

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-016371**Date Inspected:** 21-Aug-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 Shi Gang.**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.

Subassembly, Bay 09, Gantry# 1, 14E, Deck Plate to U-rib.

GMAW welding of Partial Penetration weld joints DP3161-001-001 to 016; located on Bay 09, Gantry# 1. Welder is identified as 059443, 201788, 059403, 059416; 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 random visual inspection of tack weld on above panel; this QA inspector observed ZPMC tack welded an extra tack in between two assigned tack weld locations. The Y-locations & respective weld identification are as follows,

DP3161-001-001; approximate Y location: 11280mm.

DP3161-001-004; approximate Y location: 11280mm.

DP3161-001-005; approximate Y location: 11280mm.

DP3161-001-008; approximate Y location: 11280mm.

This QA inspector marked all of the above locations with paint-marker on the deck panel.

Subassembly, Bay 09, 14E, Continuity Stiffener inside U-Rib.

FCAW welding of weld complete penetration joint DP3157-001-138, 141, 162, 165; located on subassembly, Bay 09, 14E. Welder is identified as 062265, 059378; ZPMC Quality Control Inspector (QC) is identified as Chen

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Shi Gang. 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, 14E, Continuity Stiffener inside U-Rib.

FCAW welding of Fillet weld Partial Penetration joint DP3157-001-139, 140, 163, 164; located on subassembly, Bay 09, 14E. Welder is identified as 062265, 059378; 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-2133.

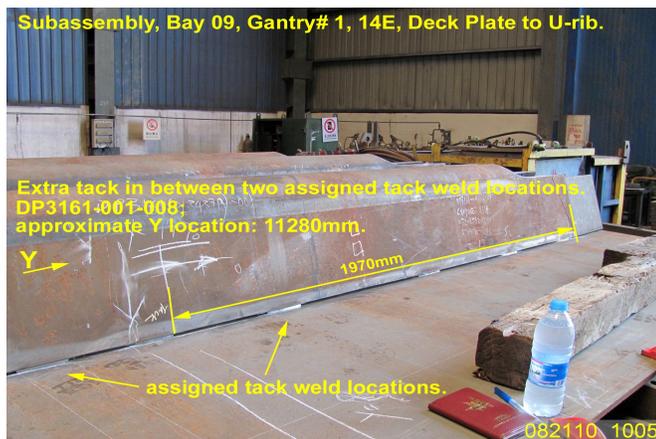
Subassembly, Bay 09, Gantry# 1, 14E, Deck Plate to U-rib.

SAW welding of Partial Penetration weld joints DP3161-001-007, 008, 015, 016; located on Bay 09, Gantry# 1. Welder is identified as 059403, 059416; ZPMC Quality Control Inspector (QC) is identified as Chen Shigang. 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 two (2) locations. ZPMC marked those locations & AB/F NDT personnel “Chu Ziqing” carried out Magnetic Particle Testing (MT) at the “Stop” location of the weld. The locations & respective weld identification are as follows

DP3161-001-011, 12; Y location: 110mm.

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.

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Inspected By:	Juvekar,Amit	Quality Assurance Inspector
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Reviewed By:	Carreon,Albert	QA Reviewer
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