

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-009538**Date Inspected:** 11-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.

QA Inspector observed the following work in process:

FCAW welding of TR5C-PP77-005 by welding operator 0215185 utilizing WPS-B-T-2231-TC-U4c-F-1.

FCAW welding of TR5C-PP77-005 by welding operator 0215185 utilizing WPS-B-T-2233-TC-U4c-F-1.

FCAW welding of BK001-007-001/003 by welding operator 053742 utilizing WPS-B-T-2231-B-U4c-F-1.

FCAW welding of BK001-030-001/003 by welding operator 058174 utilizing WPS-B-T-2231-B-U4c-F-1.

FCAW welding of BK001-021-008 by welding operator 0215250 utilizing WPS-B-T-2231-B-U4c-F-1.

QA Inspector performed in process survey of Deck panel fit-up and tack welding preparation for automatic welding process with the following results:

DP3026-001(12CE), panel fit, tacked and first SAW full length weld pass present. Production getting set up for final weld pass.

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DP3042-001(12AW), panel fit, tacked and first SAW full length weld pass present. Production getting set up for final weld pass.

DP3005-001(12AE), panel fit, tacked and first SAW full length weld pass present. Production getting set up for final weld pass.

DP3004-001, Panel fully fit and tacked. Tack weld partially ground. No MT performed by ZPMC. Partially ground tack welds have visibly rejectable longitudinal indications. No action taken by this inspector pending completion of grinding preparation and MT by ZPMC.

QA Inspector performed QA verification UT pursuant to the requirements of AWS D1.5; 2002 on Traveller rail Brackets identified as TR8A-PP8.5-001/002 and TR7A-PP8.5-001/002 with no rejectable indications noted. QA Inspector generated a UT report for this date.

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
