

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-008690**Date Inspected:** 26-Aug-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 / 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 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 Assembly Bay 14

This Quality Assurance Inspector (QA) observed that the contractor is deviating from the AWS D1.5 Code requirements for heat straightening. The contractor is using an overhead crane to lift one end of a side panel while local heat is being applied. ZPMC Heat Straightening Report (HSR) number is 7639. The side panel super assembly is going in assembly 9DW SEG 055A the Side Panels are SP772B, SP732B, SP494B, SP672B the weld in the photograph that heat is being applied to is Weld Number 013. An incident report will be written on this issue. See photograph for additional information.

Flux Cored Arc Welding (FCAW) of weld joint SEG056 - SSD18 - PP82 for OBG assembly Floor Beam FL 2-2 welded to FL 1, weld number 014 for Segment 9DE. The ZPMC welders identified as 055491 was welding in the 3G position. The ZPMC QC identified as Zhong Guo Hui was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-T-2233-B-U2-F.

Flux Cored Arc Welding (FCAW) of weld joint SEG056 - SSD18A - PP82 for OBG assembly Floor Beam FL 2-2 welded to FL 1, weld number 133 for Segment 9DE. The ZPMC welders identified as 044795 was welding in the

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

3G position. The ZPMC QC identified as Zhong Guo Hui was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-T-2233-B-U2-F.

Shielded Metal Arc Welding (SMAW) of CJP welds Floor beam flanges FL1 welded to FL2-2 on OBG assembly SEG 054 SSD20 PP77 weld number 131 for Segment 9CE. The ZPMC welder identified as 043661 was welding in the 4G position. The ZPMC QC identified as Zhang Xian Ji was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-P-2214-Tc-U4b.

Shielded Metal Arc Welding (SMAW) of CJP welds Floor beam flanges FL1 welded to FL2-2 on OBG assembly SEG 054 SSD20 PP79 weld number 131 for Segment 9CE. The ZPMC welder identified as 043661 was welding in the 4G position. The ZPMC QC identified as Zhang Xian Ji was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-P-2214-Tc-U4b.

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
