

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-008928**Date Inspected:** 12-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:** Xu Xian Ping**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 & TOWER Components**Summary of Items Observed:**

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

BAY 1

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #001 located on Counter Weight CW001A – PP060. Welder is identified as 219189. ZPMC QC is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

FCAW process welding of weld joint #004 located on Cross Beam CB202B – 015. Welder is identified as 216872. ZPMC QC is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – B – U2 – F.

FCAW process welding of weld joint #001 located on Counter Weight CW001B – PP094. Welder is identified as 054460. ZPMC QC is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

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BAY 2

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #045 located on Floor Beam FB3082 – 003. Welder is identified as 062438. ZPMC QC is identified as Zhang Hai Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

FCAW process welding of weld joint #040 located on Floor Beam FB3096 – 001. Welder is identified as 045209. ZPMC QC is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2233 – Tc – U4b – F.

FCAW process welding of weld joint #011 located on Floor Beam FB3082 – 002. Welder is identified as 045203. ZPMC QC is identified as Zhang Hai Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

FCAW process welding of weld joint #024 located on Floor Beam FB3096 – 001. Welder is identified as 206358. ZPMC QC is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2133.

BAY 5

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #002 located on Traveler Rail Bracket TR6A – PP090. Welder is identified as 215009. ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2233 – Tc – U4c – F.

FCAW process welding of weld joint #008 located on Bike Path BK001 – 023. Welder is identified as 205390. ZPMC QC is identified as Zheng Zhi Wei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – B – U4c – F – 1.

FCAW process welding of weld joint #007 located on Traveler Rail Bracket TR1D – PP075. Welder is identified as 217185. ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – Tc – U4c – F.

FCAW process welding of weld joint #004 located on Bike Path BK001 – 022. Welder is identified as 215250. ZPMC QC is identified as Zheng Zhi Wei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – B – U4c – F – 1.

FCAW process welding of weld joint #002 located on Traveler Rail Bracket TR6A – PP072. Welder is identified as 215185. ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2233 – Tc – U4c – F.

FCAW process welding of weld joint #002 located on Bike Path BK001 – 019. Welder is identified as 204342.

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ZPMC QC is identified as Zheng Zhi Wei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – B – U4c – F – 1.

BAY 6

TOWER

This QA Inspector observed the following work in progress:

SMAW process welding of weld joint #1A located on WD1 – A305 – 53M – 4. Welder is identified as 053753. ZPMC QC is identified as Zhang Bao Bo. The welding variables recorded by QC appeared to comply with the WPS – 485 – SMAW – 2G (2F) FCM – Repair – 1.

SMAW process welding of weld joint #8A located on WD1 – A305 – 53M – 1. Welder is identified as 049769. ZPMC QC is identified as Zhang Bao Bo. The welding variables recorded by QC appeared to comply with the WPS – 485 – SMAW – 2G (2F) FCM – Repair – 1.

Cross Beam - 8

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #057 located on Floor Beam FB204 – 019. Welder is identified as 222396. ZPMC QC is identified as Zhou Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – B – U2 – F.

Cross Beam - 9

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #033 located on Cross Beam CB202G – 024. Welder is identified as 220688. ZPMC QC is identified as Meng Lin Nan. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2133.

FCAW process welding of weld joint #036 located on Cross Beam CB202G – 023. Welder is identified as 220688. ZPMC QC is identified as Meng Lin Nan. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

BAY 7

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #059 located on Side Plate SP3026 – 017. Welder is identified as 205774. ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

FCAW process welding of weld joint #023 located on Side Plate SP3026 – 017. Welder is identified as 205774. ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

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Unless otherwise noted, all work 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 - 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Sandeep	Quality Assurance Inspector
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Reviewed By:	Prue,Erik	QA Reviewer
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