

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-014880**Date Inspected:** 27-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Geng Wei, Zhu Zhong Hai, Xu Tao			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:	Orthotropic Box Girder (OBG)		

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector, Amit K. Juvekar, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Assembly, Bay 14, 12AW, Deck panel diaphragm.

FCAW welding of weld joint DP3046-001-28, 29; located at assembly, Bay 14, 12AW. Welder is identified as 048696; ZPMC Quality Control Inspector (QC) is identified as Xu Tao. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2132.

Assembly, Outside Yard, 10AE.

During random in process inspection this QA inspector witness repair gouges out for WRR # B-WR12216; located at outside yard 10AE. ZPMC gouged out T-rib stiffener to T-rib stiffener butt joint at 5(five) locations for correcting distortion.

Assembly, Bay 14, 10AW.

Segment 10AW moved to Trial Assembly Yard for further processing. The attached photographs provide additional detail.

Assembly, Bay 14, 12DW, Corner Assembly Deck plate Stiffener to Corner Assembly Diaphragm.

FCAW welding of weld joint SSD11A-PP105-138 to 149; located on assembly, Bay 14, 12DW. Welder is

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

identified as 047864; ZPMC Quality Control Inspector (QC) is identified as Xu Tao. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-P-2113-FCM-1.

Assembly, Bay 14, 12BE, Corner Assembly to Side Panel.

FCAW welding of weld joint SEG3002B-001; located on assembly, Bay 14, 12BE. Welder is identified as 044830, 206623, 044790, 044801; ZPMC Quality Control Inspector (QC) is identified as Lu Li Qing. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2231-U2-F.

Assembly, Bay 14, 12BE, PP114.5, Deck Panel Diaphragm to Floor Beam.

FCAW welding of weld joint SEG3002D-302; located on assembly, Bay 14, 12BE. Welder is identified as 217805; ZPMC Quality Control Inspector (QC) is identified as Lu Li Qing. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2232-TC-U4B-F.

Assembly, Bay 14, 12CW, Edge Beam.

SMAW Repair welding of Edge Beams Buttering about 5mm over 800mm length(WRR # B-WR12419); located on assembly, Bay 14, 12CW. Welder is identified as 068924; ZPMC Quality Control Inspector (QC) is identified as Xu Tao. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-345-SMAW-1G(1F)-FCM-REPAIR.

Unless otherwise noted, all work observed on this date appeared to generally comply with 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, 1500.042.2372, who represents the Office of Structural Materials for your project.

Inspected By:	Juvekar,Amit	Quality Assurance Inspector
Reviewed By:	Hall,Steven	QA Reviewer
