

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-008916**Date Inspected:** 07-Sep-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:** Chen Xi**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:

-(Seg052D-052~059)

-(Seg052D-068~073)

-(Seg064D-024~029)

-(Seg064D-047~052)

-(Seg056E-047~052)

-(Seg064E-082~087)

Bay #3

This QA inspector observed that all the required NDT work completed on following items. This QA Inspector issued a Green Tag for those items. The member is identified as OBG Components. The weld designations and Green Tag number reviewed are as follows:

CORNER ASSEMBLY

SEG052D-054~059 GREEN TAG#10287

SEG052D-068~073 GREEN TAG#10288

SEG052D-082~087 GREEN TAG#10289

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SEG056D-082~087 GREEN TAG#10292
SEG060D-054~059 GREEN TAG#10293
SEG060D-068~073 GREEN TAG#10294
SEG060D-082~087 GREEN TAG#10295
SEG064D-001~006 GREEN TAG#10296
SEG064D-024~029 GREEN TAG#10297
SEG064D-047~052 GREEN TAG#10298
SEG052E-001~006 GREEN TAG#10299
SEG052E-024~029 GREEN TAG#10300
SEG052E-047~052 GREEN TAG#10301
SEG056E-001~006 GREEN TAG#10302
SEG056E-024~029 GREEN TAG#10493
SEG056E-047~052 GREEN TAG#10494
SEG060E-001~006 GREEN TAG#10495
SEG060E-024~029 GREEN TAG#10496
SEG060E-047~052 GREEN TAG#10497
SEG064E-054~059 GREEN TAG#10498
SEG064E-068~073 GREEN TAG#10499
SEG064E-082~087 GREEN TAG#10500

Bay#2

SMAW welding of weld joint Seg059*-001-008 located on Seg9E. Welder is identified as 207540 (1G). ZPMC QC-CWI is identified as Guo Xiue. The welding variables recorded by QC appeared to comply with the Applicable WPS.

SMAW welding of weld joint Seg059*-001-005 located on Seg9E. Welder is identified as 205098 (1G). ZPMC QC-CWI is identified as Guo Xiue. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint FB3008-001-004, 022 located on FB3008-001. Welder is identified as 045203 (2F). ZPMC QC-CWI is identified as Zhang Hai Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint FB3060-001-022, 023 located on FB3060-001. Welder is identified as 045203 (2F). ZPMC QC-CWI is identified as Zhang Hai Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint FB3035-001-008, 013 located on FB3035-001. Welder is identified as 062438 (2F/3F). ZPMC QC-CWI is identified as Zhang Hai Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint FB3063-001-022, 023 located on FB3063-001. Welder is identified as 062438 (2F/3F). ZPMC QC-CWI is identified as Zhang Hai Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

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FCAW welding of weld joint FB3011-001-008, 013 located on FB3011-001. Welder is identified as 045203 (2F). ZPMC QC-CWI is identified as Zhang Hai Feng. 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:

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
