

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-015273**Date Inspected:** 29-Jun-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:** Xu tao / Li yan hua**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

During the Quality Assurance visual inspection the QA Inspector observed that the ZPMC personnel performing heat straightening of Bike path bearing plate is identified as BK006A-001 is appeared to comply with the HSR1 (B)-8699.

FCAW welding of weld joint 2F-001 located on PCMK SBDP-P3-009 of Lift 8 the welder is identified as 062807. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2132.

FCAW welding of weld joint 2G-002 located on PCMK SBDP-P3-015 of Lift 8 the welder is identified as 062807. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2332-Tc-P4-F.

OUTSIDE SHOP

11AE

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as Segment 11AE.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

SSD19A-PP96-128- Reject able indication found. Incident report made for this weld.

SEG066A-003.

SEG066B-019,003,004,020.

SEG066C-003,004,019,020.

SSD19A-PP96-134,131,106.

During the Quality Assurance Ultrasonic Testing (UT) review of welds located on Segment 11AE, this Quality Assurance Inspector (QA) discovered the following issue:

-One (1) Class “A” reject able indication measuring approximately 20mm in length.

-The weld is a Complete Joint Penetration (CJP) ‘T’ joint joining Floor beam flange FL2-2 (FB4A) to Floor beam flange FL-1 (FB10B).

-The db rating is +8.

For more information please see the incident report of

04-0120F4_TL-15_B247_06-29-10_11AE__UT_Rejectable_Indication

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
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Reviewed By:	McClendon,Timothy	QA Reviewer
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