

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-009489**Date Inspected:** 16-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:	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:

SMAW welding of weld joint 160 located on PCMK CB202G-020 (CB8). Welder is identified as 070007. ZPMC QC is identified as Liu Fa Wen. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint 002 located on PCMK CB202A-009 (CB8). Welder is identified as 220688. ZPMC QC is identified as Liu Fa Wen. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint 005 located on PCMK TR5C-PP091. Welder is identified as 215185. ZPMC QC is identified as Li Yong. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint 005 located on PCMK TR1C-PP084. Welder is identified as 215009. ZPMC QC is identified as Li Yong. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint 001 located on PCMK 11TR5-001 thru 11TR5-007. Welder is identified as 205390. ZPMC QC is identified as Li Yong. The welding variables recorded by QC appeared to comply with the

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Applicable WPS.

FCAW welding of weld joint 002 located on PCMK 11TR5-001 thru 11TR5-007. Welder is identified as 215250. ZPMC QC is identified as Li Yong. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint 003 located on PCMK 11TR1-024 thru 11TR1-026 and 10TR2-007. Welder is identified as 215689. ZPMC QC is identified as Li Yong. The welding variables recorded by QC appeared to comply with the Applicable WPS.

SMAW welding of weld joint 001 located on PCMK WD1-A305-77M. Welder is identified as 49769. ZPMC QC is identified as Xu Xian Ping. The welding variables recorded by QC appeared to comply with the Applicable WPS.

SMAW welding of weld joint 01a located on PCMK WD1-A305-77M. Welder is identified as 53753. ZPMC QC is identified as Xu Xian Ping. The welding variables recorded by QC appeared to comply with the Applicable WPS.

SMAW welding of weld joint 09b located on PCMK WD1-A305-77M. Welder is identified as 06707. ZPMC QC is identified as Xu Xian Ping. The welding variables recorded by QC appeared to comply with the Applicable WPS.

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
