

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:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-007239**Date Inspected:** 10-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:** Sun Wei / Sun Bo**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:**

The Caltrans (CT) Quality Assurance (QA) Inspector Charlie Franco was present at the time requested to randomly observe welding and associated operations being performed for the Tower and Orthotropic Box Girders (OBG).

Outside at Vertical Milling Machine:

The QA Inspector randomly observed a ZPMC Machine Operator utilizing the Vertical Milling Apparatus to mill the bottom edges of Skin Plates A through E and attached longitudinal stiffeners on Lift 1 South Tower. The attached photograph provides additional detail.

Heavy Equipment Shop Bay 11:

The QA Inspector randomly observed ZPMC welder Zhang Ming Wu ID 066283, utilizing the Flux Cored Arc Welding (FCAW) Process with ZPMC Weld Procedure Specification WPS-B-T-4333-TC-P4-F in the 3F (Vertical Fillet) Position to weld the longitudinal stiffeners on Skin Plate A to 77M Upper Diaphragm in Lift 2 West Tower Shaft. The QA Inspector randomly observed ZPMC QC monitoring weld parameters. Weld parameters appeared to comply with contract requirements.

The QA Inspector randomly observed ZPMC welder Zhang Bing Hua ID 053316, utilizing the FCAW Process with ZPMC WPS WPS-B-T-2332-TC-U4b-F in the 2G (Horizontal Groove) Position to weld the long seam between Skin Plate B and C above 68M Upper Diaphragm in Lift 2 West Tower Shaft. The QA Inspector

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

randomly observed ZPMC QC monitoring weld parameters. Weld parameters appeared to comply with contract requirements.

The QA Inspector randomly observed ZPMC welder Yang Gui Long ID 068919, utilizing the FCAW Process with ZPMC WPS WPS-B-T-2332-TC-U4b-F in the 2G (Horizontal Groove) Position to weld the long seam between Skin Plate B and C above 68M Upper Diaphragm in Lift 2 West Tower Shaft. The QA Inspector randomly observed ZPMC QC monitoring weld parameters. Weld parameters appeared to comply with contract requirements.

The QA Inspector randomly observed ZPMC welder Chang Fei ID 069712, utilizing the FCAW Process with ZPMC (WPS) WPS-B-T-4133-3F in the 3F (Vertical Fillet) Position to weld fit lugs to Lift 2 West 43M Diaphragm at Skin B. The QA Inspector randomly observed ZPMC QC monitoring weld parameters. Weld parameters appeared to comply with contract requirements.

The QA Inspector randomly observed ZPMC welder Wang Ru Jia ID 066882, utilizing the FCAW Process with ZPMC WPS-B-T-4332-TC-P4-F in the 2F (Horizontal Fillet) Position to weld the longitudinal stiffeners on Skin Plate A to 65M Upper Diaphragm in Lift 2 East Tower Shaft. The QA Inspector randomly observed ZPMC QC monitoring weld parameters. Weld parameters appeared to comply with contract requirements.

The QA Inspector randomly observed ZPMC welder Yang Gui Long ID 0068919, utilizing the FCAW Process with ZPMC WPS WPS-B-T-2332-TC-U4b-F in the 2G (Horizontal Groove) Position to weld the long seam between Skin Plate B and A between 59M Upper and 61M Lower Diaphragms in Lift 2 East Tower Shaft. The QA Inspector randomly observed ZPMC QC monitoring weld parameters. Weld parameters appeared to comply with contract requirements.

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

Summary of Conversations:

No relevant conversations.

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 13482570045, who represents the Office of Structural Materials for your project.

Inspected By:	Franco,Charlie	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
