

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-007746**Date Inspected:** 28-Jun-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 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 and 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 2:

This Caltrans QA inspector monitored activities related to internal stiffener replacement for Partial Joint Penetration (PJP) welds exceeding Welding Procedure Specification root gap tolerance on OBG segments 1AAW and 1AAE.

1AAE

The following base metal repairs were tested and accepted by ZPMC MT technicians were verified and accepted by QA.

SEG2F-043, 024, 044, 025, 026, SEG2E-334, SEG2D-088 at location A00

Caltrans QA observed SMAW welding of A41 base metal repairs. ZPMC QC was identified as Chen Xi. Welding appeared to in conformance with Welding Procedure Specifications, WPS-345-SMAW-1G(1F)-Repair, WPS-345-SMAW-2G(2F)-Repair, WPS-345-SMAW-3G(3F)-Repair.

Bay 2-

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

This QA Inspector observed the following work in progress: FCAW welding of weld joint 044 located on FB003-178. ZPMC welder was identified as 044824. ZPMC QC is identified as Chen Xi. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2232-TC-U4b-F.

Bay 3-

This QA Inspector observed the following work in progress: FCAW repair welding of weld joint 148 located on Floor Beam, FB024-009. ZPMC welder was identified as 045260. ZPMC QC is identified as Chen Xi. The welding appeared to be in conformance with welding procedure specification, WPS-345-FCAW-2G(2F)-Repair and Weld Repair report B-WR5819.

Bay 6-

This QA Inspector observed the following work in progress: SMAW welding of weld joints 006 and 007 located on West Tower 143 meter Double Diaphragm WSD1-DPSA4-12 B/B. ZPMC welders were identified as 068091, 068924, 037932, 066268. ZPMC QC is identified as Wu Ming Kai. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-3312-TC-P5.

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 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
