

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-009152**Date Inspected:** 19-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		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No	
Rod Oven in Use:	Yes	No	N/A
Weld Procedures Followed:	Yes	No	N/A
Verified Joint Fit-up:	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 #119 located on Cross Beam CB201G – 014. Welder is identified as 216575. ZPMC QC is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the WPS – 345 – FCAW – 2G (2F) – Repair – 1.

BAY 2

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #039 located on Floor Beam FB3013 – 003. Welder is identified as 062438. ZPMC QC is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

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FCAW process welding of weld joint #036 located on Floor Beam FB3013 – 001. Welder is identified as 045203. ZPMC QC is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2133.

FCAW process welding of weld joint #045 located on Floor Beam FB3022 – 001. Welder is identified as 215676. 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 #028 located on Floor Beam FB3013 – 003. Welder is identified as 062438. ZPMC QC is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2133.

BAY 3

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #012 located on Longitudinal Diaphragm LD002 – 046. Welder is identified as 051356. ZPMC QC is identified as Guo Yuan Ting. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – Tc – P4 – F.

FCAW process welding of weld joint #012 located on Longitudinal Diaphragm LD003 – 056. Welder is identified as 051356. ZPMC QC is identified as Guo Yuan Ting. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – Tc – P4 – F.

BAY 5

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #001 located on Traveler Rail Bracket TR2A – PP068. Welder is identified as 068858. ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U4c – F.

FCAW process welding of weld joint #003 located on Traveler Rail 10TR4 – 002. Welder is identified as 217805. ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – B – U2 – F.

FCAW process welding of weld joint #007 located on Traveler Rail Bracket TR1D – PP057. Welder is identified as 068858. ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U4c – F.

FCAW process welding of weld joint #003 located on Traveler Rail 11TR1 – 029. Welder is identified as 217805.

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ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – B – U2 – F.

BAY 6

This QA Inspector observed the following work in progress:

TOWER

SMAW process welding of weld joint #2A located on WD1 – A305 – 77M – 4. Welder is identified as 067707. ZPMC QC is identified as Zhao Chen Sun. 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 #2A located on WD1 – A305 – 77M – 4. Welder is identified as 048659. ZPMC QC is identified as Zhao Chen Sun. The welding variables recorded by QC appeared to comply with the WPS – 345– SMAW – 2G (2F) FCM – Repair.

SMAW process welding of weld joint #8B located on WD1 – A305 – 77M – 4. Welder is identified as 053753. ZPMC QC is identified as Zhao Chen Sun. The welding variables recorded by QC appeared to comply with the WPS – 485 – SMAW – 2G (2F) FCM – Repair – 1.

Cross Beam - 9

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #014 located on Cross Beam CB202A – 009. Welder is identified as 048625. ZPMC QC is identified as Meng Linnan. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U4b – F.

FCAW process welding of weld joint #069 located on Floor Beam FB204 – 022. Welder is identified as 053609. ZPMC QC is identified as Meng Linnan. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U4b – F.

SMAW process welding of weld joint # 183 located on Cross Beam CB202G – 022. Welder is identified as 070007. ZPMC QC is identified as Meng Linnan. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2113.

FCAW process welding of weld joint #088 located on Floor Beam FB204 – 024. Welder is identified as 220688. ZPMC QC is identified as Meng Linnan. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – B – U2a – F – 1.

BAY 7

This QA Inspector observed the following work in progress:

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FCAW process welding of weld joint #025 located on Side Plate SP3026 – 017. Welder is identified as 051246. ZPMC QC is identified as Zhong Dian Xing. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2233 – Tc – U4b – F.

FCAW process welding of weld joint #050 located on Side Plate SP3026 – 017. Welder is identified as 051246. ZPMC QC is identified as Zhong Dian Xing. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2233 – Tc – U4b – F.

FCAW process welding of weld joint #053 located on Side Plate SP3026 – 017. Welder is identified as 051246. ZPMC QC is identified as Zhong Dian Xing. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2233 – Tc – U4b – F.

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
Reviewed By:	Prue,Erik	QA Reviewer
