

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-008007**Date Inspected:** 31-Jul-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Lv Li Qing**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, Tim McClendon 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 - Bay No. 13

Shielded Metal Arc Welding (SMAW) of weld joint SEG048-046 located on OBG Segment 8CE. Welder is identified as 200114. ZPMC QC is identified as Guo Xing Hui. The welding variables recorded by QC appeared to comply with the WPS-B-T-2214-TC-U4b-FMC-1.

Flux Cored Arc Welding (FCAW) of weld joint SEG047B - 032 located on OBG Segment 8CW. Welder is identified as 050242. ZPMC QC is identified as Wang Xu. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-B-U2-F.

Shielded Metal Arc Welding (SMAW) of weld joint SSD11- PP69 - 008 located on OBG Segment 8CW. Welder is identified as 200432. ZPMC QC is identified as Wang Xu. The welding variables recorded by QC appeared to comply with the WPS-B-T-2213-B-U2-FCM-1.

OBG Bay No. 14

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Flux Cored Arc Welding (FCAW) of weld joint SEG050A, weld number 135 located on OBG Segment 9AE at PP 72 Dwg. number SSD 19. Welder is identified as 051356 was welding in the 3G position . ZPMC QC is identified as Zhang Xian Ji was monitoring the welding and recording the weld variables. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U2-F.

Flux Cored Arc Welding (FCAW) of weld joint SEG050A, weld number 131 located on OBG Segment 9AE at PP 72 Dwg. number SSD 19. Welder is identified as 044795 was welding in the 3G position . ZPMC QC is identified as Zhang Xian Ji was monitoring the welding and recording the weld variables. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U2-F.

Shielded Metal Arc Welding (SMAW) of weld joint SEG062, weld number 004 located on OBG Segment 10BE. Welder is identified as 043661 was welding in the 4G position. ZPMC QC is identified as Zhang Xian Ji was monitoring the welding and recording the weld variables. The welding variables recorded by QC appeared to comply with the WPS-B-T-2214-TC-U4b-FMC-1.

On this date the QA inspector observed ZPMC personnel installing Side Panel SP9DE located at E7 adjacent to PP80.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations spoken on this date.

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:	McClendon, Timothy	Quality Assurance Inspector
Reviewed By:	Patterson, Rodney	QA Reviewer
