

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-008463**Date Inspected:** 09-Aug-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:** Lv Li Qing / Shen Fu You**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, Tim McClendon was present during the time noted above for observations relative to the work being performed.

The QA Inspector randomly observed the following work in progress:

ZPMC removed X3P brackets on 6BE assembly because of misalignment using carbon air arc gouging. Magnetic particle Inspection (MT) was performed by ZPMC some indications were found and marked to be ground and re-inspected. The QA inspector also performed a random MT inspection and found similar indications on the surface of web on several T-Stiffeners.

OBG Bay No. 14

Flux Cored Arc Welding (FCAW) on Longitudinal Diaphragm to Floor Beam on SEG 050B weld number 011, 012 and 017 for Segment 9AE. The ZPMC welder identified as 055491 were welding in the 3G position. The ZPMC QC identified as Li Ming Yang was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-T-2232-Tc-U4b-F.

Flux Cored Arc Welding (FCAW) on Longitudinal Diaphragm to Floor Beam on SEG 050C weld number 012, 017 and 018 for Segment 9AE. The ZPMC welder identified as 044795 were welding in the 3G position. The ZPMC QC identified as Li Ming Yang was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-T-2232-Tc-U4b-F.

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Shielded Metal Arc Welding (SMAW) of SEG 052A on Bottom Panel to Side Panel weld Number 020 for Segment 9BE. The ZPMC welder identified as 043661 were welding in the 4G position. The ZPMC QC identified as Li Ming Yang was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-P2214-B-U2-FCM-1.

Flux Cored Arc Welding (FCAW) of Deck Panel to Edge Panel of CA058 Corner Assembly weld number 004 for Segment 9AE. The ZPMC welders identified as 051356 and 055564 were welding in the 2G position. The ZPMC QC identified as Zhang Xian Ji was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-T-2232-TC-U4b-F.

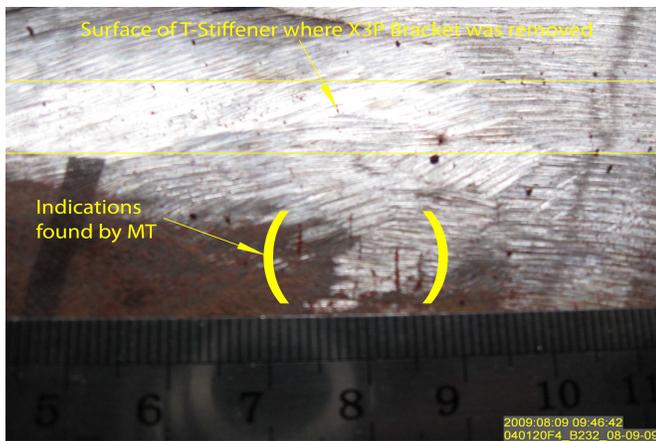
Flux Cored Arc Welding (FCAW) on CA057 CSD6 – PP72 Corner Assembly weld numbers 063 ~074 for Segment 9AE. The ZPMC welder identified as 066064 were welding in the 3F position. The ZPMC QC identified as Zhang Xian Ji was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-T-2133.

On this date the QA inspector observed ZPMC personnel installing FL3 and FL1 floor beam segment at the PP93 location for SEG. 10CE.

On this date the QA inspector observed ZPMC personnel installing FL1 floor beam segment at the PP9 location for SEG. 10CE.

On this date the QA inspector observed ZPMC personnel Air Arc Gouging 5 areas on Bottom Panel segment for 9BW.

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



Summary of Conversations:

No relevant conversations spoken on this date.

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 (15000422372), who represents the Office of Structural Materials for

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your project.

Inspected By:	McClendon, Timothy	Quality Assurance Inspector
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Reviewed By:	Patterson, Rodney	QA Reviewer
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