

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-007322**Date Inspected:** 01-May-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:** Shi Lie**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:** Shi Lin**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the time noted above for observations relative to the work being performed.

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This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an MT report for this date. The member is Segment Assembly (6AE) Components. The weld designations reviewed as follows:

LD015-013-01.

LD004-020-01.

FB003-045-05,90,45,80,83,86.

FB014-014-12,13,17,18.

FB012-011-12,16.

FB010-007-21,22,37,38.

FB016-010-47,49,16,37,22.

FB003-003-06,71,63,75,82.

FB013-005-24,25,30.

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On going FCAW Welding of Weld Joint 1G-231 Located on SSD18-PP52 on SEG036 Welder no indentified as

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068087 and The welding variables recorded by QC ZMPC Mr. Zhang Xianji to comply with the WPS-B-T-2231-TC-U4C-F.

On going FCAW Welding of Weld Joint 2F-05 Located on SSD19-PP49 on SEG034 Welder no indentified as 068596 and The welding variables recorded by QC ZMPC Mr. Zhang Xianji to comply with the WPS-B-T-2132.

Unless otherwise noted, all 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 Eric Tsang-150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar, Chadra	Quality Assurance Inspector
Reviewed By:	Clifford, William	QA Reviewer
