

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-005207**Date Inspected:** 19-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 4G position of the lifting lug vertical plate welds previously rejected by (UT) at panel point 22. 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-345-SMAW-4G(4F)-FCM-Repair.

Shielded Meta Arc Welding (SMAW) in the 4G position of the lifting lug vertical plate welds previously rejected by (UT) at panel point 20. The welder is identified as #037723. 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.

Segment 3BW

This QA Inspector observed the following work in progress:

Preproduction testing of stud welds for the bike path counter weight. The welder was qualified in accordance with AWS D1.5/2002 section 7.7.4.1.

(Paint Shop)

Segment 5AE

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

This QA Inspector performed visual inspection after the grit blast of the areas previously inspected and accepted by ZPMC Quality control personnel. Multiple areas were marked for repair and tape was applied to these areas prior to paint.

Segment Repair Yard (South of the Paint Shop)

Segment 5CE

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

Segment 4BW

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 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
---------------------	------------------	-------------