

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:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023382**Date Inspected:** 29-Apr-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:** Shen Fu Yoo**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 Trial Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S. Manjunath. Math. 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:

BAY 14

Deck Panel

Submerged Arc Welding (SAW) Deck plate DP145A to DP118A Weld Joint No. SEG041*-002 in progress.

Welder is identified as 045265. ZPMC QC is identified as Mr. Li Ming Yang and ZPMC CWI is identified as Mr. Shen Fu Yoo. The welding variables recorded by QC appeared to comply with the B-T-2221-B-L2C-S-2.

Shielded Metal Arc Welding (SMAW) Side plate SP-476-001 Weld Joint No. from 015 to 028 in progress. Welder

is identified as 067610. ZPMC QC is identified as Mr. Li Ming Yang and ZPMC CWI is identified as Mr. Shen Fu Yoo. The welding variables recorded by QC appeared to comply with the B-P-2114-B-U2.

Flux Cored Arc Welding (FCAW) for Longitudinal Diaphragm for SEG 039B weld Joint No. 38 and 39 in

progress. Welder is identified as 201215. ZPMC QC is identified as Mr. Li Ming Yang and ZPMC CWI is identified as Mr. Shen Fu Yoo. The welding variables recorded by QC appeared to comply with the WPS

B-T-2132.

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Flux Cored Arc Welding (FCAW) for 7DW Deck plate DP198-001 Weld Joint No. 013, 024, 033, 042, 052, 060, 070, 078, 086, 094, 102, 112, 120, 128 and 136 in progress. Welder is identified as 066401 and 067103. ZPMC QC is identified as Mr. Li Ming Yang and ZPMC CWI is identified as Mr. Shen Fu Yoo . The welding variables recorded by QC appeared to comply with the WPS-B-T-2122; WPS-B-T-2133 and WPS –B-T-2233-TC-U4b-F.

Flux Cored Arc Welding (FCAW) for 7EW Deck plate DP118-001 Weld Joint No. 050, 055, 063, 071, 049, 059, 067, 075, 047, 052, 057 and 068 in progress. Welder is identified as 067947. ZPMC QC is identified as Mr. Li Ming Yang and ZPMC CWI is identified as Mr. Shen Fu Yoo . The welding variables recorded by QC appeared to comply with the WPS-B-T-2122; WPS-B-T-2133 and WPS –B-T-2233-TC-U4b-F.

Flux Cored Arc Welding (FCAW) for 7PW Deck plate DP117-001 Weld Joint No. 082, 092, 095, 103, 084, 089, 097, 105, 081, 086, 094, 009, 038, 028, 012, 018, 010, 021, 043 and 036 in progress. Welder is identified as 066401 and 067103. ZPMC QC is identified as Mr. Li Ming Yang and ZPMC CWI is identified as Mr. Shen Fu Yoo . The welding variables recorded by QC appeared to comply with the WPS-B-T-2122; WPS-B-T-2133 and WPS –B-T-2233-TC-U4b-F.

Flux Cored Arc Welding (FCAW) for 7BW Deck plate DP196-001 Weld Joint No. 103, 108, 116, 124, 132, 102, 112, 120, 128, 136, 100, 105, 110, 113, 121 and 129 in progress. Welder is identified as 068852. ZPMC QC is identified as Mr. Li Ming Yang and ZPMC CWI is identified as Mr. Shen Fu Yoo . The welding variables recorded by QC appeared to comply with the WPS-B-T-2122; WPS-B-T-2133 and WPS –B-T-2233-TC-U4b-F.

Flux Cored Arc Welding (FCAW) for 7BW Deck plate DP227-001 Weld Joint No. 010, 016, 025, 034, 008, 014, 019, 028, 032, 007, 013, 022 and 031. Deck Plate DP-115-001 Weld Joint No. 012, 018, 027, 036, 045, 011, 017, 026, 035, 044, 009, 015 and 033. Deck Plate DP-250_001 Weld Joint No. 014, 020, 029, 038, 013, 019, 028, 033, 017, 026, 035 and 044 in progress. Welder is identified as 067275, 066012 and 205091. ZPMC QC is identified as Mr. Li Ming Yang and ZPMC CWI is identified as Mr. Shen Fu Yoo . The welding variables recorded by QC appeared to comply with the WPS-B-T-2122; WPS-B-T-2133 and WPS –B-T-2233-TC-U4b-F.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations were reported on this date.

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:	Math,Manjunath	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer
