK SEG064D of segment 10CE welder is identified as 043661.ZPMC QC is identified as Mr.Li ping . The welding variables recorded by QC appeared to Comply with the WPS-B-P-2114-FCM-1.

BAY# 14

During in process visual inspection it is observed that Segment 12CE near PP117 Bottom plate distortion of 35 mm in (BK side south side) in the length of 2500mm and 29mm in (CB side north side) in length of 2500mm. Dimension measured with CT QA personnel Mr.Manikandan.

Segment 12CE, partial floor beam FL1 @PP115.5 is going to connect with Corner assembly it is found that 32mm distortion in length of 1580mm. this was marked on that location and informed to ZPMC QA Mr. Zhang wei.

Segment 12AE, partial floor beam FL1 @PP111.5 is going to connect with Corner assembly it is found that 18mm distortion in length of 1440mm. this was marked on that location and informed to ZPMC QA Mr. Zhang wei.

BAY#16

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an MT report for this date. The members are identified as Tower Facade plate. The weld designations reviewed are as follows: NWIT-005622.

ND1-A259-3,12,11
ND1-A234-2
ND1-A214-9-3,7
ND1-A216-9-4,10,11
SD1-A260-1,18,9,
SD1-A235-1,2
ND1-A214-10-7,8,9
ND1-A216-10-6,9,10

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 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
