

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-007304**Date Inspected:** 17-May-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:** Lang zao gan**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 Segment 3BE / 4AE**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:

OBG # SEGMENT 3BE

Flux Cored Arc Welding Process:

Welding of weld joint -025,026,027,028 located on PCMK BP011A-001. Welder is identified as 202841. ZPMC QC is identified as Zhang hai tao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132.

Welding of weld joint -029,030 located on PCMK BP012A-001. Welder is identified as 220066. ZPMC QC is identified as Zhang hai tao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132.

Welding of weld joint -029,030,031,032 located on PCMK BP010A-001. Welder is identified as 048801. ZPMC QC is identified as Zhang hai tao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132.

Welding of weld joint -012 located on PCMK EP010A-001. Welder is identified as 037932. ZPMC QC is

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identified as Zhang hai tao. The welding variables recorded by QC appeared to comply with the WPS-B-P-2114-FCM.

Welding of weld joint –010,012 located on PCMK EP004A-001. Welder is identified as 067756. ZPMC QC is identified as Zhang hai tao. The welding variables recorded by QC appeared to comply with the WPS-B-P-2114-FCM.

OBG # SEGMENT 4AE

Flux Cored Arc Welding Process:

Welding of weld joint –001,002,003,004 located on PCMK BP017A-001. Welder is identified as 202841. ZPMC QC is identified as Zhang hai tao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132.

Welding of weld joint –001,002,003,004 located on PCMK BP018A-001. Welder is identified as 220066. ZPMC QC is identified as Zhang hai tao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132.

Welding of weld joint –001,002,003,004 located on PCMK BP016A-001. Welder is identified as 048801. ZPMC QC is identified as Zhang hai tao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132.

Welding of weld joint –006,008 located on PCMK EP016A-001. Welder is identified as 037932. ZPMC QC is identified as Zhang hai tao. The welding variables recorded by QC appeared to comply with the WPS-B-P-2114-FCM.

Welding of weld joint –006,008 located on PCMK EP012A-001. Welder is identified as 067756. ZPMC QC is identified as Zhang hai tao. The welding variables recorded by QC appeared to comply with the WPS-B-P-2114-FCM.

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