

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-010451**Date Inspected:** 23-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:** Chen Xi**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:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials (OSM) Quality Assurance (QA) Inspector, D.Sukanthan 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 # CROSS BEAM 16 (BAY # 5)

Flux Cored Arc Welding Process:

Welding of weld joint FB204-051-058. Welder is identified as 217185. ZPMC Quality Control Personnel (QC) is identified as Zheng zhi wei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-B-U2-F.

Welding of weld joints FB204-050-164,146. Welder is identified as 204342. ZPMC QC is identified as Zheng zhi wei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-B-U2-F.

OBG # CROSS BEAM 9 (BAY # 6)

Shield Metal Arc Welding Process:

Welding of weld joints FB204-024-071,072. Welder is identified as 048617. ZPMC QC is identified as Lin chuan

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gang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2113.

OBG # CROSS BEAM 13 (BAY # 8)

Flux Cored Arc Welding Process:

Welding of weld joint FB204-039-064. Welder is identified as 215082. ZPMC QC is identified as Zhao cheng jian. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U2-F.

Shield Metal Arc Welding Process:

Welding of weld joint FB204-039-057. Welder is identified as 069896. ZPMC QC is identified as Zhao cheng jian. The welding variables recorded by QC appeared to comply with the WPS-B-P-2212-B-U2.

OBG # SEGMENT 11BW (BAY # 13)

Shield Metal Arc Welding Process:

Welding of weld joint SEG 067A-026. Welder is identified as 048617. ZPMC QC is identified as Zhang qiao. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-TC-U4b-FCM-1.

OBG # SEGMENT 11AE (BAY # 13)

Flux Cored Arc Welding Process:

Welding of weld joint SSD19-PP95-005. Welder is identified as 044795 / 055564. ZPMC QC is identified as Zhang qiao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132.

OBG # SEGMENT 12AW (BAY # 14)

Submerged Arc Welding Process:

Welding of weld joints SEG 300 4AL-002,004. Welder is identified as 045265. ZPMC QC is identified as Xutao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-B-L2C-S-2.

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 150-00422372, who represents the Office of Structural Materials for your project.

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Inspected By:	Sukanthan,Dhanasingh	Quality Assurance Inspector
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Reviewed By:	Hall,Steven	QA Reviewer
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