

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-020061**Date Inspected:** 13-Mar-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:	Liu Hua Jie, Lu Li Qing, Geng Wei			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.

This QA Inspector observed the following work in progress:

Assembly, Bay 14, 11DE, SEG072.

SMAW welding of weld joint SEG072*-47; located on assembly, Bay 14, 11DE. Welder is identified as 068764; ZPMC Quality Control Inspector (QC) is identified as Lu Li Qing. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-P-2214-TC-U4B-FCM-1.

Assembly, Bay 14, 11DE, SEG072.

SMAW welding of weld joint SEG072*-009, 010, 026, 024; located on assembly, Bay 14, 11DE. Welder is identified as 044772, 037748, 067656, 037848; ZPMC Quality Control Inspector (QC) is identified as Lu Li Qing. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-P-2214-TC-U4B-FCM-1.

Assembly, Bay 14, 12BE, Deck plate (DP3017A) to Deck plate (DP3016A).

SAW welding of weld joint SEG3002*-005; located on assembly, Bay 14, 12BE. Welder is identified as 058100; ZPMC Quality Control Inspector (QC) is identified as Lu Li Qing. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2221-LC-S-1.

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Assembly, Bay 14, Traveler rail.

FCAW Repair welding of weld joint 10TR3-035(CWR # B-CWR1086); located on assembly, Bay 14. Welder is identified as 044795, 208035; ZPMC Quality Control Inspector (QC) is identified as Lu Li Qing. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-345-FCAW-2G(2F)-REPAIR.

Assembly, Bay 14, 12AE, Edge Plate.

During Random Visual in process Inspection, this QA inspector observed fit up of Edge Plate EP3004B. The attached photographs provide additional detail.

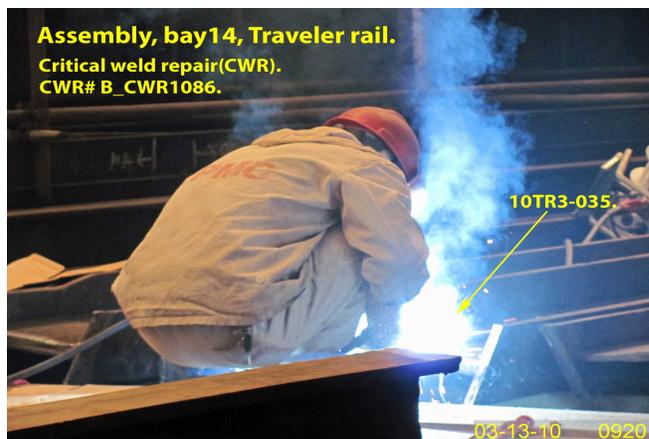
Assembly, Bay 14, 12CW, Bottom plate to Side plate.

SMAW Repair welding of weld joint SEG3006A-001, 009, 002(WRR # B-WR1106/1108/1107); located on assembly, Bay 14, 12CW. Welder is identified as 004864, 045246; ZPMC Quality Control Inspector (QC) is identified as Liu Hau Jie. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-345-SMAW-4G (4F)-FCM-REPAIR-1.

Training for Phased Array Ultrasonic Testing.

This QA inspector attended Training for Phased Array Ultrasonic Testing (PAUT) from 1600Hrs. to 1900Hrs.

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



Summary of Conversations:

12CW, Bottom plate to Side plate (WRR # B-WR1106/1108/1107):

This QA inspector observed ZPMC repairing above mentioned weld joint without any weld repair report (WRR or CWR) on site. ZPMC QC “Li Ming Yang” showed Ultrasonic Inspection report upon asking for weld repair report. Per ZPMC Quality Control (QC) inspector; ZPMC was not able to produce report since responsible personnel was on holiday due to week-end. ZPMC QC agreed to produce proper weld repair report on Monday (Date: 03-15-10). Keeping in mind that not to slow production down this QA inspector agreed to see report on Monday (Date: 03-15-10) & let ZPMC proceed with the repair.

Comments

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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
