

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-013723**Date Inspected:** 20-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:** Gang wei**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.

BLAST SHOP-1

Caltrans Quality Assurance (QA) Inspectors performed random visual inspection of Segment 9CW Internal Bottom panel, Side panel and Longitudinal diaphragm from panel point PP77 to PP79 after grit blasting. Areas requiring additional grinding were marked by QA and repaired by ZPMC personnel.

BAY#14

FCAW welding of weld joint 3F-048 located on PCMK SSD24-PP104 of segment 11DE welder is identified as 048038. ZPMC QC is identified as Mr. Guo pan. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2133.

FCAW welding of weld joint 2F-081 located on PCMK SEG3001V of segment 12AE welder is identified as 050977. ZPMC QC is identified as Mr. Guo pan. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2132.

FCAW welding of weld joint 3G-018 located on PCMK SEG71* of segment 11DW welder is identified as 0202122. ZPMC QC is identified as Mr. Tao wei. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2233-B-U2-F.

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SMAW welding of weld joint 3G-045 located on PCMK SEG072D of segment 11DE welder is identified as 206683.ZPMC QC is identified as Mr.Guo pan . The welding variables recorded by QC appeared to Comply with the WPS-B-T-4213-Tc-U4b-2.

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
