

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-008338**Date Inspected:** 14-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:	Zhu Zheng Hai & Shen Fu You	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 Bays 13 & 14	

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector, Rory O'Kane 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 Process:

Welding of weld joint SEG043A-041 located on OBG Segment 8AW. Welder is identified as 067589. ZPMC QC is identified as Zhu Zheng Hai. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-TC-U4b-FCM-1.

Welding of weld joint SEG045-025 located on OBG Segment 8BW. Welder is identified as 201087. ZPMC QC is identified as Zhu Zheng Hai. The welding variables recorded by QC appeared to comply with the WPS-B-T-2213-B-U2.

Welding of weld joint SEG045-021 located on OBG Segment 8BW. Welder is identified as 048047. ZPMC QC is identified as Zhu Zheng Hai. The welding variables recorded by QC appeared to comply with the WPS-B-T-2213-B-U2.

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Flux Cored Arc Welding Process:

Welding of weld joint SEG045-SSD13-PP65-004 located on OBG Segment 8AW. Welder is identified as 044774. ZPMC QC is identified as Zhu Zheng Hai. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-TC-U4b-F.

Welding of weld joint SEG043A-SSD10-003 located on OBG Segment 8AW. Welder is identified as 058551. ZPMC QC is identified as Zhu Zheng Hai. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-TC-U4b-F.

OBG - BAY No. 14

Flux Cored Arc Welding Process:

Welding of weld joint SSD10A-PP56-225 located on OBG Segment 7DW. Welder is identified as 045175. ZPMC QC is identified as Shen Fu You. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-TC-U4b-F.

Visual Inspection - General

This QA Inspector observed Deck Plate Distortion and Base Metal Repair on Deck Panel DP503-001. See submitted Incident Report for details.

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member is identified as Bottom Panel. The weld designations reviewed are as follows:

SEG064A-013
SEG064A-014
SEG064A-017
SEG064A-018
SEG064A-019

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

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

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, who represents the Office of Structural Materials for your project.

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Inspected By: O'Kane,Rory Quality Assurance Inspector

Reviewed By: Carreon,Albert QA Reviewer