

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-006348**Date Inspected:** 08-Apr-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:** Liu Wei Nei**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**Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Erik Prue was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA Inspector observed and/or found the following:

Cross Beam CB2: QA Inspector randomly observed ZPMC qualified welder ID#05812 welding stiffeners to bottom plates in cross beam assembly. Welder was observed welding in the 2G (horizontal) position utilizing Shielded Metal Arc Welding (SMAW) process. QA Inspector observed the ZPMC QC Inspector Zhan Cheng verifying welding parameters and pre-heat were in accordance with the Welding Procedure Specification (WPS). QA Inspector with QC Inspector observed parameters as follows: preheat temperature to be at 80°C and measured the welding parameters to be 186 amps, 25.2 volts, a travel speed of 100 mm/min. Welding parameters verified by QA Inspector appear to be in general compliance with the approved WPS-B-P-2112.

QA Inspector received notification to perform visual verification inspection of ZPMC QC accepted OBG catwalk welded angle and channel iron pieces prior to blast cleaning. QA Inspector randomly performed visual inspection of welds and base material for the following items.

Type 1 CATW-0 I-W: 216 pieces

Type 2 CATW-0 F-W: 24 pieces

Type 3 CATW-0 G-W: 2 pieces

Type 4 CATW-0 I-W: 40 pieces

Type 7 CATW-0Q1/P1-W: 96 pieces

Type 8 CATW-0 R1-W: 12 pieces

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Type 9 CATW-0 T1-W: 255 pieces

Type 13 CATW-0 P2-W: 75 pieces

ZPMC QC accepted welds and base material appear to be in accordance with AWS D1.5 (02) and the contract documents.

Unless otherwise noted, all work observed on this date appears to be in general compliance with the applicable contract documents.

Summary of Conversations:

No significant conversations this day.

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:	Prue,Erik	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
