

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-011543**Date Inspected:** 09-Jan-2010**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:** Zhu Zhong Hai**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.

Segment 7CW

This QA Inspector performed a preliminary random visual inspection after the grit blast of the internal components of the side plate, bottom plate and corner assemblies of this segment. Areas of visual weld defects that will require welding were taped and will be repaired after the coating is applied. ZPMC QC personnel are aware of these areas and were present during the inspection.

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SMAW welding of weld joint SSD18-PP100-253, 252 located on Segment 11BE. Welder is identified as 044772 (4G). ZPMC QC is identified as Guo Xing Hui. 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 SSD18A-PP100-222, 252 located on Segment 11BE. Welder is identified as 044772 (4G). ZPMC QC is identified as Guo Xing Hui. 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 SSD19A-PP95-134 located on Segment 11AE. Welder is identified as 200113 (4G). ZPMC QC is identified as Guo Xing Hui. The welding variables recorded by QC appeared to comply with the

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Applicable WPS-B-P-2214-B-U2-FCM-1.

FCAW welding of weld joint SSD20-PP103-256, 257 located on Segment 11CE. Welder is identified as 058551 (2G). ZPMC QC is identified as Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232-Tc-U4b-F.

FCAW welding of weld joint SSD20A-PP103-256, 257 located on Segment 11CE. Welder is identified as 051356 (2G). ZPMC QC is identified as Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232-Tc-U4b-F.

FCAW welding of weld joint SSD29A-PP95.5-059~094 located on Segment 11AW. Welder is identified as 048038 (3F). ZPMC QC is identified as Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2133.

FCAW welding of weld joint SSD29-PP95.5-099~132 located on Segment 11AW. Welder is identified as 048038 (2F). ZPMC QC is identified as Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132.

FCAW welding of weld joint Seg065*-302 located on Segment 11AW. Welder is identified as 044795 (2G). ZPMC QC is identified as Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232-Tc-U4c-F.

FCAW welding of weld joint SSD29-PP96.5-133~166 located on Segment 11AE. Welder is identified as 055564 (3F). ZPMC QC is identified as Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2133.

FCAW welding of weld joint SSD29-PP96.5-211~244 located on Segment 11AE. Welder is identified as 055564 (3F). ZPMC QC is identified as Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2133.

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.

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