

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-008088**Date Inspected:** 10-Jul-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:** Wan Wen Zhong**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 COMPONENTS**Summary of Items Observed:**

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

Bay 10

FCAW--South Shaft Lift-3

1) FCAW welding of weld joint SSTL3-1B/K-82B, 83B located on South Tower Shaft; Lift-3. Welding of CD Corner weld (out side) in progress. Welder is identified as 0503060/051413/050295/207745. ZPMC QCI-CWI is identified as Li Ming. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-B-L2C-S-2 & B-T-2221-C-U2b-S-2.

SMAW

2) SMAW welding of weld joint SSTL3-1B/K- 82B located on South Tower; Lift-3. Welding of connection plate inside Double Diaphragm is in progress. Welder is identified as 052075/201825. ZPMC QCI-CWI is identified as Li Ming. The welding variables recorded by QC appeared to comply with the WPS- B-T-4312-TC-P4.

Bay 11

SAW

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

SAW welding of weld joint WSD1-FDSA4-4A/D-14A, 15A located on West Tower; Lift-4; Skin-D. Welder is identified as 047304. ZPMC QCI is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS- B-T-4221-B-U3C-S-3.

FCAW

FCAW welding of weld joint ESD1-FCSA4-2C/C-5, 6 located on East Tower; Lift-4; Skin-C. Welding of Skin plate to Stiffener is in progress. Welder is identified as 068920/068493. ZPMC QCI-CWI is identified as Zhang Zhi Neng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P5-F.

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

Inspected By:	Rao,Gady	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
