

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-008549**Date Inspected:** 26-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Gao Zhin Chun**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:**

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

This QA Inspector randomly observed the following work in progress

BAY#10

FCAW welding process of weld joint 128 located on PCMK NSD1-TL-8E/L. Welder is identified as 052771
ZPMC QC is identified as Gao Zhin Chun. The welding variables recorded by QC appeared to comply with the
WPS-B-T-3312-TL-P4

FCAW welding process of weld joint 76 located on PCMK NSD1-TL-8H/L. Welder is identified as 053049
ZPMC QC is identified as Gao Zhin Chun. The welding variables recorded by QC appeared to comply with the
WPS-B-T-3312-TL-P4

SAW welding process of weld joint 51A located on PCMK NSD1-FCSA4-1A/C. Welder is identified as 051413
ZPMC QC is identified as Wen zhong Wan. The welding variables recorded by QC appeared to comply with the
WPS-B-T-2221-B-U3-C-S2

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BAY#11

SMAW welding process of weld joint 17A/B located on PCMK WSD1-FESA-2B/D. Welder is identified as 040669 ZPMC QC is identified as Shao hain hang. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G (2F) Repair

FCAW welding process of weld joint 20A/B located on PCMK WSD1-FESA-2B/D. Welder is identified as 040713ZPMC QC is identified as Shao hain hang. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-2G (2F) Repair

FCAW welding process of weld joint 51B located on PCMK WSD1-A115E/J. Welder is identified as 040634 ZPMC QC is identified as Yun xiao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-C-U2-BS2

SAW welding process of weld joint 11A located on PCMK ESD1-FESA4-2A/F. Welder is identified as 202756 ZPMC QC is identified as Cao Cheng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-B-U3B-S2

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

Summary of Conversations:

No relevant conversation

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:	Utekar,Shrikant	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
