

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-012151**Date Inspected:** 17-Feb-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) Components**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

BAY 1

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW):

Weld joint # 005 located on Traveler Rail 20TR1 – 019. Welder is identified as 219188. ZPMC Quality Control (QC) Inspector is identified as Yin Donghai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – Tc – U5 – F.

Weld joint # 003 located on Traveler Rail 20TR1 – 020. Welder is identified as 219188. ZPMC Quality Control (QC) Inspector is identified as Yin Donghai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – Tc – U5 – F. (see attached photo)

BAY 3

WELDING INSPECTION REPORT

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This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW):

Weld joint # 015 located on Traveler Rail 20TR2 – 013. Welder is identified as 214945. ZPMC Quality Control (QC) Inspector is identified as Yin Donghai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – Tc – U5 – F.

Weld joint # 013 located on Traveler Rail 20TR2 – 011. Welder is identified as 214945. ZPMC Quality Control (QC) Inspector is identified as Yin Donghai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – Tc – U5 – F. (see attached photo)

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: Kumar,Sandeep

Quality Assurance Inspector

Reviewed By: Hall,Steven

QA Reviewer