

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-007457**Date Inspected:** 30-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:** WU ZHICHENG**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 COMPONENT**Summary of Items Observed:**

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

In process Inspection

OUTSIDE SEGMENT ASSEMBLY AREA

This QA Inspector randomly observed ZPMC welding personnel performing groove welding repair work of weld joint SP-396-001-15~18 filler passes at segment 1AE. The personnel were observed welding in the 2G position utilizing a SMAW process. Welder is identified as 045133. The welding variables recorded by QC appeared to comply with the WPS- 345-SMAW-2G(2F)-FCM-REPAIR-1.

This QA Inspector randomly observed ZPMC welding personnel performing groove welding repair work of weld joint SP-390-001-25~26 filler passes at segment 1AE. The personnel were observed welding in the 2G position utilizing a SMAW process. Welder is identified as 048659. The welding variables recorded by QC appeared to comply with the WPS- 345-SMAW-2G(2F)-FCM-REPAIR-1.

This QA Inspector randomly observed ZPMC welding personnel performing groove welding repair work of weld joint SP-648-001-11~20 filler passes at segment 1BE. The personnel were observed welding in the 2G position utilizing a SMAW process. Welder is identified as 045133. The welding variables recorded by QC appeared to comply with the WPS- 345-SMAW-2G(2F)-FCM-REPAIR-1.

WELDING INSPECTION REPORT

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This QA Inspector randomly observed ZPMC welding personnel performing groove welding of weld joint FB-089-001-028 filler passes at segment 1AE. The personnel were observed welding in the 2G position utilizing a SMAW process. Welder is identified as 069896. The welding variables recorded by QC appeared to comply with the WPS- B-P-2112-FCM-1.

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 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Bera,Subhasis	Quality Assurance Inspector
Reviewed By:	Prue,Erik	QA Reviewer
