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

Bay Area Branch
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Contract #: 04-0120F4
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-016722
Date Inspected: 28-Aug-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 Qian.			**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 04, 14W, Deck panel to U-rib.

During Random Visual in process Inspection, this QA inspector observed ZPMC personnel carrying out Weld repairs after visual testing on Deck panel to U-rib welds of Deck Panel DP3174-001. Repair carried out with Flux core arc welding (FCAW). Welder is identified as 203805; ZPMC Quality Control Inspector (QC) is identified as Yang Bai Qian. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-345-FCAW-2G(2F)-FCM-REPAIR.

Welds & Approximate Y-locations of repair were;
W001 – 3050mm.

Subassembly, Bay 04, 14E, Bottom Plate.

During Random Visual in process Inspection, this QA inspector observed ZPMC personnel Heat Straightening Bottom Plate BP3082-001. ZPMC QC “Shen Jian Guo” showed Heat Straightening Report HSR1 (B) # 9228. The attached photographs provide additional detail.

Subassembly, Bay 04, 14W, Deck panel to U-rib.

FCAW Repair welding of partial penetration weld joints DP3174(PL3487B)-001; located on subassembly, Bay 04, 14W. Welder is identified as 062265; ZPMC Quality Control Inspector (QC) is identified as Yang Bai

Qian. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-345-FCAW-2G(2F)-FCM-REPAIR.

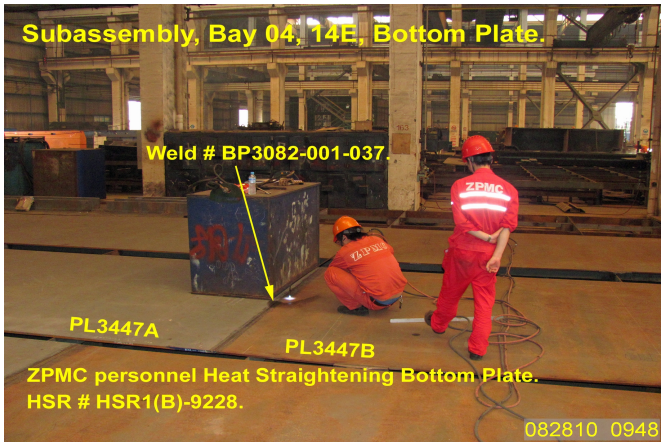
Welds & Approximate Y-locations of repair were;
W012 – 5300mm.
W014 – 5300mm.

Subassembly, Bay 04, 14E, Deck panel to U-rib.

FCAW Repair welding of partial penetration weld joints DP3160(PL3487B)-001; located on subassembly, Bay 04, 14E. Welder is identified as 062265; ZPMC Quality Control Inspector (QC) is identified as Yang Bai Qian. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-345-FCAW-2G(2F)-FCM-REPAIR.

Welds & Approximate Y-locations of repair were;
W022 – 50mm.
W021 – 1850, 2950mm.

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

WELDING INSPECTION REPORT

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Reviewed By: Carreon,Albert QA Reviewer