

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-008908**Date Inspected:** 06-Sep-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

Shielded Metal Arc Welding (SMAW) on Longitudinal Diaphragm to Floor Beam (FL1) of weld joint SEG060C OBG assembly weld number 031 for Segment 10AE. The ZPMC welder identified as 200113 was welding in the 4G 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-P-2214-Tc-U4b-FCM-1.

Shielded Metal Arc Welding (SMAW) on Side Panel T-Stiffener Splice of weld joint SP630-001 OBG assembly weld numbers 037 ~ 042 for Segment 10AE. The ZPMC welders identified as 054013 was welding in the 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-P-2213-B-U2-FCM-1.

Flux Cored Arc Welding (FCAW) on Longitudinal Diaphragm to Floor Beam (FL1) of weld joint SEG060C for OBG assembly weld number 019 for Segment 10AE. The ZPMC welders identified as 214945 was welding in the

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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-U4b-F.

Flux Cored Arc Welding (FCAW) on Floor Beam (FL3) to Side Panel of weld joint SEG060A for OBG assembly weld number 027 for Segment 10AE. The ZPMC welders identified as was welding in the 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.

Flux Cored Arc Welding (FCAW) on Longitudinal Diaphragm to Floor Beam of weld joint SEG058B for OBG assembly weld numbers 044, 045, 046, 047, 048 for Segment 19EE. The ZPMC welders identified as 048038 was welding in the 2G 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-2232c-U4b-F.

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 your project.

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