

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-002226**Date Inspected:** 26-Apr-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Sun 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:** Tower Skin Plates**Summary of Items Observed:**

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

Bay 1-New Tower Building

The QA Inspector randomly observed ZPMC qualified welder Ms. Xu Xiushui, ID #040489, performing groove welding of weld joint SSD1-SA16F/G-88A filler passes. Ms. Xu was observed welding in the 1G (flat) position utilizing a Submerged Arc Welding (SAW) process with a 4.8mm diameter electrode, filler metal brand LA-85, class MIL800-HPNI machine.

The QA Inspector randomly observed ZPMC qualified welder Ma Ying, ID #045270, performing groove welding of weld joint SSD1-173J/K-8B filler passes. Ms. Ma was observed welding in the 1G (flat) position utilizing a Submerged Arc Welding (SAW) process with a 4.8mm diameter electrode, filler metal brand LA-85, class MIL800-HPNI machine.

Bay 2-New Tower Building

The QA Inspector randomly observed ZPMC qualified welder Ms. Xue Yi An, ID #040634, performing groove welding of weld joint ESD1-SA216A/K-13A filler passes. Ms. Xue was observed welding in the 1G (flat) position utilizing a Submerged Arc Welding (SAW) process with a 4.8mm diameter electrode, filler metal brand LA-85, class MIL800-HPNI machine.

The QA Inspector randomly observed ZPMC qualified welder Ms. Cao Gui Mei, ID #047304, performing groove

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

welding of weld joint ZSD1-SA233A/F-20A filler passes. Ms. Cao was observed welding in the 1G (flat) position utilizing a Submerged Arc Welding (SAW) process with a 4.8mm diameter electrode, filler metal brand LA-85, class MIL800-HPNI machine.

The QA Inspector randomly observed ZPMC qualified welder Ms. Shen Mei, ID #041716, performing groove welding of weld joint ESD1-SA227A/H-14B filler passes. Ms. Shen was observed welding in the 1G (flat) position utilizing a Submerged Arc Welding (SAW) process with a 4.8mm diameter electrode, filler metal brand LA-85, class MIL800-HPNI machine.

The QA Inspector randomly observed ZPMC qualified welder Ms. Cao Xiao Hua, ID #056975, performing groove welding of weld joint ZSD1-SA227A/H-17B filler passes. Ms. Cao was observed welding in the 1G (flat) position utilizing a Submerged Arc Welding (SAW) process with a 4.8mm diameter electrode, filler metal brand LA-85, class MIL800-HPNI machine.

Bay 3- New Tower Building

The QA Inspector randomly observed ZPMC qualified welder Ms. Yuen Feng Chuan, ID #059355, performing groove welding of weld joint DP246-001-189. Ms. Yuen was observed welding in the 1G (flat) position utilizing a Submerged Arc Welding (SAW) process with a 4.8mm diameter electrode, filler metal brand LA-85, class MIL800-HPNI machine.



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 Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Clifford, William

Quality Assurance Inspector

Reviewed By: Cuellar, Robert

QA Reviewer