

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-009276**Date Inspected:** 24-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 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-T-2214-Tc-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-T-2214-Tc-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-T-2214-Tc-FCM-1.

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Flux Cored Arc Welding (FCAW) on Edge Panel to Floor Beam (FL3) of weld joint SEG 056A for OBG assembly weld numbers 033, 034, 035 for Segment 9DE. The ZPMC welders identified as 044774 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-Tc-U4b-F.

Flux Cored Arc Welding (FCAW) on Edge Panel to Floor Beam (FL3) of weld joint SEG 056A for OBG assembly weld numbers 036, 037, 038 for Segment 9DE. The ZPMC welders identified as 044795 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-Tc-U4b-F.

Shielded Metal Arc Welding (SMAW) on Corner Assembly diaphragm to Deck Panel of weld joint SEG056 SSD18 PP82 OBG assembly weld numbers 132 ~ 139 for Segment 9DE. The ZPMC welder identified as 049339 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-T-2214-FCM.

Shielded Metal Arc Welding (SMAW) on Corner Assembly diaphragm to Deck Panel of weld joint SEG056 SSD18 PP80 OBG assembly weld numbers 131 ~ 138 for Segment 9DE. The ZPMC welder identified as 044779 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-T-2214-FCM.

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
