

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-023389**Date Inspected:** 04-May-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

Orthotropic Box Girder (OBG)

Shielded Metal Arc Welding (SMAW) for Longitudinal Diaphragm for 7DW Drawing No. SEG 039B and weld Joint No. SEG039B-001-052 is in progress. Welder is identified as 047856. 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-2214-Tc-U4b.

Shielded Metal Arc Welding (SMAW) for Longitudinal Diaphragm for 7AW Drawing No. SEG 033C Weld Joint No. SEG033C-004 is in progress. Welder is identified as 047864. 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-2214-Tc-U4b.

Flux Cored Arc Welding (FCAW) for Longitudinal Diaphragm for 6CW Drawing No. SEG 031F Weld Joint No. SEG033F-034 is in progress. Welder is identified as 067947. ZPMC QC is identified as Mr. Li Ming Yang and

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

ZPMC CWI is identified as Mr. Shen Fu Yoo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-Tc-U4b-F.

Shielded Metal Arc Welding (SMAW) Section-6AW Weld Joint No. SSD031-PP38.5 from 085 to 122 is in progress. Welder is identified as 207540. 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-P-2213.

Shielded Metal Arc Welding (SMAW) for Longitudinal Diaphragm for 7CW Drawing No. SEG 037F Weld Joint No. SEG037F-006 is in progress. Welder is identified as 066361. 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-P-2214-Tc-U4b.

Shielded Metal Arc Welding (SMAW) for Longitudinal Diaphragm for 7DW Drawing No. SEG 039C Weld Joint No. SEG039C-042 is 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-2214-Tc-U4b.

Submerged Arc Welding (SAW) Section-9BW Base Plate BP098 to –BP044 Weld Joint No. Seg 051A-003 is in progress. Welder is identified as 066422. 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-2221-B-L2-C-S-2.

Submerged Arc Welding (SAW) Section-9BW Base Plate BP101A to –BP047 Weld Joint No. 057A-005 is in progress. Welder is identified as 066422. 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-2221-B-L2-C-S-2.

Submerged Arc Welding (SAW) Section-9BE Base Plate BP179A to –BP71A Weld Joint No. 052A is in progress. Welder is identified as 044755. 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-2221-B-L2-C-S-2.

BAY 19

Bike Path

Grinding and Welding for Bike Path BK 4A-005 in progress. Welder is identified as 062772. ZPMC QC is identified as Mr. Sheng Jian Guo and ZPMC CWI is identified as Mr. Liu Hua Wen.

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.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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
