

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-008694**Date Inspected:** 28-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.

This QA Inspector randomly observed the following work in progress:

OBG Assembly Bay 14

This Quality Assurance Inspector (QA) observed that the contractor has used steel backing on T-stiffener on assembly 10CE that does not conform to the code requirements. This backing bar appears to be from an unknown source and is not in intimate contact with the base metal. An incident will be written on this issue. See photographs for additional information.

This Quality Assurance Inspector (QA) observed that the contractor has welded T – Stiffener on 10CE PP93 / PP74 improperly. This weld is in-process and not complete and no VT was performed by ZPMC QC. This is to capture in-process workmanship being performed on this weld joint. An incident report will be written on this issue. See photographs for additional information.

The QA inspector observed that fit-up is currently being performed on Deck panel 9CE.

Flux Cored Arc Welding (FCAW) on Floor Beam FL3 being welded to Side Panel of weld joint SEG056A for OBG assembly, weld number 009 for Segment 9DE. The ZPMC welders identified as 055564 was welding in the

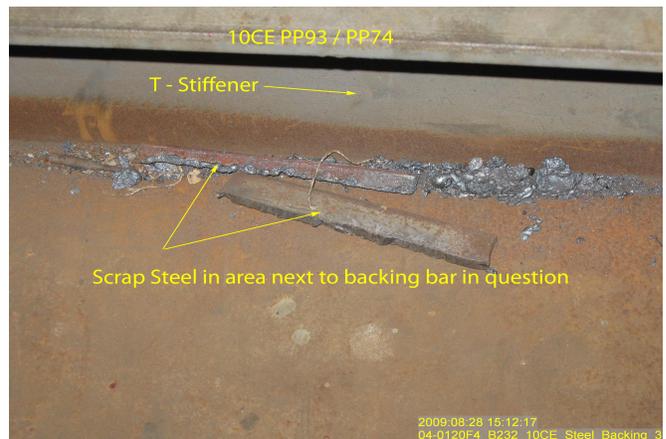
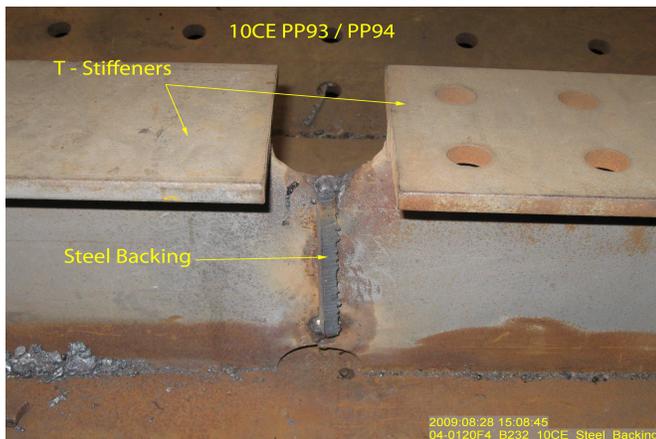
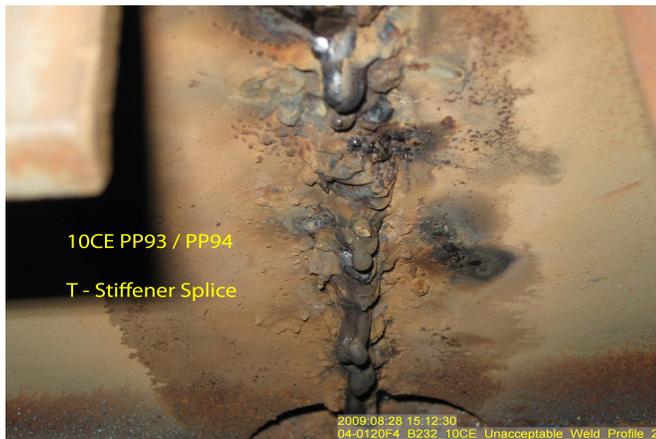
WELDING INSPECTION REPORT

(Continued Page 2 of 3)

3G position. The ZPMC QC identified as Zhong Guo Hui was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-T-2233-Tc-U2a-F.

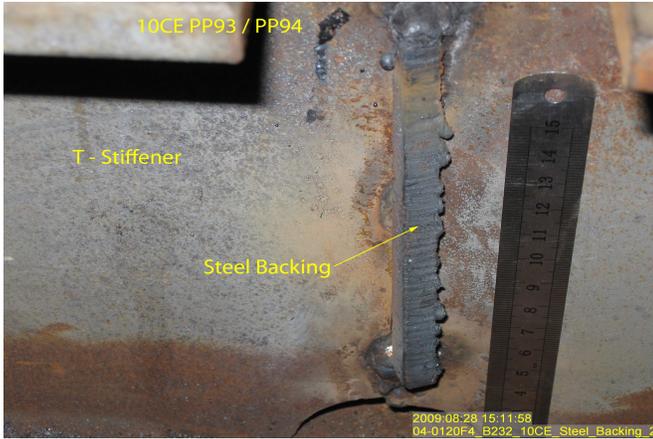
Shielded Metal Arc Welding (SMAW) on Floor Beam FL1 being welded to FL2-1 of weld joint SEG056 - SSD16A - PP80 for OBG Assembly weld number 134 for Segment 9DE. The ZPMC welders identified as 067904 was welding in the 4F position. The ZPMC QC identified as Zhong Guo Hui was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-T-2114-FCM-1.

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



WELDING INSPECTION REPORT

(Continued Page 3 of 3)



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 your project.

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