

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-007817**Date Inspected:** 24-May-2009**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:** Luan Zhae 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 Trial Assembly**Summary of Items Observed:**

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

OBG Trial Assembly Area

This QA Inspector observed ZPMC welding personnel performing Flux Core Arc Welding (FCAW) of the Complete Joint Penetration (CJP) deck, edge, side and floor panel splice welds as well as deck, edge, side and floor panel stiffeners between segment assemblies designated as 4AE+4BE, 2AE+2BE and 2AW+2BW. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedures as follows:

Monitoring of welding personnel qualifications in accordance with the applicable Welding Procedure Specifications as follows:

Welders Name: Li Guimin

Welder ID # 220069

Process Qualified: FCAW

Position Qualified: 3G

Expiration Date: 03-20-2012

Welders Name: Cao Caijun

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Welder ID # 220064
Process Qualified: FCAW
Position Qualified: 3G
Expiration Date: 03-29-2012

Welders Name: Shen Wei
Welder ID # 218976
Process Qualified: FCAW
Position Qualified: 3G
Expiration Date: 03-20-2012

Welders Name: Liu Huang
Welder ID # 218958
Process Qualified: FCAW
Position Qualified: 3G
Expiration Date: 03-09-2012

Welders Name: Li Xuehau
Welder ID # 200676
Process Qualified: FCAW
Position Qualified: 3G
Expiration Date: 03-20-2012

Welders Name: Cao Chuchu
Welder ID # 220061
Process Qualified: FCAW
Position Qualified: 3G
Expiration Date: 03-29-2012

Welders Name: Zhou Pan
Welder ID # 220063
Process Qualified: FCAW
Position Qualified: 3G
Expiration Date: 03-29-2012

This QA Inspector observed activity that did not appear to comply with project requirements. See submitted Incident Reports.

This QA Inspector reviewed the contract files and tracking logs for the Magnetic Particle Testing (MT), Ultrasonic Testing (UT), Welding Procedure Specifications (WPS), Procedure Qualification Records (PQR), and QC Inspector records to this date.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

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

Inspected By:	O'Kane,Rory	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
