

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-008355**Date Inspected:** 24-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 & 19	

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.

OBG - BAY No. 13

Flux Cored Arc Welding Process:

Welding of weld joint SEG043-SSD12A-PP64-226 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-2232-TC-U5-F.

Welding of weld joint SEG047-SSD11-PP69-003 located on OBG Segment 8CW. Welder is identified as 055491. ZPMC QC is identified as Zhu Zheng Hai. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132.

Welding of weld joint SEG047-SSD12A-PP64-234 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-2233-TC-U5-F.

OBG - BAY No. 14

WELDING INSPECTION REPORT

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Shielded Metal Arc Welding Process:

Welding of weld joint SEG058A-007 located on OBG Segment 9EE. Welder is identified as 067756. ZPMC QC is identified as Shen Fu You. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-B-U2-FCM-1.

This QA Inspector noted installation of the following Structural Framing Components:

OBG Segment 9CE (Panel Point 78) FB013-031, SSD19/19A-PP078

OBG Segment 9CE (Panel Point 79) FB010-026, FB013-036, SSD20/20A-PP079

OBG – BAY No. 19

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated An MT Test report for this date. The components are identified as Suspender Brackets. The weld designations reviewed are as follows:

SB013-068-021, 033, 045, 057, 030, 036, 060

SB013-062-022, 034, 040, 064, 053, 023, 047

SB019-070-045, 052, 064, 054, 066, 047, 059

SB014-054-003, 027, 034, 046, 029, 042, 035

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.

Inspected By:	O'Kane,Rory	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
