

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-009473**Date Inspected:** 08-Oct-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:** 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 Subassemblies**Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Stefan Holmes was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China.

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #010 located on Floor Beam - FB3047-001. Welder is identified as 045209. ZPMC QC is identified as Zhan Hai Feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

FCAW process welding of weld joint #028 located on Floor Beam - FB3047-001. Welder is identified as 045209. ZPMC QC is identified as Zhan Hai Feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

FCAW process welding of weld joint #033 located on Floor Beam - FB3083-001. Welder is identified as 062438. ZPMC QC is identified as Zhan Hai Feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-TC-U4b-F.

FCAW process welding of weld joint #041 located on Floor Beam - FB3083-001. Welder is identified as

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062438. ZPMC QC is identified as Zhan Hai Feng. The welding variables recorded by QC appeared to comply with the
WPS-B-T-2232-TC-U4b-F.

SMAW process welding of weld joint #015 located on Floor Beam - FB3037-001. Welder is identified as 045251. ZPMC QC is identified as Zhan Hai Feng. The welding variables recorded by QC appeared to comply with the
WPS-B-P-2112.

SMAW process welding of weld joint #016 located on Floor Beam - FB3037-001. Welder is identified as 045251. ZPMC QC is identified as Zhan Hai Feng. The welding variables recorded by QC appeared to comply with the
WPS-B-P-2112.

SMAW process welding of weld joint #021 located on Floor Beam - FB3085-001. Welder is identified as 049972. ZPMC QC is identified as Zhan Hai Feng. The welding variables recorded by QC appeared to comply with the
WPS-B-P-2112.

SMAW process welding of weld joint #022 located on Floor Beam - FB3085-001. Welder is identified as 049972. ZPMC QC is identified as Zhan Hai Feng. The welding variables recorded by QC appeared to comply with the
WPS-B-P-2112.

FCAW process welding of weld joint #001 located on Traveller Rail - 10TR2-009. Welder is identified as 215684. ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-BU2-F.

FCAW process welding of weld joint #001 located on Traveller Rail - 10TR2-008. Welder is identified as 215684. ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-BU2-F.

FCAW process welding of weld joint #002 located on Bike Path - BK001-037. Welder is identified as 205390. ZPMC QC is identified as Wang Liang. 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 - BK001-038. Welder is identified as 215009. ZPMC QC is identified as Wang Liang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-TC-U4c-F.

FCAW process welding of weld joint #002 located on Bike Path - BK001-039. Welder is identified as 217185. ZPMC QC is identified as Wang Liang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-TC-U4c-F.

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Ultrasonic Testing

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 members are identified as OBG Components. The weld designations reviewed are as follows:

CB-15

1. CB202C-015-001
2. CB202C-015-004

OBG U-rib Connection Plates

1. USPL1-208-001/002

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the 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 , who represents the Office of Structural Materials for your project.

Inspected By:	Holmes,Stefan	Quality Assurance Inspector
Reviewed By:	Hall,Steven	QA Reviewer
