

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-005224**Date Inspected:** 14-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 1BW

Flux Cored Arc Welding (FCAW) of weld joint SEG005A-004 located on SP387A to BP305A. Welder is identified as 048038. ZPMC QC is identified as Zhang Xian Ji. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Submerged Arc Welding (SAW) of weld joint SEG005A-007 located on SP393A to BP307A. Welder is identified as 048296. ZPMC QC is identified as Zhang Xian Ji. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Segment 2BE

Shielded Metal Arc Welding (SMAW) of weld joint SEG010A-008 located on SP177 to BP194A. Welders are identified as 067829 and 067183. ZPMC QC is identified as Zhang Xian Ji. The welding variables recorded by QC

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

appeared to comply with the Applicable WPS.

Shielded Metal Arc Welding (SMAW) of weld joint SEG010A-007 located on SP183 to BP196A. Welders are identified as 067765 and 067571. ZPMC QC is identified as Zhang Xian Ji. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Segment 2BW

Shielded Metal Arc Welding (SMAW) of weld joint SEG009A-008 located on SP174A to BP193A. Welder is identified as 067183. ZPMC QC is identified as Zhang Xian Ji. The welding variables 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.

Submerged Arc Welding (SAW) of weld joint SEG034A-006 located on BP62A to BP116A. 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.

Flux Cored Arc Welding (FCAW) of weld joint SEG034A-002 located on SP530A to SP570A. Welder is identified as 048038. ZPMC QC is identified as Zhang Xian Ji. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Segment 7EE

Flux Cored Arc Welding (FCAW) of weld joint SEG042A-005 located on BP174A to BP66A. Welder is identified as 048038. ZPMC QC is identified as Zhang Xian Ji. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Segment 7CE

Submerged Arc Welding (SAW) of weld joint SEG032B-025 located on SP88C to SP528A. Welder is identified as 044780. ZPMC QC is identified as Wu Bin. The welding variables recorded by QC appeared to comply with the

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Applicable WPS.

Segment 6CE

Submerged Arc Welding (SAW) of weld joint SEG032B-008 located on SP90B to SP529B. Welder is identified as 044780. ZPMC QC is identified as Wu Bin. The welding variables recorded by QC appeared to comply with the Applicable WPS.

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.

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