

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-008889**Date Inspected:** 03-Sep-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:** Chen Xi/ Sun Wei**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 #1

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:

-(CB201A-007-005, 017)

-(CB202E-015-002, 003)

-(CB202D-015-002)

Bay#2

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:

FB3005-001-001~004

FB3005-002-001~004

FB3005-003-001~004

FB3005-004-001~004

FB3088-001-001~004

FB3088-002-001~004

FB3088-003-001~004

FB3088-004-001~004

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Bay #1

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:

- (FB204-043-034, 046, 025)
- (FB205-044-006)
- (FB205-043-013)
- (FB205-041-013)
- (FB204-041-005)
- (FB204-044-005)
- (SEG056E-024)

Bay#2

FCAW welding of weld joint FB3060-001-003, 004, 007~009, 012, 013, 016, 017 located on FB3060-001. Welder is identified as 0045203 (2F). ZPMC QC-CWI is identified as Zhan Hai Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint FB3060-001-001, 026, 021, 044, 005, 006, 010, 011, 014 located on FB3060-001. Welder is identified as 0045203 (2F). ZPMC QC-CWI is identified as Zhan Hai Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint FB3076-001-005 located on FB3076-001. Welder is identified as 0045203 (2F). ZPMC QC-CWI is identified as Zhan Hai Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint FB3076-001-023 located on FB3076-001. Welder is identified as 0045209 (2F). ZPMC QC-CWI is identified as Zhan Hai Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint FB3063-001-003, 004, 007~009, 012, 013, 016, 017 located on FB3063-001. Welder is identified as 0045209 (2F). ZPMC QC-CWI is identified as Zhan Hai Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Cross Beams Update:

CB007-Bay#1- Rectification work is in progress

CB009-Bay#6-

FCAW welding of weld joint CB202G-021-141, 159 located on CB-009. Welder is identified as 220688 (2F). ZPMC QC-CWI is identified as Meng Linnan. The welding variables recorded by QC appeared to comply with the Applicable WPS.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

FCAW welding of weld joint CB202G-021-001~020, 169 located on CB-009. Welder is identified as 220077 (2F) and 220688 (2F). ZPMC QC-CWI is identified as Meng Linnan. The welding variables recorded by QC appeared to comply with the Applicable WPS.

CB012-Bay#8-

FCAW welding of weld joint CB201A-012-002, 014 located on CB-012. Welder is identified as 066687 and 069118 (2F). ZPMC QC-CWI is identified as Zhang Jiang Xin. The welding variables recorded by QC appeared to comply with the Applicable WPS.

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
Reviewed By:	Prue,Erik	QA Reviewer
