

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-009502**Date Inspected:** 27-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 zhi jiang**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**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, D.Sukanthan 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 # BAY 01

Flux Cored Arc Welding Process:

Welding of weld joint -001 located on PCMK CW001A-PP078. Welder is identified as 219189. ZPMC QC is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

Submerged Arc Welding Process:

Welding of weld joint -001 located on PCMK CB202C-015. Welder is identified as 207345. ZPMC QC is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-B-L2C-S-2.

Welding of weld joint -004 located on PCMK CB202C-015. Welder is identified as 215548. ZPMC QC is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-B-L2C-S-2.

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OBG # BAY 06

Flux Cored Arc Welding Process:

Welding of weld joint -014 located on PCMK CB202A-009. Welder is identified as 220688. ZPMC QC is identified as Liu chuan gang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-TC-U4b-F.

Welding of weld joint -066 located on PCMK FB204-020. Welder is identified as 053609. ZPMC QC is identified as Liu chuan gang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U2-F.

Welding of weld joint -060 located on PCMK FB204-020. Welder is identified as 053742. ZPMC QC is identified as Liu chuan gang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-B-U2-F.

Welding of weld joint -002 located on PCMK CB202C-008. Welder is identified as 220064. ZPMC QC is identified as Liu chuan gang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-B-U2-F.

Welding of weld joint -059 located on PCMK FB204-020. Welder is identified as 053609. ZPMC QC is identified as Liu chuan gang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-B-U2-F.

OBG # Cross Beam10

During random Visual inspection of this crossbeam #10 this QA discovered two linear indications. The weld designations reviewed are as follows: CB202G-025-132, CB20G-025-132. See attached pictures

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

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Summary of Conversations:

As mention above

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 150-00422372, who represents the Office of Structural Materials for your project.

Inspected By: Sukanthan,Dhanasingh

Quality Assurance Inspector

Reviewed By: Hall,Steven

QA Reviewer