

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-016910**Date Inspected:** 01-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:** Gong Wai**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 COMPONENT**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

In process Inspection

Bay #14

This QA Inspector observed the following work in progress:

SAW in the 1G position for the OBG Segment 13CE, weld No. SEG3011A-009. The welder is identified as #044771. ZPMC QC is identified as Mr. Zhang Ling. The welding variables recorded by QC appear to comply with WPS-B-T-2221-B-L2c-S-2.

FCAW in the 1G position for the OBG Segment 13BW, weld No. SEG3014A-002. The welder is identified as #201215. ZPMC QC is identified as Mr. Zhang Ling. The welding variables recorded by QC appear to comply with WPS-B-T-2231-B-U2-F.

SAW in the 1G position for the OBG Segment 13CE, weld No. SEG3011A-006. The welder is identified as #044780. ZPMC QC is identified as Mr. Zhang Ling. The welding variables recorded by QC appear to comply with WPS-B-T-2221-B-L2c-S-2.

SAW in the 1G position for the OBG Segment 13BW, weld No. SEG3014A-004. The welder is identified as

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#045270. ZPMC QC is identified as Mr. Zhang Ling. The welding variables recorded by QC appear to comply with WPS-B-T-2221-B-L2c-S-2.

SMAW in the 3G position for the OBG Segment 12BW, UT repair weld No. DP3056-001-013. The welder is identified as #045133. ZPMC QC is identified as Mr. Guo Xing Hui. The welding variables recorded by QC appear to comply with WPS-345-SMAW-3G(3F)-REPAIR.

SMAW in the 3G position for the OBG Segment 12BW, UT repair weld No. DP3056-001-019. The welder is identified as #045268. ZPMC QC is identified as Mr. Guo Xing Hui. The welding variables recorded by QC appear to comply with WPS-345-SMAW-3G(3F)-REPAIR.

Bay #16

This QA Inspector observed the following work in progress:

FCAW in the 2F position for the OBG Segment 13CW Longitudinal Diaphragm to stiffener, weld No. LD3036-001-199/200. The welders are identified as #201583/#040344. ZPMC QC is identified as Mr. Xin Chun Hui. The welding variables recorded by QC appear to comply with WPS-B-T-2132.

FCAW in the 2F position for the OBG Segment 13CW Longitudinal Diaphragm to stiffener, weld No. LD3036-001-319/320. The welders are identified as #201583/#040344. ZPMC QC is identified as Mr. Xin Chun Hui. The welding variables recorded by QC appear to comply with WPS-B-T-2132.

During random visual inspection at bay#16 the QA Inspector observed ZPMC personnel cutting Bearing Pad Holes (75mm diameter) on bottom plate BP3074A with automatic Flame gas cutting device for segment 13AW.

Out Side

This QA Inspector observed the following work in progress:

SMAW in the 4G position for the OBG Segment 12AE, UT repair weld No. SEG3001*-019. The welder is identified as #044772. ZPMC QC is identified as Mr. Wu Shi Gao. The welding variables recorded by QC appear to comply with WPS-345-SMAW-4G(4F)-FCM-REPAIR. The repair report is identified as B-WR-12655.

Visual Inspection after Blast at 10BW

This Quality Assurance (QA) Inspector performed random visual inspection of OBG segment 10BW internal side panel, floor beam and bottom panel surfaces after grit blasting in between panel point PP89 to PP90. Areas that marked for repair were recorded for future repair. 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 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 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By: Bera,Subhasis

Quality Assurance Inspector

Reviewed By: Patterson,Rodney

QA Reviewer
