

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-015043**Date Inspected:** 12-May-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:	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:	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:

Subassembly, Bay 09, 13AW, Continuity Stiffener inside U-Rib.

FCAW welding of Fillet weld Partial Penetration joint DP3144-001-245-015, 014 & DP3144-001-246-023, 022 & DP3144-001-247-031, 030; located on subassembly, Bay 09, 13AW. Welder is identified as 040859; ZPMC Quality Control Inspector (QC) is identified as Sun Bo. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2133.

Subassembly, Bay 09, 13AW, Continuity Stiffener inside U-Rib.

FCAW welding of weld complete penetration joint DP3144-001-245-187, 188 & DP3144-001-246-189, 190 & DP3144-001-247-191, 192; located on subassembly, Bay 09, 13AW. Welder is identified as 040859; ZPMC Quality Control Inspector (QC) is identified as Sun Bo. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2233-TC-U4B-F.

Subassembly, Bay 09, 13AW.

During the Quality Assurance (QA) random in-process visual inspection, this QA inspector observed ZPMC Personnel performing Fit up for welding Deck panel to U-rib identified as DP3121-001-001 to 010. Welders welding tack welds are identified as 059446, 059401. Process identified as Gas Metal Arc Welding (GMAW).

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ZPMC Quality Control Inspector (QC) is identified as Sun Bo. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2342-U5(U-Rib).

Subassembly, Bay 09, 13AW, Deck Panel.

During Random Visual in process Inspection, this QA inspector observed ZPMC NDT personnel carrying out Magnetic Particle Testing (MT) on tack welds of deck panel to U-rib joints identified as DP3119-001-001 to 010. The attached photographs provide additional detail.

Subassembly, Bay 09, 13AW, Deck Panel U-ribs.

During Random Visual in process Inspection, this QA inspector observed ZPMC NDT personnel carrying out Ultrasonic Testing (UT) on 33mm Complete penetration joint on Continuity Stiffener inside U-Rib. Weld joints identified as DP3124-001-201, 202, 199, 200. The attached photographs provide additional detail.

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:	Carreon,Albert	QA Reviewer
