

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-012646**Date Inspected:** 14-Dec-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**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:****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:****Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Daniel Barrentine was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China. QA Inspector observed and/or found the following:

SMAW base metal repair welding at weld joint 002 located on section OB5W.

Welder is identified as Mr. Hu Yanming (0622092). ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G (4F).

FCAW welding on section 6AW to 6BW weld joints 56 and 57 located at OBW6 cross beam side of segment.

Welder is identified as Mr. Li Shoufu (066674). ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

FCAW welding on weld joints 23, 24 and 25 located at DP623-001 cross beam side of segment.

Welder is identified as Mr. Dai Lu (048659). ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-B-T-3213-B-U3-b.

FCAW welding on section 6BE to 6CE at weld joints 37, 38, 39 and 40 located at SP362-001 bike path side of segment. Welder is identified as Mr. Li Guimin (220069). ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-B-U2-F.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

SMAW welding on section 5AE at weld joint 001 located at CA023 cross beam side of segment.
Welder is identified as Mr. Zhao Aifei (067942). ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G (2F)-Repair-1 and WR8823.

SMAW welding on weld joints 030 and 028 located at SEG024A cross beam side of segment.
Welder is identified as Mr. Zhao Aifei (067942). ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G (2F)-Repair-1 and WR8824.

FCAW welding on section 6CE at weld joints 037 and 038 located at SP309-001 on bike path side of segment.
Welder is identified as Mr. Zhang Hanming (220066). ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-B-T-2131.

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 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Barrentine, Daniel	Quality Assurance Inspector
Reviewed By:	Carreon, Albert	QA Reviewer
