

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-010097**Date Inspected:** 27-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) on Corner Assembly Side Panel Splice of weld joint SEG 058A for OBG assembly weld number 010 for Segment 9EE. The ZPMC welders identified as 050242 was welding in the 1G position. The ZPMC QC identified as Wang Xu was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-T-2231-B-U2-F.

Flux Cored Arc Welding (FCAW) on Floor Beam (FL1) to CA Diaphragm of weld joint SEG 058 SSD 19A PP85 for OBG assembly weld number 007 for Segment 9EE. The ZPMC welders identified as 058551 was welding in the 3G position. The ZPMC QC identified as Wang Xu was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-T-2233-B-U2-F.

Shielded Metal Arc Welding (SMAW) on Floor Beam top flange to CA Diaphragm Stiffener of weld joint SEG058 SSD19 PP83 OBG assembly weld number 003 for Segment 9EE. The ZPMC welder identified as 049339 was welding in the 4G position. The ZPMC QC identified as Wang Xu was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the

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WPS-B-T-2214-B-U2-FCM-1.

Shielded Metal Arc Welding (SMAW) on CA Deck Panel to Edge Panel of weld joint SEG056* OBG assembly weld number 047 for Segment 9DE. The ZPMC welder identified as 200114 was welding in the 4G position. The ZPMC QC identified as Wang Xu was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-T-2214-Tc-U4b-FCM-1.

Flux Cored Arc Welding (FCAW) on CA Deck Panel to Edge Panel of weld joint SEG056* OBG assembly weld numbers 023 and 024 for Segment 9DE. The ZPMC welder identified as 044774 was welding in the 3G position. The ZPMC QC identified as Wang Xu was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-T-2233-B-U2-F.

Flux Cored Arc Welding (FCAW) on Floor Beam (FL3) to DP Diaphragm of weld joint SEG 056 SSD 18 PP82 for OBG assembly weld number 005 for Segment 9DE. The ZPMC welders identified as 044795 was welding in the 3G position. The ZPMC QC identified as Wang Xu was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-T-2233-B-U2-F.

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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