

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-005206**Date Inspected:** 17-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 the Paint Shop)

Segment 3AW

This QA Inspector observed the following work in progress:

Shielded Meta Arc Welding (SMAW) in the 3G position of the X37 transverse deck stiffeners in way of the crossbeam at panel point 20 $\frac{3}{4}$. The welder is identified as #047864. ZPMC QC is identified as Mr. Fu You Saen.

The welding variables recorded by QC appeared to comply with WPS-B-T-4213-U4b-2.

Shielded Meta Arc Welding (SMAW) in the 3G position of the X37 transverse deck stiffeners in way of the crossbeam at panel point 21 $\frac{3}{4}$. The welder is identified as #066413. ZPMC QC is identified as Mr. Fu You Saen.

The welding variables recorded by QC appeared to comply with WPS-B-T-4213-U4b-2.

Shielded Meta Arc Welding (SMAW) in the 4G position of the deck panel splice welds previously rejected by (UT) in way of corner assembly 1A. The welder is identified as #045138. ZPMC QC is identified as Mr. Fu You Saen. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G(4F) FCM-Repair.

This QA Inspector performed Ultrasonic testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as the edge plate to deck plate splice welds. The Weld Designations are as follows: CA001-004, SEG13*-047 and SEG13*-045.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

This QA Inspector performed Ultrasonic testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as the edge plate to bottom plate splice welds. The Weld Designations are as follows: CA001-003, SEG13A-039, SEG13A-040 and SEG13A-041.

Segment Repair Yard (North of the Bay 14)

Segment 5AW

This QA Inspector observed the following work in progress:

Shielded Meta Arc Welding (SMAW) in the 4G position of the side plate splice weld#SEG021A-010 that was previously rejected by (UT). The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G(4F)-FCM-Repair.

Segment 5BW

This QA Inspector observed the following work in progress:

Shielded Meta Arc Welding (SMAW) in the 4G position of the side plate splice weld#SEG023A-031 that was previously rejected by (UT). The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G(4F)-FCM-Repair.

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, (+86) 150-0042-2372, who represents the Office of Structural Materials for your project.

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