

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-020068**Date Inspected:** 05-Mar-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:** Liu Hua Jie, Lu Li Qing.**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, 11DW, SEG071A.

SMAW welding of weld joint SEG071A-015, 009; located on assembly, Bay 14, 11DW. Welder is identified as 37723, 045246; 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, 12CW, Corner Assembly (South side), Deck plate to Edge plate.

FCAW welding of weld joint CA3011-004(PP116 to PP117); located on assembly, Bay 14, 12CW. Welder is identified as 045175; 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-2232-TC-U4B-F.

Assembly, Bay 14, Traveler rail.

During Random Visual in process Inspection, this QA inspector observed ZPMC personnel performing Heat Straightening on Traveler rail identified as 11TR1-007. The attached photographs provide additional detail.

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Assembly, Bay 13, 11CE.

Segment 11CE moved to Trial Assembly Yard for further processing. The attached photographs provide additional detail.

Assembly, Bay 14, 11DE, SEG072.

SMAW welding of weld joint SSD24-PP104.5-123 to 128; located on assembly, Bay 14, 11DE. Welder is identified as 044772; 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-2114-FCM-1.

Assembly, Bay 14, 12BW, Near PP114.

During Random Visual in process Inspection, this QA inspector observed fit-up of Longitudinal Diaphragm identified as LD3022. The attached photographs provide additional detail.

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

During Random Magnetic Particle Testing (MT) in process Inspection after back gouging, this QA inspector observed following;

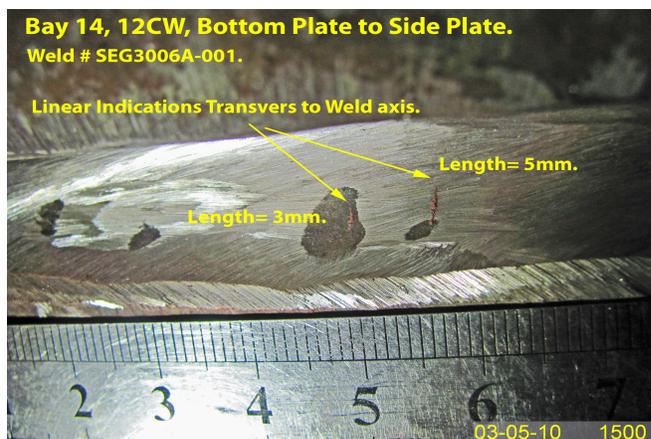
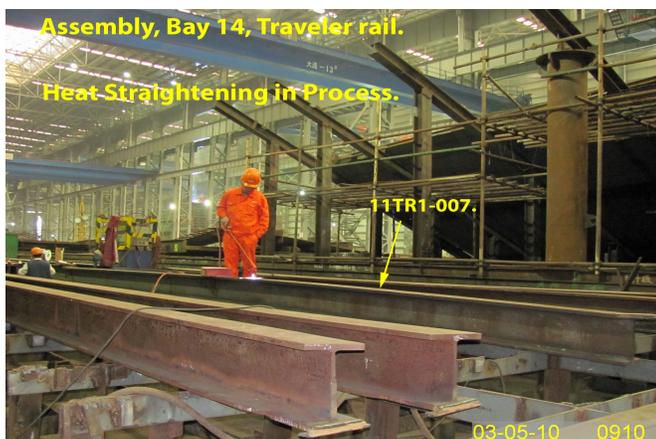
- Welds are identified as SEG3006A-001, 009, 011.
- This QA inspector observed five (5) linear indications transverse to the weld axis on four (4) different locations.
- Indications are marked with Yellow paint marker.
- This QA inspector also informed ZPMC QC & AB/F inspector about this.
- The attached photographs provide additional detail.

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, 1500.042.2372, who represents the Office of Structural Materials for your project.

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Inspected By:	Juvekar,Amit	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer
