

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-006624**Date Inspected:** 05-May-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:** Tu Jian**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:** Tower**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 11-

During random verification Magnetic Particle Testing (MT) of Lift 3 East Tower Skin Plate D longitudinal stiffener welds, Caltrans Quality Assurance (QA) Inspector discovered a 30 mm long crack on weld ESD1-ESD1-FDSA3- 2 B/C-22. ZPMC personnel excavated the indication approximately 3 mm below the stiffener surface, crack was still present. These welds have been one hundred percent MT tested and inspected by ZPMC Quality Control MT Technicians. ZPMC QC stated a critical weld repair report would be submitted for Caltrans Engineering review and ZPMC will issue a Non Conformance Report for the noted discontinuity. Please see the attached photos below.

Bay 10-

QA Inspector observed the following work in progress: FCAW welding of weld joint 055 located on South Tower Lift 2 Skin C to D corner joint SSD1-5 J/L. ZPMC welder was identified as 201825. ZPMC QC is identified as Tu Jian. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2331-TC-P4-F.

QA Inspector observed the following work in progress: SAW welding of weld joint 1A located on ESD1- A/G 7 B/H. ZPMC welder was identified as 050295. ZPMC QC is identified as Tu Jian. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2221-B-U3c-S-2.

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



Summary of Conversations:

As identified within the contents of this report.

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 Serge Sinevod, 134 8257 0045, who represents the Office of Structural Materials for your project.

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