

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-007260**Date Inspected:** 07-Jun-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:** Huang Wen pang**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, Sandeep Kumar was present during the times noted above for observations relative to the work being performed.

BAY 1

This QA Inspector observed the following work in progress:

FCAW process repair welding of weld joint #002 located on Cross Beam CB201D – 007. Welder is identified as 054460. ZPMC QC is identified as Tain Lei. The welding variables recorded by QC appeared to comply with the WPS – 345 – FCAW – 1G (1F) - Repair.

BAY 2

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #132 located on SSD19A – PP090. Welder is identified as 203871. ZPMC QC is identified as Zhu Jun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2233 – Tc – u4b – F.

BAY 3

This QA Inspector observed the following work in progress:

SMAW process Tack welding of weld joint #043 located on Floor Beam FB015 - 044. Welder is identified as

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055562. ZPMC QC is identified as Shi Lei. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2112.

FCAW process welding of weld joint #003 located on Longitudinal Diaphragm LD004 – 042. Welder is identified as 070101. ZPMC QC is identified as Zhang Yaxu. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

FCAW process welding of weld joint #034 located on Floor Beam FB204– 026. Welder is identified as 066746. ZPMC QC is identified as Yin Dong Hai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2233 – Tc – u4b - F.

FCAW process welding of weld joint #056 located on Floor Beam FB019 – 008. Welder is identified as 208035. ZPMC QC is identified as Shi Lei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

BAY 5

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #008 located on Traveler Rail TR1D – PP21. Welder is identified as 217219. ZPMC QC is identified as Xu Hong Min. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2233 – Tc – u4c - F.

FCAW process welding of weld joint #005 located on Floor Beam FB205A– 032. Welder is identified as 217562. ZPMC QC is identified as Chen Shi Ming. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – u4b - F.

FCAW process welding of a fillet weld joint located on cable Tray Support CTS4E. Welder is identified as 215185. ZPMC QC is identified as Zhou Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

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:	Kumar,Sandeep	Quality Assurance Inspector
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Reviewed By:	Prue,Erik	QA Reviewer
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