

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-005808**Date Inspected:** 18-Mar-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Xi**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**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector Larry Viars was present during the times noted above for observations relative to the work being performed.

Bay 7-

This QA inspector performed Ultrasonic Testing (UT) of approximately 15% 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 Bottom Plate Stiffener welds. The weld identification numbers are as follows: BP159-001-001, 002, 019, 021, BP132-001-019, 021, BP078-001-019, 021, BP105-001-004, 023, 025, BP186-001-002, 019, 021.

Bay 19-

This QA inspector performed Ultrasonic Testing (UT) of approximately 15% 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 Bottom Plate splice welds. The weld identification number is as follows: BP025-004-001, 002 and 003.

Bay 2-

This QA Inspector observed the following work in progress: FCAW welding of weld joints 140 and 314 located

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on OBG Segment 1E. ZPMC welders were identified as 067184 and 067275. ZPMC QC is identified as Chen Ying Xin. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2233-B-U2-F.

Bay 11-

This QA Inspector observed the following work in progress: FCAW welding of Lift 1 North Tower Skin C and D stiffener surfaces for weld build up to achieve the required length (CWR087). ZPMC welders were identified as 203977, 053819, 054069, 068501, 057180, 201825 and 040533. ZPMC QC is identified as Chen Li Kun. The welding appeared to be in conformance with welding procedure specification, WPS-345-FCAW 3G (3F)- Repair.

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

Summary of Conversations:

Only general conversations between QA and QC occurred 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 150 0042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Viars,Larry	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
