

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-011695**Date Inspected:** 12-Jan-2010**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:** 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:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this date Caltrans Office of Structural Material (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 # CROSS BEAM CB06

This QA observed ZPMC qualified welding personnel identified as 066179 perform Shielded metal Arc Welding (SMAW) Process welding on weld joint SP204-005-025,026. ZPMC Quality Control Personnel (QC) identified as Mr. Wu Zhi Cheng was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2214-1.

OBG # SEGMENT 6CE

This QA observed ZPMC qualified welding personnel identified as 066421 perform Flux Cored Arc Welding (FCAW) Process welding on weld joint SEG032F-013. ZPMC Quality Control Personnel (QC) identified as Mr. Wang Liang was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2233-TC-U4b-F.

OBG # SEGMENT 6BW + SEGMENT 6CW

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

This QA observed ZPMC qualified welding personnel identified as 068764 perform Shielded Metal Arc Welding (SMAW) Process welding on weld joint OBW6C-005. ZPMC Quality Control Personnel (QC) identified as Mr. Feng Yajun was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2214-B-U2-FCM-1.

OBG # SEGMENT 6AW

This QA observed ZPMC qualified welding personnel identified as 066261 perform Shielded Metal Arc Welding (SMAW) Process welding on weld joint OBW6F-001. ZPMC Quality Control Personnel (QC) identified as Mr. Wang Zhu was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2214-B-U2-FCM-1.

This QA observed ZPMC qualified welding personnel identified as 220067 perform Shielded Metal Arc Welding (SMAW) Process welding on weld joint SEG027J-114. ZPMC Quality Control Personnel (QC) identified as Mr. Liyang was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-3G (3F)-FCM-Repair.

This QA observed ZPMC qualified welding personnel identified as 220067 perform Shielded Metal Arc Welding (SMAW) Process welding on weld joint SEG027J-105. ZPMC Quality Control Personnel (QC) identified as Mr. Liyang was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-3G (3F)-FCM-Repair.

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

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
