

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-008359**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:	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

Shielded Metal Arc Welding Process:

Welding of weld joint SEG047B-SSD11-PP69-001 located on OBG Segment 8CW. Welder is identified as 200432. ZPMC QC is identified as Zhu Zheng Hai. The welding variables recorded by QC appear to comply with the WPS-B-P-2213-B-U2-FCM-1.

Welding of weld joint SEG047B-SSD12-PP70-009 located on OBG Segment 8CW. Welder is identified as 044772. ZPMC QC is identified as Zhu Zheng Hai. The welding variables recorded by QC appear to comply with the WPS-B-P-2213-B-U2-FCM-1.

Welding of weld joint SEG047B-SSD11-PP69-008 located on OBG Segment 8CW. Welder is identified as 067764. ZPMC QC is identified as Zhu Zheng Hai. The welding variables recorded by QC appear to comply with the WPS-B-P-2213-B-U2-FCM-1.

Flux Cored Arc Welding Process:

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Welding of weld joint SEG047B- 032 located on OBG Segment 8CW. Welder is identified as 050242. ZPMC QC is identified as Zhu Zheng Hai. The welding variables recorded by QC appear to comply with the WPS-B-T-2231-B-U2-F.

OBG - BAY No. 14

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

OBG Segment 9DE (Panel Point 81) FB024-007

OBG Segment 9DE (Panel Point 82) FB028-008

OBG Segment 9EE (Panel Point 83) FB010-028, FB013-034, SSD19/19A-PP083, FB016-033

OBG Segment 9EE (Panel Point 84) FB010-024, FB013-030, SSD19/19A-PP084, FB016-032

OBG Segment 9EE (Panel Point 85) FB010-023, FB013-032, SSD19/19A-PP085, FB016-038

OBG Segment 10AE (Panel Point 87) FB014-036, SSD17/17A-PP87

OBG Segment 10AE (Panel Point 88) FB014-040, SSD18/18A-PP88

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 a UT report for this date. The member is identified as Bottom-Side Panel. The weld designations reviewed are as follows:

SEG052A-031

OBG - BAY No. 19

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 a UT report for this date. The member is identified as Bottom Panel. The weld designations reviewed are as follows:

BP025-010-001~003

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 report for this date. The components are identified as Bottom Panel. The weld designations reviewed are as follows:

BP026-010-001~003

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
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Reviewed By:	Carreon,Albert	QA Reviewer
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