

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-007664**Date Inspected:** 04-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:** 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.

Segment 6AE

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member is identified as OBG Floor Beam. The weld designations reviewed are as follows:

-(SEG028D-011, 012, 019, 020, 025, 026, 031, 032)

-(SEG028F-011, 012, 019, 020, 025, 026, 031, 032)

-(SSD015-PP037-045~050, 105, 106)

-(SSD015A-PP037-106, 107, 047~052)

-(SSD023-PP037.5-049~054, 079, 084)

-(SSD016-PP038-026~031, 088, 089)

-(SSD016A-PP038-106, 107, 047~052)

-(SSD032-PP038.5-049~054, 079~084)

-(SSD017-PP039-026~031, 086, 087)

-(SSD017A-PP039-047~052, 106, 107)

-(SSD030-PP039.5-049~054, 079~084)

-(SSD018-PP040-027~032, 089, 090)

-(SSD018A-PP040-048~053, 109, 110)

-(SSD030-PP040.5-049~054, 079~084)

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This QA inspector observed the following work in progress:

Bay #2

FCAW welding of weld joint SSD16A-PP092-006 located on FB003-162. Welder is identified as 062708 (3G). ZPMC QC is identified as Zhu Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint SSD16A-PP092-131 located on FB003-162. Welder is identified as 062708 (3G). ZPMC QC is identified as Zhu Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint LD002-036-004, 002, 001, 005, 006 located on LD002-036. Welder is identified as 215676 (1G). ZPMC QC is identified as Zhu Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Bay #3

FCAW welding of weld joint LD012-015-003, 005 located on LD012-015. Welder is identified as 070101 (1G). ZPMC QC is identified as Li Zhi jiang. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint FB028-012-107 located on FB028-012. Welder is identified as 208035 (1G). ZPMC QC is identified as Li Zhi jiang. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Joint Fit-Up verified, SMAW welding of weld joint FB009-033-009, 046. Welder is identified as 055562 (1G). ZPMC QC is identified as Li Zhi jiang. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Back gouging by carbon arc gouging of the following weld joint numbers. ZPMC QC is identified as Li Zhi jiang.
FB028-012-148
FB020-008-073, 076
FB009-040-045

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.

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Inspected By:	Patel,Hiranch	Quality Assurance Inspector
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Reviewed By:	Prue,Erik	QA Reviewer
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