DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-009411
Date Inspected: 22-Sep-2009

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 645
OSM Departure Time: 1845
Location: Shanghai, China

CWI Name: Shen Fu You

Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**CWI Present:**	☑ Yes	☐ No	
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☑ 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.

During random visual inspection of OBG Segment 10CW and 9DW, this QA inspector observed that ZPMC has deviated from the joint design and used steel backing where it is not specified. The steel backing bar used to rectify excessive root opening in “T stiffeners” web splice joints. For further information, see attached pictures below.
Weld# having root opening more than 5mm.
SP772-001-030, 071, SP494-001-029, 030, SP732-001-066, SP733-001-038, 039, SP495-001-031, 033, SP775-001-025, SP497-001-021, SP776-001-040, SP778-001-030, SP738-001-056, 057, 047, 054, SP500-001-078, 079, 080, 082, 083, 084, SP779-001-037~042

This QA inspector observed the following work in progress:
Bay#13
SAW welding of weld joint Seg072A-002 located on Segment 11DE. Welder is identified as 062406 (1G). ZPMC QC is identified as Zhang Xian Ji. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Bay#14
SMAW welding of weld joint SP773-001-037~042 located on Segment 9DW. Welder is identified as 045196 (3G). ZPMC QC is identified as Li Ming Yang. The welding variables recorded by QC appeared to comply with the

Applicable WPS.

SMAW welding of weld joint SP733-001-037~042 located on Segment 9DW. Welder is identified as 066413 (3G). ZPMC QC is identified as Li Ming Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint SSD12-PP082-133, 067~106 located on Segment 9DW. Welder is identified as 047866/066401 (3G/3F). ZPMC QC is identified as Li Ming Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint SSD12-PP082-109~126 located on Segment 9DW. Welder is identified as 047866/066401 (2F). ZPMC QC is identified as Li Ming Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS.

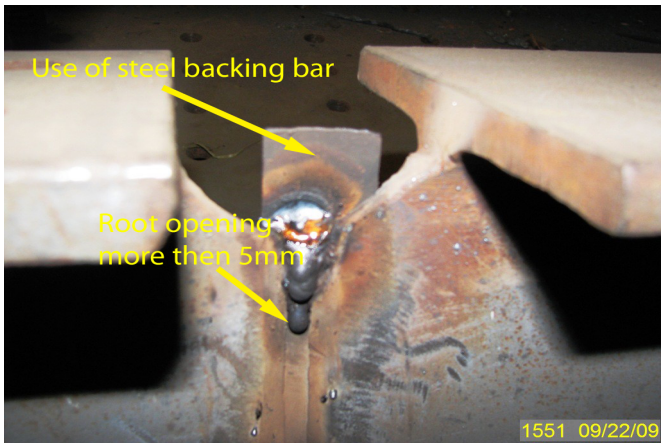
FCAW welding of weld joint SSD11-PP081-130, 124, 125 located on Segment 9DE. Welder is identified as 202122 (3G/3F). ZPMC QC is identified as Li Ming Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS.

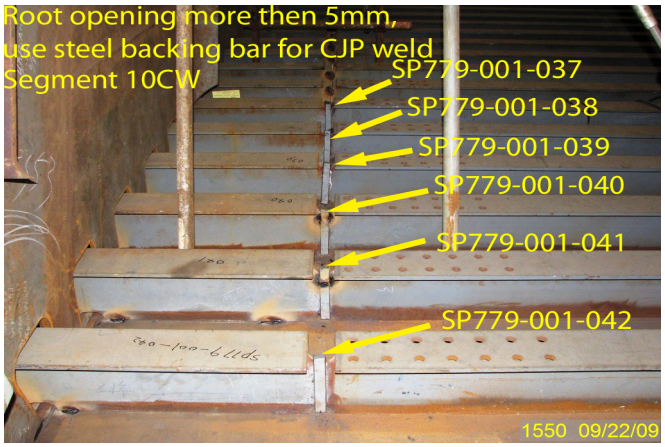
FCAW welding of weld joint SSD11-PP081-007, 126 located on Segment 9DE. Welder is identified as 202122 (1G). ZPMC QC is identified as Li Ming Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint SSD11A-PP081-013, 007, 008 located on Segment 9DE. Welder is identified as 201215 (3G/3F). ZPMC QC is identified as Li Ming Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint SSD11A-PP081-003, 009 located on Segment 9DE. Welder is identified as 201215 (1G). ZPMC QC is identified as Li Ming Yang. 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.





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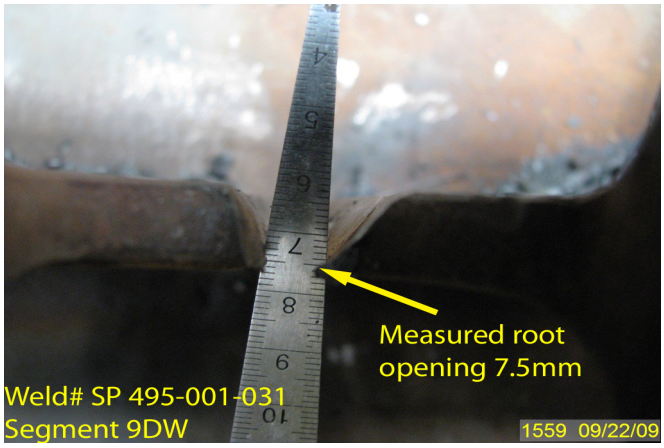

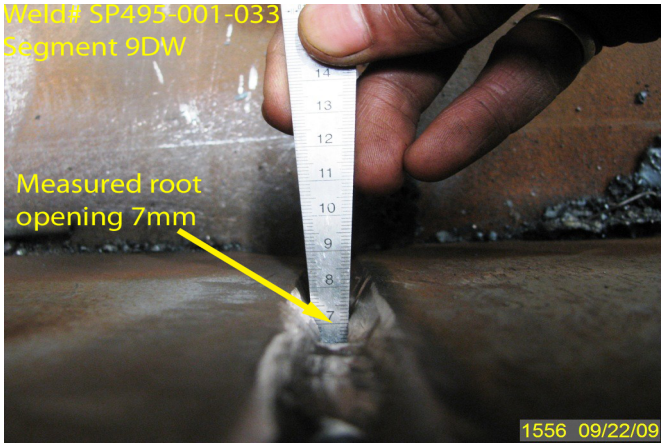

Summary of Conversations:

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:	Patterson,Rodney	QA Reviewer