

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-014544**Date Inspected:** 28-May-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:	Sun Bo			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:	Bay 12		

Summary of Items Observed:

Bay 12

DP3121-001 (Weld repair on PAUT reject areas)

This QA Inspector observed ZPMC welding personals identified as 062259 performing Flux Cored Arc welding (FCAW) on DP3121-001 U-rib to deck plate PJP weld. ZPMC QC is identified as Zhang Qiao, ABF QC Inspector is identified as Cao Haizhou. The welding variables recorded by QC appeared to comply with the WPS – 345 – FCAW – 2G(2F) – FCM - Repair

Y-location of repairs were

Weld 1 – 2650mm, 9250mm, 10450mm, 12850mm, 13450mm, 13850mm

Weld 2 – 9850mm, 13450mm

Weld 3 – 1450mm, 8650mm, 11050mm, and 13450mm

Weld 4 – 13450mm

Weld 5 – 10450mm

Weld 6 – 50mm, 2650mm, 3850mm, 5640mm, 6850mm, 10450mm, 12850mm

Weld 7 – 12250mm

Weld 8 – 11050mm, 11650mm

Weld 9 – 450mm, 3850mm, 5650mm, 6850mm, 11650mm, 12850mm

Weld 10 – 7450mm, 13450mm, 13850mm

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

This QA Inspector verified the depth of the excavations and was found to be compliant with the repair requirement. Preheat and Post weld heat treatment were in complaint with the approved WPS

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

No relevant conversations.

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 15000422372, who represents the Office of Structural Materials for your project.

Inspected By: Dsouza, Christopher

Quality Assurance Inspector

Reviewed By: Carreon, Albert

QA Reviewer