

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-012398**Date Inspected:** 01-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/Liu Fa Wen**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 Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Hiranch Patel, was present during the times noted above for observations relative to the work being performed.

Bay#1

FCAW welding of weld joint 21TR3-002-005 located on Traveler Rail 21TR3. Welder is identified as 215397 (1G). ZPMC QC is identified as Xiang Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-Tc-U5-F.

FCAW welding of weld joint 21TR4-002-007 located on Traveler Rail 21TR4. Welder is identified as 215397 (1G). ZPMC QC is identified as Xiang Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-Tc-U5-F.

FCAW welding of weld joint 21TR3-003-003 located on Traveler Rail 21TR3. Welder is identified as 054460 (1G). ZPMC QC is identified as Xiang Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-Tc-U5-F.

FCAW welding of weld joint 21TR3-004-007 located on Traveler Rail 21TR3. Welder is identified as 054460 (1G). ZPMC QC is identified as Xiang Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-Tc-U5-F.

Bay#2

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FCAW welding of weld joint 20TR1-012-003 located on Traveler Rail 20TR1. Welder is identified as 201912 (1G). ZPMC QC is identified as Yan Qing Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-Tc-U5-F.

FCAW welding of weld joint 20TR1-013-007 located on Traveler Rail 20TR1. Welder is identified as 066746 (1G). ZPMC QC is identified as Yan Qing Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-Tc-U5-F.

Bay#3

FCAW welding of weld joint 20TR2-005-015 located on Traveler Rail 20TR2. Welder is identified as 044824 (1G). ZPMC QC is identified as Guo Yuan Ting. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-Tc-U5-F.

FCAW welding of weld joint 20TR2-009-009 located on Traveler Rail 20TR2. Welder is identified as 050988 (1G). ZPMC QC is identified as Guo Yuan Ting. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-Tc-U5-F.

FCAW welding of weld joint 20TR2-012-015 located on Traveler Rail 20TR2. Welder is identified as 204338 and 214945 (1G). ZPMC QC is identified as Guo Yuan Ting. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-Tc-U5-F.

FCAW welding of weld joint 20TR2-014-009 located on Traveler Rail 20TR2. Welder is identified as 206623 (1G). ZPMC QC is identified as Guo Yuan Ting. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-Tc-U5-F.

FCAW welding of weld joint 20TR2-005-011 located on Traveler Rail 20TR2. Welder is identified as 044824 (1G). ZPMC QC is identified as Guo Yuan Ting. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-Tc-U5-F.

Bay#5

Weld buttering performed FCAW welding on traveler rail 10TR2-012 and 10TR1-006. Welder is identified as 204342 (1G). ZPMC QC is identified as Liu Fa Wen. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-FCAW-1G(1F)-Repair.

Unless otherwise noted, all 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 150-0042-2372, who represents the Office of Structural Materials for your project.

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Inspected By:	Patel,Hiranch	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer