

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-015296**Date Inspected:** 26-Jun-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:** Chen Shingong.**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, DP3124-001.

During the Quality Assurance (QA) random in-process visual inspection, this QA inspector observed ZPMC Personnel performing excavation of the phased array Ultrasonic Testing (PAUT) repair area. Welds being excavated identified as DP3124-001-002, 006.

Subassembly, Bay 09, Gantry# 2, 13BE, Deck Plate to U-rib.

GMAW welding of Partial Penetration weld joints DP3089-001-001 to 016; located on Bay 09, Gantry# 2. Welder is identified as 059418, 059421, 059416, 201788; ZPMC Quality Control Inspector (QC) is identified as Chen Shi Gang. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2342-U1(U-rib)-5.

During welding due to some malfunctioning welding has been stopped at one (1) location. ZPMC marked this location & ZPMC NDT personnel "Wang Wei" carried out Magnetic Particle Testing (MT) at the "Stop" location of the weld. The locations & respective weld identification are as follows

DP3089-001-009, 010; Y location: 2680mm.

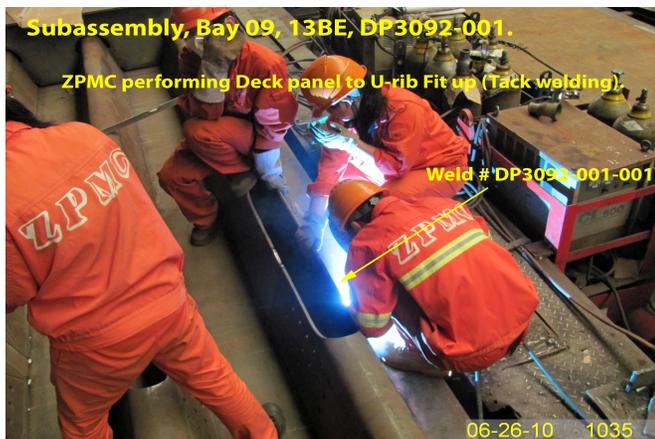
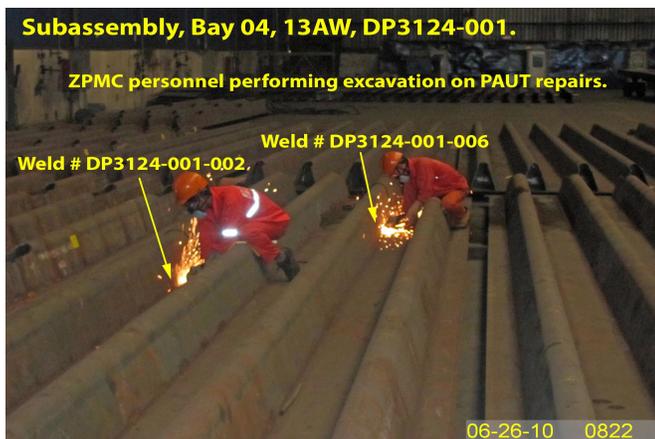
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Subassembly, Bay 09, 13BE, DP3092-001.

During the Quality Assurance (QA) random in-process visual inspection, this QA inspector observed ZPMC Personnel performing Fit up for welding on Deck panel & U-ribs identified as DP3092-001. Welder welding tack welds is identified as 062305. Process identified as Gas Metal Arc Welding (GMAW). ZPMC Quality Control Inspector (QC) is identified as Chen Shingong. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2342-U5 (U-Rib).

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

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Reviewed By: Carreon,Albert

QA Reviewer