

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-009198**Date Inspected:** 23-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

During random Visual Inspection of OBG Segment 9EE, the Caltrans Quality Assurance (QA) Inspector discovered cut lines on corner assembly Side Panel and main segment Side Panel are misaligned Approximately 10mm. This condition occurs where Corner Assembly 70A Side Panel section attaches to Side Panel 322A. See photographs for additional information. An incident report was written on this issue.

Shielded Metal Arc Welding (SMAW) on Floor Beam (FL3) to (FL2-2) of weld joint SEG064 SSD16 PP92 OBG assembly weld number 010 for Segment 10CE. The ZPMC welder identified as 200113 was welding in the 4G position. The ZPMC QC identified as Wang Xu 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 Floor Beam (FL3) to (FL2-2) of weld joint SEG064 SSD16 PP92 OBG assembly weld numbers 011 and 012 for Segment 10CE. The ZPMC welder identified as 200113 was welding in the 4F position. The ZPMC QC identified as Wang Xu was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-P-2114-FCM-1.

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Shielded Metal Arc Welding (SMAW) on Edge Panel to Deck Panel of weld joint SEG052A OBG assembly weld number 047 for Segment 9BE. The ZPMC welder identified as 200114 was welding in the 4G position. The ZPMC QC identified as Wang Xu 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 Edge Panel to Deck Panel of weld joint SEG052A OBG assembly weld number 046 for Segment 9BE. The ZPMC welder identified as 067609 was welding in the 4G position. The ZPMC QC identified as Wang Xu 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 Edge Panel to Deck Panel of weld joint SEG052A OBG assembly weld numbers 045 and 048 for Segment 9BE. The ZPMC welder identified as 067656 was welding in the 4G position. The ZPMC QC identified as Wang Xu 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 Beam Floor (FL3) to Deck Panel of weld joint SEG056A OBG assembly weld number 033 for Segment 9DE. The ZPMC welder identified as 044795 was welding in the 3G position. The ZPMC QC identified as Wang Xu was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-P-2233-Tc-U4b-FCM-1.

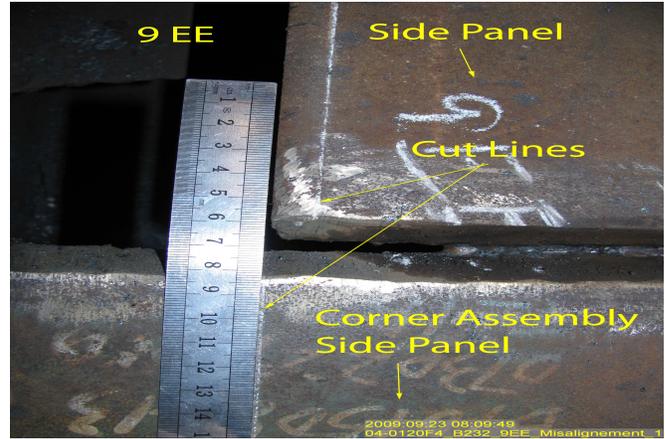
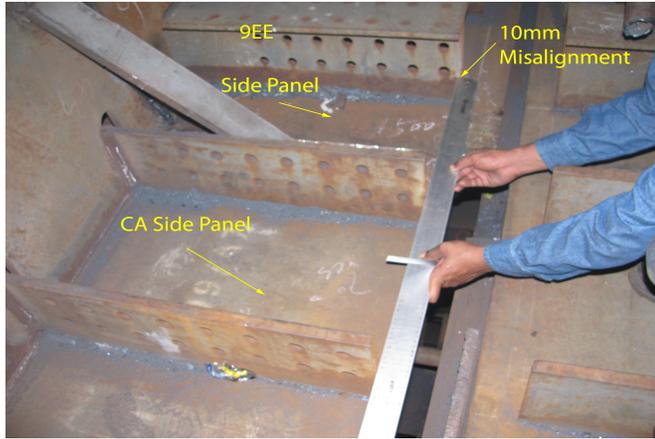
Shielded Metal Arc Welding (SMAW) on Beam Floor (FL3) to Deck Panel of weld joint SEG056A OBG assembly weld numbers 035 and 034 for Segment 9DE. The ZPMC welder identified as 044774 was welding in the 3G position. The ZPMC QC identified as Wang Xu was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-P-2233-Tc-U4b-FCM-1.

Shielded Metal Arc Welding (SMAW) on Beam Floor (FL3) to Deck Panel of weld joint SEG056A OBG assembly weld number 037 for Segment 9DE. The ZPMC welder identified as 055564 was welding in the 3G position. The ZPMC QC identified as Wang Xu was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-P-2233-Tc-U4b-FCM-1.

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

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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