

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-012318**Date Inspected:** 14-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:** 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.

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This QA Inspector observed the following work in progress: Flux Cored Arc Welding (FCAW) of OBG Segment 12 BW corner assembly edge panel to deck panel weld, CA3009-004. ZPMC welder was identified as 201215. ZPMC QC was identified as Xu Tao. ZPMC CWI was identified as Liu Hua Jie. 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 DW deck panel diaphragm to deck panel welds, DP187-001-020 and 021. ZPMC welder was identified as 045175. ZPMC QC was identified as Xu Tao. ZPMC CWI was identified as Liu Hua Jie. 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 DW deck panel diaphragm to U rib welds, DP187-001-018 and 019. ZPMC welder was identified as 045175. ZPMC QC was identified as Xu Tao. ZPMC CWI was identified as Liu Hua Jie. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2133.

Shielded Metal Arc Welding (SMAW) of OBG Segment 10 CW side panel SP779BA to bottom panel BP158A

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weld, SEG063A-005. Welding was performed on the exterior weld surface that was previously covered by a temporary support fixture. ZPMC welder was identified as 047864. ZPMC QC was identified as Li Ming Yang. ZPMC CWI was identified as Liu Hua Jie. The welding appeared to be in conformance with welding procedure specification, WPS-B-P-2214-B-U2-FCM-1.

Flux Cored Arc Welding (FCAW) of OBG Segment 11 DE longitudinal diaphragm to floor beam weld, SEG072B-024. ZPMC welder was identified as 058551. ZPMC QC was identified as Zhong Guo Hui. ZPMC CWI was identified as Lv Li Qing. 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 DE longitudinal diaphragm to floor beam weld, SEG072C-024. ZPMC welder was identified as 044774. ZPMC QC was identified as Zhong Guo Hui. ZPMC CWI was identified as Lv Li Qing. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2233-TC-U4b-F.

Shielded Metal Arc Welding (SMAW) of OBG Segment 11 DE longitudinal diaphragm to floor beam weld, SEG072C-004. ZPMC welder was identified as 037996. ZPMC QC was identified as Zhong Guo Hui. ZPMC CWI was identified as Lv Li Qing. The welding appeared to be in conformance with welding procedure specification, WPS-B-P-2214-TC-U4b-FCM-1.

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

Summary of Conversations:

Only general conversation occurred between QA and QC this date.

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:	McClendon,Timothy	QA Reviewer
