

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:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016839**Date Inspected:** 19-Sep-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:** Gu yan Fei.**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, Deck panel connection plate.

FCAW welding of weld joint SA3084B-025-005, 006; located on assembly, Bay 04. Welder is identified as 062265; ZPMC Quality Control Inspector (QC) is identified as Gu yan Fei. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2231-B-U2-F.

Subassembly, Bay 04, Deck Panel 14E-DP3157-001.

QA inspector performed conventional Ultrasonic Testing (UT) Inspection of approximately 10% for Lack of Penetration (LOP) on deck panel (U-rib to deck plate) Partial Penetration weld areas previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated UT report for this date. The members are identified as Deck Panel. The weld designations reviewed are DP3157-001-001 to 012.

Subassembly, Bay 04, Deck Panel 14W-DP3170-001.

QA inspector performed conventional Ultrasonic Testing (UT) Inspection of approximately 10% for Lack of Penetration (LOP) on deck panel (U-rib to deck plate) Partial Penetration weld areas previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated UT report for this date. The members are identified as Deck Panel. The weld designations reviewed are DP3170-001-001 to 016

Subassembly, Bay 04, Deck panel connection plate.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

FCAW welding of weld joint SA3084B-030-005, 006; located on assembly, Bay 04. Welder is identified as 062265; ZPMC Quality Control Inspector (QC) is identified as Gu yan Fei. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2231-B-U2-F.

Subassembly, Bay 04, Deck panel connection plate.

FCAW welding of weld joint SA3084B-034-005, 006; located on assembly, Bay 04. Welder is identified as 062265; ZPMC Quality Control Inspector (QC) is identified as Gu yan Fei. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2231-B-U2-F.

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
