

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-014924**Date Inspected:** 26-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:** Zhou cheng**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.

BAY#19

FCAW welding of weld joint 2G-049 located on PCMK SB013-062 of Lift 8 SB62W welder is identified as 062783. ZPMC QC is identified as Mr. Zhou cheng. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2232-Tc-U4b-F.

FCAW welding of weld joint 2G-015 located on PCMK SB013-066 of Lift 8 SB66W welder is identified as 062749. ZPMC QC is identified as Mr. Zhou cheng. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2232-Tc-U4b-F.

This QA inspector performed 15% MT of weld 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 OBG Bike path.

The weld designations reviewed as follows

NWIT-005830.

BK004A3-004-017,018,041,042,060,061,056.

BK004A-004-008,009,060,035,019,056,082.

BK004A6-004-023,024,036.

BK004A8-004-023,024,035.

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During random in-process observation of the fabrication of OBG Bike paths identified as BK004A-008, BK004A-010, BK004A-011 this Caltrans Quality Assurance Inspector (QA) discovered the following issue:

-Build up with weld (Buttering) without an approved procedure.

For more information please see the Incident report

04-0120F4_TL-15_B247_05-26-09_Buttring_Without_CWR2.

BAY#16

FCAW welding of weld joint 1G-005 located on PCMK BP3075-001 of Lift 13 SEG13AW welder is identified as 201583. ZPMC QC is identified as Mr. Li ming yang. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2231-B-U3-F.

BAY#14

SMAW welding of weld joint 4F-177 located on PCMK SEG3004R of Segment 12AW welder is identified as 067764. ZPMC QC is identified as Mr. Zhong yong gang. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2114-FCM-1.

SMAW welding of weld joint 4F-194 located on PCMK SEG3004G of Segment 12AW welder is identified as 047864. ZPMC QC is identified as Mr. Zhong yong gang. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2114-FCM-1.

FCAW welding of weld joint 3G-001 located on PCMK SEG3004H of Segment 12AW welder is identified as 201215. ZPMC QC is identified as Mr. Zhong yong gang. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2233-B-U2-F.

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
