

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-020029**Date Inspected:** 21-Apr-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:	Geng Wei, Zhu Zhong Hai, Xu Tao			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
Bridge No:	34-0006			Delayed / Cancelled:	Yes	No	N/A
				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.

This QA Inspector observed the following work in progress:

Assembly, Bay 14, 12CW, Corner Assembly, Side plate to Edge plate.

FCAW welding of weld joint CA3010-004; located on assembly, Bay 14, 12AW. Welder is identified as 048696, 058245; ZPMC Quality Control Inspector (QC) is identified as Zhu Zhong Hai. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2231-TC-U4B-F.

Assembly, Bay 14, 12AE, Deck Pannel DP3004A.

During Random Visual in process Inspection, this QA inspector observed ZPMC personnel Heat Straightening Deck Pannel DP3004A. ZPMC QC Li Ming Yang showed Heat Straightening Report HSR # 8305. The attached photographs provide additional detail.

Assembly, Bay 14, 12AE, Stiffener on Longitudinal Diaphragm.

SMAW welding of weld joint SEG3003V-0006, 008; located on assembly, Bay 14, 12AE. Welder is identified as 200113; ZPMC Quality Control Inspector (QC) is identified as Geng Wei. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-P-2114-FCM-1.

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Assembly, Bay 14, 11DE, X35 Stiffener.

SMAW welding of weld joint SEG072D-080, 81; located on assembly, Bay 14, 11DE. Welder is identified as 067656, 049339; ZPMC Quality Control Inspector (QC) is identified as Geng Wei. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-P-2114-FCM-1.

Assembly, Bay 14, 11EW, Corner Assembly to Side plate.

FCAW welding of weld joint SEG073-001; located on assembly, Bay 14, 12EW. Welder is identified as 66361, 66038; ZPMC Quality Control Inspector (QC) is identified as Zhu Zhong Hai. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-P-2214-B-U2-FCM-1.

This QA Inspector carried out NDE on following
Bay 16, Tower Facade.

This QA inspector performs Random Visual Testing (VT) & Magnetic Particle Testing (MT) of approximately 15% area previously tested and accepted by ZPMC Quality Control personnel (Notification # 005565). This QA Inspector generated an MT report (TL-6028) for this date. The members are identified as

- 1) SL3-28-12, 10, 23, 26. (Padeye of Facade)
- 2) ED1-A227-4-1, 2, 3.
- 3) ED1-A206-4-1, 2.
- 4) ED1-A204-7-1, 2, 3, 4, 5, 6, 7, 8.
- 5) ED1-A222-7-1, 2, 3.
- 6) WD1-A224-3-4, 10, 20.
- 7) WD1-A145-4-1.
- 8) ED1-A204-8-1, 2, 3, 4, 5, 6, 7, 8.
- 9) ED1-A222-8-1, 2, 3.

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



Summary of Conversations:

No relevant conversations.

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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:	Miller,Mark	QA Reviewer
