DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Vallejo, CA 94592-1133
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-015743
Date Inspected: 18-Jul-2010

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 645
OSM Departure Time: 1845
Location: Shanghai, China

CWI Name: Yang Bai Qing.

Inspected CWI report:	☐ Yes	☑ No	☐ N/A
Electrode to specification:	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A

CWI Present:	☑ Yes	☐ No	
Rod Oven in Use:	☐ Yes	☐ No	☑ N/A
Weld Procedures Followed:	☑ Yes	☐ No	☐ N/A
Verified Joint Fit-up:	☑ 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.

Subassembly, Bay 04, 13CW, Deck panel to U-rib.

FCAW Repair welding of partial penetration weld joints DP3148-001-002, 004, 005, 007, 008, 015; located on subassembly, Bay 04, 13CW. Welder is identified as 203805; ZPMC Quality Control Inspector (QC) is identified as Guo Yan Fei. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-345-FCAW-2G(2F)-FCM-REPAIR. The attached photographs provide additional detail.

Y-Locations of repairs were;
W002 – 2450, 4800mm.
W004 – 2450, 3050mm.
W005 – 650, 1250, 1850mm.
W007 – 650, 1250, 1850mm.
W006 – 650, 1250, 1850mm.
W008 – 650, 1250, 1850mm.
W015 – 650mm.

This QA Inspector carried out NDE on following
Subassembly, Bay 04, U-Rib to Deck Plate welds.

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This QA inspector performs Random Visual Testing (VT) & random Magnetic Particle Testing (MT) of approximately 15% area previously tested and accepted by ZPMC Quality Control personnel (Notification # 06222). This QA Inspector generated an MT report (TL-6028) for this date. The members are identified as DP3079(PL3175A)-001; Green tag # 11868.

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