

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-006461**Date Inspected:** 28-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: Wu zhi cheng
Inspected CWI report: Yes No N/A
Electrode to specification: Yes No N/A
Qualified Welders: Yes No N/A
Approved Drawings: Yes No N/A

CWI Present: Yes No
Rod Oven in Use: Yes No N/A
Weld Procedures Followed: Yes No N/A
Verified Joint Fit-up: Yes No N/A
Approved WPS: Yes No N/A
Delayed / Cancelled: Yes No N/A
Component: OBG Segment 3AE, 3BE, 3BW, 4BW

Bridge No: 34-0006**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, D.Sukanthan was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

Flux Cored Arc Welding Process:

OBG # SEG 3AE

Welding of weld joint -047 located on PCMK SEG14B-046. Welder is identified as 220064. ZPMC QC is identified as Wu zhi cheng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132.

OBG # SEG 3BE

Welding of weld joint -004 located on PCMK SEG16B-003. Welder is identified as 220064. ZPMC QC is identified as Wu zhi cheng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132.

OBG # SEG 3BW

Welding of weld joint -043 located on PCMK SEGOBB-008. Welder is identified as 220067. ZPMC QC is identified as Wu zhi cheng. The welding variables recorded by QC appeared to comply with the

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WPS-B-T-2133-TC-U4b-F.

Welding of weld joint –043 located on PCMK SEGOBC-008. Welder is identified as 220067. ZPMC QC is identified as Wu zhi cheng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133-TC-U4b-F.

OBG # SEG 4BW

Welding of weld joint –078,080 located on PCMK SSD25-PP021. Welder is identified as 218976. ZPMC QC is identified as Wu zhi cheng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133.

OBG # SEG 4AW + SEG 3BW

Welding of weld joint –005 located on PCMK CA003. Welder is identified as 220067. ZPMC QC is identified as Wu zhi cheng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No Relevant Conversation

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:	Sukanthan,Dhanasingh	Quality Assurance Inspector
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Reviewed By:	Prue,Erik	QA Reviewer
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