

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-016475**Date Inspected:** 26-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 / Wang jie	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 weld joint 2F-032 located on PCMK SB020-080 of SB80E the welder is identified as 062806. 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 2F-026 located on PCMK SB020-082 of SB82E the welder is identified as 062783. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2132.

SMAW welding of weld joint fit-up of 2F-026,032 located on PCMK SB019-072 and SB016-076 of SB74E & SB76W the welder is identified as 062797. ZPMC QC is identified as Mr. Xu tao. The welding variables and fit-up dimension recorded by QC appeared to Comply with the WPS-B-P-2112.

During random in-process observations of the fabrication of OBG Bike path BK004-011, this Caltrans Quality Assurance (QA) Inspector discovered the following issue:

-ZPMC personnel have performed wrap around welds of the Stringer to Bearing plate fillet weld joints.

- The welds are identified as

BK004A3-011-030,031,056,057,021,022,045,046.

BK004A4-011-019,020,045,046,071,072,004,005,032,033,056,057.

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For more information please see the Incident report

04-0120F4_TL-15_B247_08-26-10_BK004-011__Wrap_around_Fillet_weld_Ends

BAY#14

SAW welding of weld joint 1G-002 located on PCMK SEG3014N of Segment 13BW the welder is identified as 0455270. ZPMC QC is identified as Mr. Xia chun hui. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2221-B-L2c-S-2.

FCAW welding of weld joint 3G-054 located on PCMK SEG3004K of Segment 12AW the welder is identified as 047866. ZPMC QC is identified as Mr. Wang wei ming. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2233-Tc-U4b-F.

FCAW welding of weld joint 3G-166 located on PCMK SEG3004G of Segment 12AW the welder is identified as 201215. ZPMC QC is identified as Mr. Wang wei ming. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2233-Tc-U4b-F.

OUTSIDE SHOP

FCAW welding of weld joint 3G-021 located on PCMK SEG3001R of Segment 12AE the welder is identified as 458087. ZPMC QC is identified as Mr. Wang xian pin. The welding variables recorded by QC appeared to Comply with the WPS-345-FCAW-3G(3F)-Repair and WR-11928.

SMAW welding of repair weld joint 4G-006 located on PCMK SEG3001W of Segment 12AE the welder is identified as 044772. ZPMC QC is identified as Mr. Wang xian pin. The welding variables recorded by QC appeared to Comply with the WPS-345-SMAW-4G(4F)-Repair and WR-12366.

BLAST SHOP#1

Caltrans Quality Assurance (QA) Inspectors performed random visual inspection of OBG segment 11AE Inside Bottom panel, side panel and longitudinal diaphragm surfaces from the panel point 95 to 97 after grit blasting. Areas requiring additional grinding were marked by QA and repaired by ZPMC personnel.

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

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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