

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-005748**Date Inspected:** 15-Mar-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Likun & Li Ming**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 Assembly, Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Joe Alaniz was present during the times noted above for observations relative to the work being performed.

This QA inspector performed VT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. The member(s) is/are identified as Lift 1 East Tower Skin E stiffeners. The weld designations reviewed are as follows:

Bay 11

ESD1-SA227A/B:

1. 73-86

2. 18-31

This QA Inspector performed Ultrasonic Testing (UT) on approximately 15% of CJP on the OBG welds previously accepted by ZPMC ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3. The QA Inspector observed no rejectable indications at the time of testing. The QA Inspector generated a TL-6027 UT report on this date. Welds UT verified were identified as listed below

BAY 9

LB002-001:

1. 001

2. 037

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3.061

This QA Inspector observed the following work in progress:

Bay 10

ZPMC's qualified welding personnel are identified as Mrs. Xu Yang (052917) and Mrs. Wang Shougin (201750) performing groove welding of weld joint SSD1-TL5B/L-4A/ K-44B filler passes. The personnel were observed welding in the 1G (flat) position utilizing a Submerged Arc Welding (SAW) process. ZPMC QC identified Mr. Li Ming and was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-C-U2b-S-2.

Bay 11

This QA Inspector observed the following work in progress:

ZPMC's qualified welding personnel are identified as Mr. Xue Yian (040634) and Mrs. Yang Meizhen (042195) performing groove welding of weld joint ESD1-FCSA3-2 B/C-66A and ESD1-FBSA3-2A/C-9A,10A, 12A,14, 16A, 19, 22A & 23/ K-44B filler passes. The personnel were observed welding in the 1G (flat) position utilizing a Submerged Arc Welding (SAW) process. ZPMC QC identified Mr. Li Ming and Mr. Li Le was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-U3c-S-2 and WPS-B-T-2321-B-P3-S-2.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

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 (134-8257-0045), who represents the Office of Structural Materials for your project.

Inspected By:	Alaniz,Joe	Quality Assurance Inspector
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Reviewed By:	Carreon,Albert	QA Reviewer
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