

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-008699**Date Inspected:** 16-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Zhan Hai Feng/ Guo Yuan Ting	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 Components	

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector, Hiranch Patel, was present during the times noted above for observations relative to the work being performed.

Bay #3

This QA inspector performed 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 member is identified as OBG Components. The weld designations reviewed are as follows:

-(FB003-186-011~054)

CB-006

This QA inspector performed 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 member is identified as OBG Components. The weld designations reviewed are as follows:

-(CB202G-010-184)

Bay #3

This QA inspector performed 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 OBG Components. The weld designations reviewed are as follows:

-(SSD014-PP103-137)

-(FB003-186-020, 032, 044, 022)

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Bay #14

This QA inspector performed 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 OBG Components. The weld designations reviewed are as follows:

-(Seg052A-005)

This QA inspector observed the following work in progress:

Bay#1

FCAW welding of weld joint CB201A-007-017 located on CB007. Welder is identified as 054460 & 216575(3G). ZPMC QC-CWI is identified as Zhan Hai Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Bay#2

Joint fit up performed by SMAW welding process of weld joint FB3031-001-078, 079 located on FB3031-001. Welder is identified as 200569(1G). ZPMC QC-CWI is identified as Zhang Hai Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

SAW welding of weld joint FB3042-001-023, 031 located on FB3024-001. Welder is identified as 207237 (1G). ZPMC QC-CWI is identified as Zhang Hai Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint FB3005-001-005~020 located on FB3005-001. Welder is identified as 045209 (1G) & 062438 (1G). ZPMC QC-CWI is identified as Zhan Hai Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Bay#3

SAW welding of weld joint CB202B-014-003/004 located on CB202B-014. Welder is identified as 062406 (1G). ZPMC QC-CWI is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Bay#8

Joint fit up performed by SMAW welding process of weld joint CB202A-012-005 located on CB012. Welder is identified as 058242(3G). ZPMC QC-CWI is identified as Zhang Jing Xin. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Joint fit up performed by FCAW welding process of weld joint CB202A-012-017 located on CB012. Welder is identified as 069118(3G). ZPMC QC-CWI is identified as Zhang Jing Xin. The welding variables recorded by QC appeared to comply with the Applicable WPS.

SAW welding of weld joint CB202C-013-003/004 located on CB013. Welder is identified as 207463 (1G). ZPMC QC-CWI is identified as Zhang Jing Xin. The welding variables recorded by QC appeared to comply with the Applicable WPS.

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

Summary of Conversations:

No relevant conversations.

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 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Patel,Hiranch	Quality Assurance Inspector
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Reviewed By:	Prue,Erik	QA Reviewer
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