

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-005452**Date Inspected:** 09-Feb-2009**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:** Luan Zhao Gang**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:** OBG Assembly**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.

Paint Shop**Segment 3AW**

This QA Inspector performed a preliminary random visual inspection after the grit blast of the internal components of the deck panel and corner assemblies of this segment. Areas of visual weld defects that will require welding were taped and will be repaired after the coating is applied. ZPMC QC personnel are aware of these areas and were present during the inspection.

Segment Repair Yard (North of the paint shop)**Segment 3AE**

This QA Inspector observed the following work in progress:

Flux Cored Arc Welding (FCAW) in the 2G position of the lifting lug vertical side plates at panel point 20. The welder is identified as #058551. ZPMC QC is identified as Mr. Luan Zhao Gang. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-TC-U5-F.

Shielded Metal Arc Welding (SMAW) in the 4G position of the lifting lug vertical side plates at panel point 20.

The welder is identified as #200114. ZPMC QC is identified as Mr. Luan Zhao Gang. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-TC-U5-b.

WELDING INSPECTION REPORT

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Segment 3BE

This QA Inspector observed that there was no work being done on this segment at the time of inspection.

Segment 4AE

This QA Inspector observed that there was no work being done on this segment at the time of inspection.

Segment Repair Yard (South of the paint shop)

Segment 4AW

This QA Inspector observed the following work in progress:

Flux Cored Arc Welding (FCAW) in the 1G position of the lug plate fillet weld attachments to the T-rib stiffeners at panel point 25. The welder is identified as #066399. ZPMC QC is identified as Mr. Geng Wei. The welding variables recorded by QC appeared to comply with the applicable WPS.

Segment 5CE

This QA Inspector observed that there was no work being done on this segment at the time of inspection.

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

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 Ryan Smith, (858) 232-6799, who represents the Office of Structural Materials for your project.

Inspected By:	Patterson,Rodney	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
