

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-010890**Date Inspected:** 28-Dec-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:	Guo Yen Wei			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:	Deck Panel		

Summary of Items Observed:

On this day Caltrans OSM Quality Assurance (QA) Inspector Christopher D'souza was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China. QA Inspector observed and/or found the following:

CB 10

This QA Inspector witnessed ABF Inspectors performing UT of CB202A-010-013, 014, 015 and CB202A-010-001,002, 003 (DP-SP – W and E)

See Caltrans Ultrasonic Transverse Indication Evaluation sheet dated December 28th, 2009 for further information on inspection.

North Lay down

No Relevant work observed

Bay 9

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

This QA Inspector observed ZPMC welding personnel's performing Flux cored arc welding (FCAW) on visually rejectable areas on DP 3044-001. Welder is identified as 059378. ZPMC QC is identified as Chen Shi gang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2342

This QA Inspector observed ZPMC welding personnel's performing Submerged Arc welding (SAW) on DP 3002-001 and DP 3002A-001 Splice. Welder is identified as 059403. ZPMC QC is identified as Chen Shi gang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2221

Unless otherwise noted, all work 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 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Dsouza,Christopher	Quality Assurance Inspector
----------------------	--------------------	-----------------------------

Reviewed By:	Carreon,Albert	QA Reviewer
---------------------	----------------	-------------