

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-009161**Date Inspected:** 15-Sep-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

Flux Cored Arc Welding (FCAW) of Longitudinal Diaphragm to Bottom Panel for SEG 64B weld number 027 and 028 for Segment 10CE. The ZPMC welder identified as 055801 was welding in the 2F position. The ZPMC QC identified as Guo Xing 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-2132.

Flux Cored Arc Welding (FCAW) of Longitudinal Diaphragm to Bottom Panel for SEG 64B weld number 015 and 016 for Segment 10CE. The ZPMC welder identified as 214945 was welding in the 2F position. The ZPMC QC identified as Guo Xing 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-2132.

Flux Cored Arc Welding (FCAW) of Floor Beam to Corner Assembly for SEG 052A SSD 16A PP74 weld number 008 for Segment 9BE. The ZPMC welder identified as 044795 was welding in the 3G position. The ZPMC QC identified as Guo Xing Hui was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-P-2233-B-U2-F.

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Flux Cored Arc Welding (FCAW) of Floor Beam to Corner Assembly for SEG 052A SSD 17A PP75 weld number 008 for Segment 9BE. The ZPMC welder identified as 066064 was welding in the 3G position. The ZPMC QC identified as Guo Xing Hui was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-P-2233-B-U2-F.

Flux Cored Arc Welding (FCAW) of Floor Beam to Corner Assembly for SEG 052A SSD 18A PP76 weld number 009 for Segment 9BE. The ZPMC welder identified as 044774 was welding in the 3G position. The ZPMC QC identified as Guo Xing Hui was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-P-2233-B-U2-F.

Shielded Metal Arc Welding (SMAW) on Floor Beam (FL2-1) to Floor Beam (FL3) of SEG 064 SSD 18 PP94 weld Number 010 for Segment 10CE. The ZPMC welder identified as 200113 were welding in the 4G position. The ZPMC QC identified as Waung Xu 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-FCM-1.

Shielded Metal Arc Welding (SMAW) on Floor Beam (FL3) to Side Panel of SEG 052A weld Number 024 for Segment 9BE. The ZPMC welder identified as 067764 were welding in the 4G position. The ZPMC QC identified as Waung Xu 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-FCM-1.

Shielded Metal Arc Welding (SMAW) on Floor Beam (FL3) to Side Panel of SEG 052A weld Number 026 for Segment 9BE. The ZPMC welder identified as 067609 were welding in the 4G position. The ZPMC QC identified as Waung Xu 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-FCM-1.

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
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Reviewed By:	Patterson, Rodney	QA Reviewer
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