

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-005110**Date Inspected:** 08-Jan-2009**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:** Fu You Saen**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 Assembly**Summary of Items Observed:**

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

Bay 18 (Cross Beam Assembly)

This QA Inspector observed the following work in progress:

Submerged Arc Welding (SAW) in the 1G position of the deck panel splice weld# CB205B-001-006. The welder is identified as #062819. ZPMC QC is identified as Mr. Liu Hua Jie. The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-L2C-S-2.

Segment Repair Yard (North of Bay 14)**Segment 5AW**

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 4G position of side panel to corner assembly splice welds repairs previously rejected by UT. The welders are identified as #067609 and #066258. ZPMC QC is identified as Mr. Wu Shi Gao. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-B-U2-FCM.

Segment Repair Yard (North of the Paint Shop)**Segment 3AW**

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 4G position of the lifting lug side plates at panel point 20. The welder is identified as #047864. ZPMC QC is identified as Mr. Yang Ming. The welding variables recorded by QC

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

appeared to comply with WPS-B-P-2214-TC-U5b-FCM.

Shielded Metal Arc Welding (SMAW) in the 4G position of the lifting lug side plates at panel point 22. The welder is identified as #037723. ZPMC QC is identified as Mr. Yang Ming. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-TC-U5b-FCM.

Flux Cored Arc Welding (FCAW) in the 2G position of the lifting lug side plates at panel point 20. The welder is identified as #045280. ZPMC QC is identified as Mr. Yang Ming. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-TC-U5-F.

Segment 3BW

This QA Inspector observed the following work in progress:

Shielded Meta Arc Welding (SAW) in the 1G position of the side panel to edge plate weld#CA-003-004. The welder is identified as #067656. ZPMC QC is identified as Mr. Fu You Saen. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-B-U2-Repair.

Summary of Conversations:

No Relavant 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 Ryan Smith, (858) 232-6799, who represents the Office of Structural Materials for your project.

Inspected By:	Patterson,Rodney	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
