

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-010104**Date Inspected:** 15-Nov-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:** 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**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Larry Viars was present during the times noted above for observations relative to the work being performed.

North of Bay 13-

This QA Inspector observed the following work in progress: Shielded Metal Arc Welding (SMAW) of OBG segment 7BW drainage plate weld, OBW7D-026 and 027. ZPMC welders were identified as 067829 and 067665. ZPMC QC is identified as Li Ping. ZPMC CWI was identified as Li Yan Hua. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-4114-1.

Bay 14-

This QA Inspector observed the following work in progress: Flux Cored Arc Welding (FCAW) of OBG segment 10BW angle to bottom panel stiffener flange welds, SSD29-PP90.5-191~196. ZPMC welder was identified as 215676. ZPMC QC is identified as Xu Tao. ZPMC CWI was identified as Shen Fu You. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2132.

Submerged Arc Welding (SAW) of Deck panel DP291A to DP690A butt splice weld, SEG063*-008. ZPMC welder was identified as 045265. ZPMC QC is identified as Xu Tao. ZPMC CWI was identified as Shen Fu You. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-223(2)1T-2.

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Flux Cored Arc Welding (FCAW) of OBG segment 9DW lifting lug to floor beam welds, SSD10A-PP80-240 and 250. ZPMC welder was identified as 047866. ZPMC QC is identified as Xu Tao. ZPMC CWI was identified as Shen Fu You. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2231-TC-U4b-F-2.

Submerged Arc Welding (SAW) of Deck panel DP158A to DP131A butt splice weld, SEG067*-002. ZPMC welder was identified as 044771. ZPMC QC is identified as Guo Hui. ZPMC CWI was identified as Lv Li Qing. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2221-B-L2C-S-2.

South of Blast Bay-

This QA Inspector performed Magnetic Particle Testing (MT) verification of welds previously tested and accepted by ZPMC for OBG Segment 7AW. For additional information see the TL-6028 MT report generated this date. The following welds that were tested:

Longitudinal Diaphragm welds- SEG033B-002, 003, 010, 012, 015 and 017

Angle to Side Panel stiffener flange welds – SSD29-PP48.5-51~58

Floor beam to Side panel welds- SSD13-PP49-091, 093, 095 and 097

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

Summary of Conversations:

Only general conversation between QA and QC occurred 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, 150 0042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Viars,Larry	Quality Assurance Inspector
Reviewed By:	Dawson,Paul	QA Reviewer
