

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-009158**Date Inspected:** 18-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

Flux Cored Arc Welding (FCAW) on Floor Beam (FL1) to Corner Assembly of weld joint SEG054 SSD20A PP77 for OBG assembly weld number 007 for Segment 9CE. The ZPMC welder identified as 055564 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-B-U2-F.

Flux Cored Arc Welding (FCAW) on Floor Beam (FL1) to Corner Assembly of weld joint SEG054 SSD19 PP78 for OBG assembly weld number 009 for Segment 9CE. The ZPMC welder identified as 05491 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-B-U2-F.

Shielded Metal Arc Welding (SMAW) on Deck Panel to corner Stiffeners of weld joint SEG052A SSD24 PP74.5 OBG assembly weld numbers 123, 124, 125, 126, 127, 128 for Segment 9BE. The ZPMC welders identified as 067609 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

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

WPS-B-T-2112-FCM-1.

Shielded Metal Arc Welding (SMAW) on Corner Assembly to Floor Beam (FL3) of weld joint SEG052A SSD18 PP76 OBG assembly weld number 005 for Segment 9BE. The ZPMC welders identified as 066459 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-2213-B-U2-FCM-1.

Shielded Metal Arc Welding (SMAW) on Side Panel Splice of weld joint SEG052A OBG assembly weld number 032 for Segment 9BE. The ZPMC welders identified as 200114 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-T-2214-B-U2-FCM-1.

Shielded Metal Arc Welding (SMAW) on Floor Beam (FL2-2) to (FL1) of weld joint SEG058 SSD19 PP84 for OBG assembly weld number 132 for Segment 9EE. The ZPMC welders identified as 20013 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-T-2214-Tc-U4b-FCM-1.

Shielded Metal Arc Welding (SMAW) on Floor Beam (FL2-2) to (FL1) of weld joint SEG058 SSD19A PP83 for OBG assembly weld number 128 for Segment 9EE. The ZPMC welders identified as 049339 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-T-2214-Tc-U4b-FCM-1.

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
