

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-007859**Date Inspected:** 22-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 Yan Hua**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 Assembly**Summary of Items Observed:**

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

This QA Inspector observed the following work in progress:

Segment Repair Yard (North of bay 14)

Segment 6AW

Shielded Metal Arc Welding (SMAW) in the 4G position of side panel to bottom panel splice weld that was previously inaccessible due to the jig. The welder is identified as #045196. The weld designation is SEG027B-031. ZPMC QC is identified as Mr. Li Yan Hua. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-B-U2-FCM-1.

Segment 6BW

Shielded Metal Arc Welding (SMAW) in the 4G position of side panel to bottom panel splice weld that was previously inaccessible due to the jig. The welder is identified as #068097. The weld designation is SEG029A-004. ZPMC QC is identified as Mr. Li Yan Hua. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-B-U2-FCM-1.

Flux Cored Arc Welding (FCAW) in the 3G position of the side plate stiffeners in way of the access hole cut out. The welder is identified as #045280. The weld designation is SSD9B-PP41-056. ZPMC QC is identified as Mr. Li Yan Hua. The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

WELDING INSPECTION REPORT

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Segment Repair Yard (South of bay 13 and 14)

This QA Inspector observed that there was no work being done on OBG Segments 6CE, 7EE and 7DE at the time of inspection.

Segment Repair Yard (North of the Blast Shop)

Segment 7CE

This QA Inspector observed that there was no work being done on this segment at the time of inspection.

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:	Patterson,Rodney	Quality Assurance Inspector
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Reviewed By:	Carreon,Albert	QA Reviewer
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