

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-010354**Date Inspected:** 18-Nov-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**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:** 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, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

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SMAW welding of weld joint 4G-038 located on PCMK SEG059* of 10AW welder is identified as 066329. ZPMC QC is identified as Mr.Xu tao. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2214-Tc-U4b-FCM-1.

FCAW welding of weld joint 1G-221 located on PCMK SSD14A-PP77 of 9CW welder is identified as 047866. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2231-TC-U4b-F.

SAW welding of weld joint 1G-003 located on PCMK SEG3005L of 12BW welder is identified as 045265. ZPMC QC is identified as Mr.Xu tao. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2221-B-L2C-S-2.

Visual inspection of weld joint fit up of Side plate to side plate of Lift 12AW weld no is identified as SEG30004AL-004 checked with ZPMC QC Mr.Li ming yang and dimension recorded.

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WELDING INSPECTION REPORT

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FCAW welding of weld joint 3G-024 located on PCMK SEG067A of 11BW welder is identified as 058551.ZPMC QC is identified as Mr.Zhang qiao. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2233-Tc-U4b-F.

SMAW welding of weld joint 4G-024 located on PCMK SEG068A of 11BE welder is identified as 244772.ZPMC QC is identified as Mr.Guo xing hui. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2214-Tc-U4b-FCM-1.

OUTSIDE SEGMENT

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 members are identified as Segment 7DE. The weld designations reviewed are as follows:

SSD17-PP57-004,010,013,215,088.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract 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-15--0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Chadra	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
