

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-005216**Date Inspected:** 13-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:** Chen Chih Ming**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 Segments**Summary of Items Observed:**

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

This QA Inspector observed the following work in progress:

Bay 13 OBG Assembly

Segment 2AE

Shielded Metal Arc Welding (SMAW) of weld joint SEG008A-032 located on SP189A to BP300A. Welders are identified as 067765, 067829, 067571 and 044837. ZPMC QC is identified as Zhang Xian Ji. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Segment 1BE

Shielded Metal Arc Welding (SMAW) of weld joint SEG006A-007 located on SP390A to BP306A. Welder is identified as 044837. ZPMC QC is identified as Zhang Xian Ji. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Shielded Metal Arc Welding (SMAW) of weld joint SEG006A-007 located on SP396A to BP308A. Welders are identified as 067829, 067571 and 044837. ZPMC QC is identified as Zhang Xian Ji. The welding variables

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

recorded by QC appeared to comply with the Applicable WPS.

Bay 14 OBG Assembly

Segment 7BE

Submerged Arc Welding (SAW) of weld joint SEG036A-003 located on SP63A to BP117A. Welder is identified as 062406. ZPMC QC is identified as Wu Bin. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Segment 7AE

Submerged Arc Welding (SAW) of weld joint SEG034A-009 located on SP310A to SP337A. Welder is identified as 062406. ZPMC QC is identified as Wu Bin. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Plate Yard

This QA Inspector selected Eight (8) 460mm x 355mm plate check samples and assigned a QA Lot number to the following material:

Lot number B222-034-09, 50mm A709SL-Gr345, Heat number: 07105548N

Lot number B222-035-09, 50mm A709SL-Gr345, Heat number: 08100406N0

Lot number B222-036-09, 50mm A709SL-Gr345, Heat number: 08201797N1

Lot number B222-037-09, 70mm A709SL-Gr345, Heat number: 08201797N1

Lot number B222-038-09, 75mm A709SL-Gr345, Heat number: 08201797N1

Lot number B222-039-09, 60mm A709SL-Gr345, Heat number: 07205956N

Lot number B222-040-09, 60mm A709SL-Gr345, Heat number: 7203807N

Lot number B222-041-09, 75mm A709SL-Gr345, Heat number: 7203807N

Plate check samples were marked with direction of rolling, QA lot number and date, and will be shipped to an Independent Testing lab.

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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By:	Hernandez, Dan	Quality Assurance Inspector
Reviewed By:	Clifford, William	QA Reviewer
