

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-009501**Date Inspected:** 01-Oct-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:** Li zhi jiang**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**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, D.Sukanthan 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 # BAY 02

Flux Cored Arc Welding Process:

Welding of weld joint -013,014 located on PCMK FB3002-001. Welder is identified as 206358. ZPMC QC is identified as Yang Qing fang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

Welding of weld joint -015,016 located on PCMK FB6501-001. Welder is identified as 045203. ZPMC QC is identified as Yang Qing fang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

Welding of weld joint -002,015,016 located on PCMK FB3084-001. Welder is identified as 045203. ZPMC QC is identified as Yang Qing fang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

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OBG # BAY 03

Flux Cored Arc Welding Process:

Welding of weld joint –098,099 located on PCMK CSD4-PP100. Welder is identified as 044824. ZPMC QC is identified as Yin dong hai. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-TC-U4b-F.

Welding of weld joint –063,064 located on PCMK CSD9-PP099. Welder is identified as 044824. ZPMC QC is identified as Yin dong hai. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-TC-U4b-F.

Welding of weld joint –098,099 located on PCMK CSD3-PP98. Welder is identified as 044824. ZPMC QC is identified as Yin dong hai. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-TC-U4b-F.

Welding of weld joint –098,099 located on PCMK CSD3-PP100. Welder is identified as 044824. ZPMC QC is identified as Yin dong hai. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-TC-U4b-F.

Welding of weld joint –098,099 located on PCMK CSD5-PP99. Welder is identified as 044824. ZPMC QC is identified as Yin dong hai. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-TC-U4b-F.

OBG # BAY 06

Shield Metal Arc Welding Process:

Welding of weld joint –100,101 located on PCMK CB202G-020. Welder is identified as 048800. ZPMC QC is identified as Zhou jie. The welding variables recorded by QC appeared to comply with the WPS-B-P-2112.

Welding of weld joint –134,135 located on PCMK CB202G-019. Welder is identified as 070007. ZPMC QC is identified as Zhou jie. The welding variables recorded by QC appeared to comply with the WPS-B-P-2112.

OBG # BAY 01 (Cross Beam 15)

During in-process visual inspection of the OBG Cross Beam 15 components in Bay 1, This QA inspector witnessed that ZPMC QC Personnel Mr.Han feng discovered a total of two joints (2) Repair three (R3) non-conforming indications found with ultrasonic testing for the following Cross beam components.

(FB204-045-028)

(FB204-046-040)

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract

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documents.

Summary of Conversations:

No Relevant Conversation

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 150-00422372, who represents the Office of Structural Materials for your project.

Inspected By:	Sukanthan,Dhanasingh	Quality Assurance Inspector
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Reviewed By:	Hall,Steven	QA Reviewer
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