

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-017064**Date Inspected:** 28-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:** Chen Xi.**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 02, 14W, Longitudinal Diaphragm.

During Random Visual in process Inspection, this QA inspector observed ZPMC personnel Heat-straightening Longitudinal Diaphragm. Longitudinal Diaphragm weld being Flame heated is identified as LD3040-001-008. Heat Straightening report (HSR) number identified as HSR1(B)-9465. The attached photographs provide additional detail.

Subassembly, Bay 03, Floor Beam Stiffener.

FCAW welding of weld joint FB3265-001-90, 91; located on assembly, Bay 03. Welder is identified as 214945, 206623; ZPMC Quality Control Inspector (QC) is identified as Chen Xi. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2132-3.

Subassembly, Bay 02, Steel Barrier.

FCAW welding of weld joint E5-SB10-003-100, 101; located on assembly, Bay 02. Welder is identified as 045276; ZPMC Quality Control Inspector (QC) is identified as Tian Lei. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2133.

This QA Inspector carried out NDE on following
Subassembly, Bay 07.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

This QA inspector performs Random Visual Testing (VT) of area previously tested and accepted by ZPMC Quality Control personnel (Notification # 06788). The members are identified as

- 1) W2-SB1G-008, 012, 002, 004.
- 2) W2-SB1-014, 013, 011, 012, 009, 016, 008, 017.

During random visual inspection this QA inspector marked locations need repair. QA inspector informed ZPMC QA “Zhong Wei” about this issue. ZPMC agreed to repair all marked visual repairs locations. ZPMC postponed inspection till they finish all repairs.

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



Summary of Conversations:

Subassembly, Bay 07.

During random visual inspection QA inspector marked locations needed to be repaired. ZPMC agreed to repair marked repair locations. ZPMC QA "Zhong Wei" informed to this QA inspector that; ZPMC will renotify for the same inspection (NWIT#06788) after completing repairs.

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
