

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-008706**Date Inspected:** 27-Aug-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:	Zhan Hai Feng/ Guo Yuan Ting	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 Components	

Summary of Items Observed:

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

Bay #3

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 identified as OBG Components. The weld designations reviewed are as follows:

-(FB024-010-111, 114, 131, 132, 058, 059, 060, 061, 125, 126, 127, 086, 087)

Bay #6

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 identified as OBG Components. The weld designations reviewed are as follows:

-(WD1-CBSA3-1-1-14, 27, 28, 34, 36, 48, 43, 30, 31, 32.) Green Tag: 005866

-(WD1-CBSA3-1-2-14, 27, 28, 34, 36, 48, 43, 30, 31, 32.) Green Tag: 006784

-(WD1-CBSA3-1-3-14, 27, 28, 34, 36, 48, 43, 30, 31, 32.) Green Tag: 006785

-(WD1-CBSA3-1-4-14, 27, 28, 34, 36, 48, 43, 30, 31, 32.) Green Tag: 006786

-(WD1-CBSA3-1-5-14, 27, 28, 34, 36, 48, 43, 30, 31, 32.) Green Tag: 006787

-(WD1-CBSA3-1-6-14, 27, 28, 34, 36, 48, 43, 30, 31, 32.) Green Tag: 006788

-(WD1-CBSA3-1-7-14, 27, 28, 34, 36, 48, 43, 30, 31, 32.) Green Tag: 006789

-(WD1-CBSA3-1-8-14, 27, 28, 34, 36, 48, 43, 30, 31, 32.) Green Tag: 005867

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This QA inspector observed the following work in progress:

Bay#2

FCAW welding of weld joint FB3029-001-005, 051, 052, 059, 060, 067, 068 located on FB3029-001. Welder is identified as 045203 (2F). ZPMC QC-CWI is identified as Zhan Hai Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint FB3029-001-053, 054, 061, 062, 069, 070 located on FB3029-001. Welder is identified as 045203 (3F). ZPMC QC-CWI is identified as Zhan Hai Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint FB3030-001-005, 051, 052, 059, 060, 067, 068 located on FB3030-001. Welder is identified as 045203 (2F). ZPMC QC-CWI is identified as Zhan Hai Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint FB3061-001-005, 051, 052, 059, 060, 067, 068 located on FB3061-001. Welder is identified as 045209 (2F). ZPMC QC-CWI is identified as Zhan Hai Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint FB3059-001-053, 054, 061, 062, 069, 070 located on FB3059-001. Welder is identified as 045209 (3F). ZPMC QC-CWI is identified as Zhan Hai Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Cross Beams Update:

CB007-Bay#1- Rectification work is in progress

CB015-Bay#1-

FCAW welding of weld joint FB204-046-037, 043 and FB204-047-005, 009 located on FB204-046 and FB204-047. Welder is identified as 216575 (2F). ZPMC QC-CWI is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint FB204-048-028, 034, 005, 009 and FB204-046-006, 012 located on FB204-046 and FB204-048. Welder is identified as 216575 (2F). ZPMC QC-CWI is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS.

CB014-Bay#3-

SAW welding of weld joint CB202E-014-002, 003 located on CB-014. Welder is identified as 058100 (1G). ZPMC QC-CWI is identified as Guo Yuan Ting. The welding variables recorded by QC appeared to comply with the Applicable WPS.

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

Summary of Conversations:

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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:	Patel,Hiranch	Quality Assurance Inspector
Reviewed By:	Prue,Erik	QA Reviewer
