

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-016434**Date Inspected:** 24-Aug-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:	Wu shi gao / 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

FCAW welding of repair weld joint 2G-004 located on PCMK SB016-076 of SB76W the welder is identified as 062794. ZPMC QC is identified as Mr.Xu tao. The welding variables recorded by QC appeared to Comply with the WPS-345-FCAW-2G (2F)-repair.

During back gouging of rejected CJP weld by ZPMC UT in SB74E, it is observed by visually 3 transverse indication of length 15~30 appr the weld is identified as SB019-074-019.

One transverse indication of length 30mm found, the weld is identified as SB019-074-004.

All these indications observed by visually and confirmed with MT. For more information please see the photos.

During back gouging of rejected CJP weld by ZPMC UT in SB76W, it is observed that by visually Base metal discontinuity of app 10mm in length. For more information please see the photos.

This QA inspector performed UT 10% of weld areas previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an UT report for this date. The members are identified as OBG Suspender bracket. The weld designations reviewed as follows.

SB76E

SB019-076-025,037,008,018,001,020,011,005,031,043,004,007.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

OUTSIDE SHOP

12AE

SMAW welding of weld joint 3F-057 located on PCMK SEG3001J of the Segment 12AE welder is identified as 215553. ZPMC QC is identified as Mr. Wu shi gao. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2113-FCM-1.

SMAW welding of weld joint 3F-062 located on PCMK SEG3001M of the Segment 12AE welder is identified as 050232. ZPMC QC is identified as Mr. Wu shi gao. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2113-FCM-1.

BAY#14

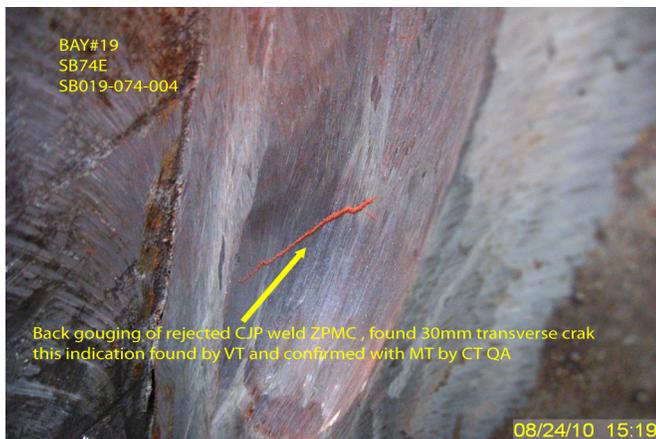
SMAW welding of weld joint 4F-143 located on PCMK FB3056-001 of segment 12AW the welder is identified as 051348. ZPMC QC is identified as Mr. Wang Xian pin. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2114-FCM-1.

SMAW welding of weld joint 2F-039 located on PCMK FB3055-001 of Segment 12AW the welder is identified as 051348. ZPMC QC is identified as Mr. Wang xian pin. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2114-FCM-1.

FCAW welding of weld joint 3G-005 located on PCMK SEG3004 of Segment 12AW the welder is identified as 202122. ZPMC QC is identified as Mr. Wang xian pin. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2233-Tc-U4b-F.

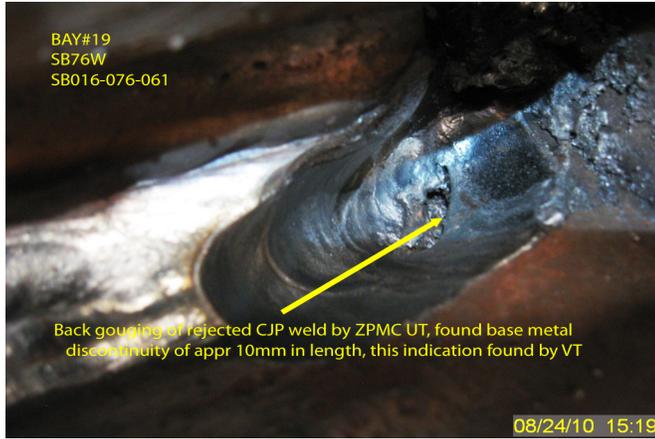
FCAW welding of weld joint 3G-040 located on PCMK SEG3004 of Segment 12AW the welder is identified as 201215. ZPMC QC is identified as Mr. Wang xian pin. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2233-Tc-U4b-F.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



WELDING INSPECTION REPORT

(Continued Page 3 of 3)



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
Reviewed By:	McClendon,Timothy	QA Reviewer
