

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-005684**Date Inspected:** 04-Mar-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:** Li Yan Hua**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.

This QA Inspector observed the following work in progress:

Segment Repair Yard (South of the paint shop)

Segment 5AW

Shielded Metal Arc Welding (SMAW) in the 4G position of the side plate to corner assembly splice welds previously rejected by ZPMC QC personnel. The welder is identified as #067572. The weld designation is CA015-003. ZPMC QC is identified as Mr. Zhang Bao Lai. The welding variables recorded by QC appear to comply with WPS-345-SMAW-4G(4F)-FCM-Repair.

Shielded Metal Arc Welding (SMAW) in the 2G position of the lifting lug vertical plate welds. The welder is identified as #037723. The weld designation is SSD14A-PP031-243. ZPMC QC is identified as Mr. Zhang Bao Lai. The welding variables recorded by QC appear to comply with WPS-B-T-2214-Tc-U5b-FCM.

Segment 5CE

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

Segment 5CW

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

Segment 5BW

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

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Segment Repair Yard (North of the paint shop)

Segment 4AE

Shielded Metal Arc Welding (SMAW) in the 4G position of the side plate to corner assembly splice welds previously rejected by ZPMC QC personnel. The welder is identified as #067572. The weld designation is CA015-003. ZPMC QC is identified as Mr. Li Yan Hua. The welding variables recorded by QC appear to comply with WPS-345-SMAW-4G(4F)-FCM Repair.

Segment 4BW

This QA Inspector performed a preliminary random visual inspection of the internal structure of this segment. Areas that were marked to be ground and welded were repaired at the time of inspection. No access was available to the external welds of this segment at the time of inspection.

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, (15000422372), who represents the Office of Structural Materials for your project.

Inspected By:	Patterson,Rodney	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
