

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-009583**Date Inspected:** 16-Oct-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:** 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 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.

Bay#14

FCAW welding of weld joint Seg049*-010 located on 9AW. Welder is identified as 066673 (1G). ZPMC QC is identified as Li Ming Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-T-1.

SMAW welding of weld joint SP776-001-038~047 located on 10AW. Welder is identified as 067665 (4G). ZPMC QC is identified as Li Ming Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-B-U2.

SAW welding of weld joint Seg057*-004 located on 9EW. Welder is identified as 045265 (1G). ZPMC QC is identified as Li Ming Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-223(2)1-T-2.

SMAW welding of weld joint Seg055A-010 located on 9DW. Welder is identified as 045246 (4G). 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-FCM-1.

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SMAW welding of weld joint Seg055A-009 located on 9DW. Welder is identified as 058242 (4G). 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-FCM-1.

SMAW welding of weld joint Seg055A-015 located on 9DW. Welder is identified as 051348 (4G). 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-FCM-1.

SMAW welding of weld joint Seg055A-016 located on 9DW. Welder is identified as 047864 (4G). 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-FCM-1.

FCAW welding of weld joint Seg049A-001 located on 9AW. Welder is identified as 066401 and 047866 (1G). ZPMC QC is identified as Li Ming Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-B-U2-F.

FCAW welding of weld joint SSD20-PP77-225, 245 located on 9CE. Welder is identified as 044774 (3G). ZPMC QC is identified as Zhong Guo Hai. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-Tc-U5-F.

FCAW welding of weld joint SSD20-PP77-227, 247 located on 9CE. Welder is identified as 044774 (3G). ZPMC QC is identified as Zhong Guo Hai. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232-Tc-U5-F.

SMAW welding of weld joint SSD20A-PP77-223, 243 located on 9CE. Welder is identified as 200114 (4G). ZPMC QC is identified as Zhong Guo Hai. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-Tc-U5-FCM.

FCAW welding of weld joint Seg052D-039, 030 located on 9BE. Welder is identified as 066683 (3G). ZPMC QC is identified as Zhong Guo Hai. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-Tc-U4b-F.

SMAW welding of weld joint Seg052D-036, 027 located on 9BE. Welder is identified as 215553 and 216086 (3G). ZPMC QC is identified as Zhong Guo Hai. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2213-Tc-U4b-FCM.

FCAW welding of weld joint SSD29-PP78.5-171~206 located on 9CE. Welder is identified as 050988 (2F). ZPMC QC is identified as Zhong Guo Hai. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132.

FCAW welding of weld joint SSD29-PP78.5-133~170 located on 9CE. Welder is identified as 050988 (3F). ZPMC QC is identified as Zhong Guo Hai. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2133.

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SMAW welding of weld joint Seg62A-010 located on 10BE. Welder is identified as 044779 (4G). ZPMC QC is identified as Zhong Guo Hai. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-B-U2-FCM-1.

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
