

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-005125**Date Inspected:** 04-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.

Segment Repair Yard (North of Bay 14)

Segment 5BW

This QA Inspector observed ZPMC welding personnel #067829 performing Shielded Metal Arc Welding (SMAW) of Complete Joint Penetration (CJP) weld joints in the 1G position, on the floor beam flange splices at panel point 33. In process SMAW appears to be progressing in compliance with approved contract documents.

Segment 5AW

This QA Inspector observed ZPMC welding personnel #067656 performing Shielded Metal Arc Welding (SMAW) of Complete Joint Penetration (CJP) weld joints in the 4G position, on the floor beam web to corner assembly web splice. In process SMAW appears to be progressing in compliance with approved contract documents.

This QA Inspector observed ZPMC welding personnel #047866 performing Shielded Metal Arc Welding (SMAW) of Complete Joint Penetration (CJP) weld joints in the 4G position, on the floor beam web to corner assembly web splice. In process SMAW appears to be progressing in compliance with approved contract documents.

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Segment 4BW

This QA Inspector observed that there was no work being done on this segment.

Segment Repair Yard (North of the Paint Shop)

Segment 5AE

This QA Inspector observed ZPMC welding personnel#200114 performing Shielded Metal Arc Welding (SMAW) repair welds of areas previously rejected by UT, on the lifting lugs attached to the TL2-2 floor beam web at panel point 31.

This QA Inspector observed ZPMC welding personnel #200432 performing Shielded Metal Arc Welding (SMAW) of Complete Joint Penetration (CJP) weld joints in the 2G position, on the floor beam flange weld. In process SMAW appears to be progressing in compliance with approved contract documents.

Segment 3AW

This QA Inspector observed ZPMC personnel grit blasting the truss bolt holes and floor beams in way of lug attachments.

This QA Inspector observed ZPMC NDT personnel doing UT inspection of the previously rejected transverse deck panel stiffeners in way of the cross beams.

Segment 3BW

This QA Inspector observed that there was no work being done on this segment.

Segment Repair Yard (South of the Paint Shop)

Segment 4AW

This QA Inspector observed that there was no work being done on this segment.

Unless otherwise noted, all work observed on this date appeared to generally comply with the 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, (+86) 150-0042-2372, who represents the Office of Structural Materials for your project.

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