

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-013354**Date Inspected:** 03-Apr-2010**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:	Zhou Cheng/Sun Bo/Zhu Tian Sh			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.

Bay#8

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:

-(BK004A1-053-009)

Bay#2

SAW welding of weld joint FB3220-001-001 located on FB3220-001. Welder is identified as 045270 (1G). ZPMC QC is identified as Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2221-B-L2c-S-2.

SAW welding of weld joint FB3189-001-002 located on FB3189-001. Welder is identified as 250050 (1G). ZPMC QC is identified as Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2221-B-L2c-S-2.

FCAW welding of weld joint FB3185-001-006, 002, 004 located on FB3185-001. Welder is identified as 045209 (1G). ZPMC QC is identified as Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-B-U2-F-1.

WELDING INSPECTION REPORT

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FCAW welding of weld joint FB3188-001-009, 002, 003 located on FB3188-001. Welder is identified as 045209 (1G). ZPMC QC is identified as Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-B-U2-F-1.

Bay#8

FCAW welding of weld joint BK004A7-061-051, 200, 052, 201 located on BK004A. Welder is identified as 219414 and 054460 (2F). ZPMC QC is identified as Zhao Cheng Jian. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132.

FCAW welding of weld joint BK004A7-064-009, 010, 132, 133 located on BK004A. Welder is identified as 054460 and 219414 (2F). ZPMC QC is identified as Zhao Cheng Jian. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132.

FCAW welding of weld joint BK004A6-055-74 located on BK004A. Welder is identified as 500479 and 054459 (2F). ZPMC QC is identified as Zhao Cheng Jian. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132.

Bay#19

SAW welding of weld joint BK004A1-016-009 located on BK004A. Welder is identified as 062816 (1G). ZPMC QC is identified as Zhou Chang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2221-B-L2c-S-2.

SAW welding of weld joint BK004A1-017-009 located on BK004A. Welder is identified as 062816 (1G). ZPMC QC is identified as Zhou Chang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2221-B-L2c-S-2.

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:	McClendon,Timothy	QA Reviewer
