

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-009435**Date Inspected:** 25-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:** Li Yan Hua/ 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.

This QA inspector observed the following work in progress:

Segment 8AW

SMAW welding of weld joint Seg043E-027, 036, 160, 151 located on Segment 8AW. Welder is identified as 044772 (3G). ZPMC QC is identified as Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2213-Tc-U4b.

Segment 9CW

FCAW welding of weld joint Seg053B-020 located on Segment 9CW. Welder is identified as 201215(3G). ZPMC QC is identified as Li Ming Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-Tc-U4b-F.

FCAW welding of weld joint Seg053B-023 located on Segment 9CW. Welder is identified as 066401(3G). ZPMC QC is identified as Li Ming Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-Tc-U4b-F.

FCAW welding of weld joint Seg053C-020 located on Segment 9CW. Welder is identified as 202122(3G). ZPMC QC is identified as Li Ming Yang. The welding variables recorded by QC appeared to comply with the Applicable

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WPS-B-T-2233-Tc-U4b-F.

FCAW welding of weld joint Seg053C-025 located on Segment 9CW. Welder is identified as 047866(3G). ZPMC QC is identified as Li Ming Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-Tc-U4b-F.

SMAW welding of weld joint Seg051A-009 located on 9BW. Welder is identified as 051348 (4F). ZPMC QC is identified as Li Ming Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-Tc-U4b.

SMAW welding of weld joint Seg051A-010 located on 9BW. Welder is identified as 058242 (4F). ZPMC QC is identified as Li Ming Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-Tc-U4b.

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FCAW welding of weld joint SSD19A-PP67-047~063(2F), SSD19A-PP67-008~045(3F) located on CB-009. Welder is identified as 055564(2F/3F). ZPMC QC is identified as Wang Xiang Pin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132-3 (2F) and WPS-B-T-2133 (3F).

FCAW welding of weld joint SSD19-PP67-048~065(2F), SSD19-PP67-010~047(3F) located on CB-009. Welder is identified as 055564(2F/3F). ZPMC QC is identified as Wang Xiang Pin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132-3 (2F) and WPS-B-T-2133 (3F).

FCAW welding of weld joint FB204-022-088, 087 located on CB-009. Welder is identified as 220688(3G). ZPMC QC is identified as Zhou Jie. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint FB204-021-088 located on CB-009. Welder is identified as 220688(3G). ZPMC QC is identified as Zhou Jie. 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:	Patterson,Rodney	QA Reviewer
