

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-002174**Date Inspected:** 08-Apr-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1430**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Huang Wei Pang & Sha Zhi	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:	Floor Beams		

Summary of Items Observed:

On this date, Caltrans Office of Structural Materials (OSM), Quality Assurance (QA) Inspector, David A. Smith was present for the observations related the following;

Bay-7, Observed welder Sun Guzuo #058100 performing welding on FB-011-04026. The weld procedure utilized was WPS-B-T-2221-B-L2c-S-1 and the welding parameters were Amps 520, Volts 30 Travel Speed 427 mm/min and the Temperature was checked at 105c. The CWI present was Huang Wen Pang and the QC was Xiang Fang.

Bay-7, Observed ZPMC's Level II MT Inspector Zhou Dongyun performing an MT test on the following, FB-014-01 welds 01, 02, 03, 04, 05 and 06. No relevant indications were noted by during these tests.

Bay-8, Run off plates were observed being welded to WSD1-SA372 A/B-3A by SMAW welder Yun Chengxian #045138 utilizing welding rods 9018M H4R which were taken from a hot rod box. The CWI present was Sha Zhi and the QC was Xu Tao.

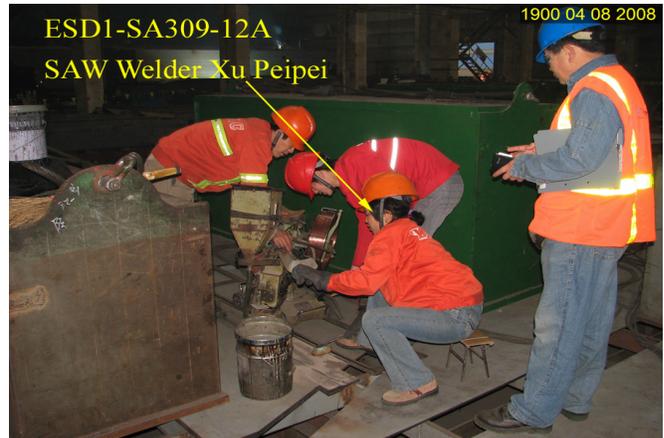
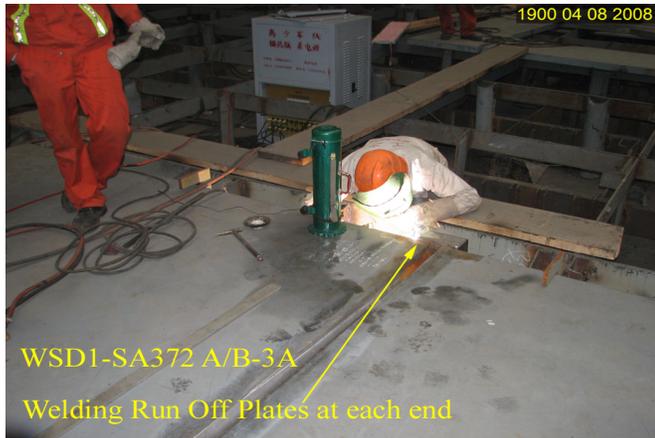
Bay-8, SAW welder Xu Peipei #050323 was observed welding the final weld passes on ESD1-SA309-12A. The welding procedure used was WPS-B-T-3221-B-U3c-S-1 on 485 material 75 mm thick. The CWI present was Sha Zhi and the QC was Yin Chun Fang.

Bay-8, SAW welder Wang Lan Ying #045265 was observed welding the filler weld passes in WSD1-SA370-10B utilizing welding wire LA-85 4.8mm diameter. The welding procedure being used for this 485 material 75mm in thickness was WPS-B-T-3221-B-U3c-S-1. The CWI present was Sha Zhi and the QC was Tuli Gao.

Bay-8, SSD1-SA277 A/B-1B (1A) 485 material 75 mm thick weld was being back gouged to good clean metal.

WELDING INSPECTION REPORT

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Summary of Conversations:

There were no pertinent conversations pertaining to the project during this shift.

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 Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Smith,David

Quality Assurance Inspector

Reviewed By: Hager,Craig

QA Reviewer
