

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-006656**Date Inspected:** 26-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:** Li Zhi jiang**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 Components**Summary of Items Observed:**

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

Super Structure

This Quality Assurance Inspector, Hiranch Patel, observed removing of backing bar from segment weld joint OBW3-002, OBW3-003 and OBW3-004 (3AW+3BW) by carbon arc gouging. According to WPS WPS-B-T-2221-B-L2a-S-3 (SAW), WPS-B-T-2231-B-U2a-F3 (FCAW) backing bar is to remain in place. ZPMC changing the joint design. This QA inspector generates an Incident Report on that.

Segment 3BE+4AE

This QA inspector observed the following work in progress:

SMAW welding of weld joint Segment 4AE, Seg020D-PP26 located on Segment 4AE. Welder is identified as 048617 (4G). ZPMC QC is identified as Li Jingba. The welding variables recorded by QC appeared to comply with the Applicable WPS.

SMAW welding of weld joint Segment 4AE, Seg020E-PP27 located on Segment 4AE. Welder is identified as 037743 (4G). ZPMC QC is identified as Li Jingba. The welding variables recorded by QC appeared to comply with the Applicable WPS.

SMAW welding of weld joint Segment 3BE, Seg020E-PP28 located on Segment 3BE. Welder is identified as 037743 (4G). ZPMC QC is identified as Li Jingba. The welding variables recorded by QC appeared to comply with the Applicable WPS.

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FCAW welding of weld joint Segment 4BW, SSD25-PP027-047 located on Segment 4BW. Welder is identified as 058174 (3G). ZPMC QC is identified as Li Jingba. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Unless otherwise noted, all 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:	Patel,Hiranch	Quality Assurance Inspector
Reviewed By:	Prue,Erik	QA Reviewer
