

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-010183**Date Inspected:** 08-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 Components		

Summary of Items Observed:

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

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This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member is identified as OBG Components. The weld designations reviewed are as follows:

-(FB3098-001-046, 047)
-(FB3093-001-046, 047)
-(FB3096-001-046, 047)
-(FB3090-001-044, 046)
-(FB3022-001-039, 040)
-(FB3021-001-039, 040)
-(FB3026-001-035, 036)
-(FB3052-001-043, 045)
-(FB3055-001-043, 045)
-(FB3051-001-043, 045)
-(FB3089-001-069, 070)
-(FB3046-001-069, 070)

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SMAW welding of weld joint Seg51A-040 located on Segment 9BW. Welder is identified as 037996 and

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066361(4G). ZPMC QC is identified as Wang Xu. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-Tc-U4b-FCM-1.

SMAW welding of weld joint Seg51A-041 located on Segment 9BW. Welder is identified as 047864 (4G). ZPMC QC is identified as Wang Xu. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-Tc-U4b-FCM-1.

FCAW welding of weld joint Seg055A-032 located on Segment 9DW. Welder is identified as 050316 and 066734 (1G). ZPMC QC is identified as Wang Xu. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231T.

FCAW welding of weld joint Seg63B-018, 023 located on Segment 10CW. Welder is identified as 047866 (2G). ZPMC QC is identified as Wang Xu. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232-Tc-U4b-F.

FCAW welding of weld joint Seg63B-015, 016 located on Segment 10CW. Welder is identified as 047866 (2F). ZPMC QC is identified as Wang Xu. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232.

FCAW welding of weld joint Seg63C-015, 016 located on Segment 10CW. Welder is identified as 202122 (2F). ZPMC QC is identified as Wang Xu. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232.

FCAW welding of weld joint SSD29-PP83.5-171, 206 located on Segment 9EW. Welder is identified as 215676 (2F). ZPMC QC is identified as Wang Xu. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232.

SMAW welding of weld joint Seg55*-045 located on Segment 9EW. Welder is identified as 067829 and 037723 (4G). ZPMC QC is identified as Wang Xu. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-Tc-U4b-FCM-1.

SMAW welding of weld joint Seg55*-047 located on Segment 9EW. Welder is identified as 066361 and 037996 (4G). ZPMC QC is identified as Wang Xu. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-Tc-U4b-FCM-1.

Unless otherwise noted, all observed on this date appeared to generally comply with 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 Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

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Inspected By:	Patel,Hiranch	Quality Assurance Inspector
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Reviewed By:	Patterson,Rodney	QA Reviewer
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