

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-010708**Date Inspected:** 28-Nov-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:** As Identified Below**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 Larry Viars was present during the times noted above for observations relative to the work being performed.

Bay 14-

This QA Inspector observed the following work in progress: Flux Cored Arc Welding (FCAW) of OBG Segment 10 BW longitudinal diaphragm to floor beam weld, SEG061B-028 at Panel point 89. ZPMC welder was identified as 047866. ZPMC QC was identified as Xu Tao. ZPMC CWI was identified as Zhu Zhong Hai The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2233-TC-U4b-F.

Flux Cored Arc Welding (FCAW) of OBG Segment 10 AW longitudinal diaphragm to floor beam weld, SEG059C-011 at Panel point 86. ZPMC welder was identified as 047866. ZPMC QC was identified as Xu Tao. ZPMC CWI was identified as Zhu Zhong Hai The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2233-TC-U4b-F.

Flux Cored Arc Welding (FCAW) of OBG Segment 11 DW corner assembly edge panel to deck panel weld, CA089-003. ZPMC welders were identified as 045240 and 058245. ZPMC QC was identified as Xu Tao. ZPMC CWI was identified as Zhu Zhong Hai The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2232-TC-U4b-F.

Flux Cored Arc Welding (FCAW) of OBG Segment 11 EW corner assembly edge panel to deck panel weld,

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

CA089-003. ZPMC welders were identified as 045175 and 050316. ZPMC QC was identified as Xu Tao. ZPMC CWI was identified as Zhu Zhong Hai The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2232-TC-U4b-F.

North of Bay 14-

Caltrans QA performed preliminary visual inspection of OBG segment 7BW along with ABF and ZPMC QC. ZPMC was still in process of weld repairs and NDT testing. ZPMC personnel performed repairs of welds found visually unacceptable to AWS D1.5 that were marked by ZPMC QC, ABF QC and Caltrans QA.

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

Summary of Conversations:

As identified within the contents of this report.

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:	Viars,Larry	Quality Assurance Inspector
Reviewed By:	Dawson,Paul	QA Reviewer
