

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-008128**Date Inspected:** 03-Aug-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:** Li Jia, Li Lin**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&OBG**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.

TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress

OBG segment 3AE-3BE

FCAW welding process of weld joint 233 located on PCMK SSD18A-PP22. Welder is identified as 054016 ZPMC QC is identified as Xu Tao. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F) Repair.

This QA Inspector observed ZPMC NDT Inspector performing Ultrasonic Inspection (UT) on repaired weld joint between Deck panel diaphragms to floor beam Flange (SSD18A-PP22-004).

OBG segment 2BE

This QA Inspector Observed ZPMC personnel performing the SMAW welding on the base metal excavation area due to removing of temporary attachments on the deck panel of cross beam#1 and FL3 at PP14-16 near the weld joint between FL3 and cross beam. Welder is identified as 048617 ZPMC QC is identified as Wang Li Yang. The

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welding variable recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F) Repair.

OBG segment 1AAW-1AW

FCAW welding process of weld joint 001 located on PCMK OBW1A. Welder is identified as 220063, 220069 ZPMC QC is identified as Wang Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-B-U2A-F3.

This QA Inspector observed ZPMC performing the Carbon Air arc gouging on the weld joint between deck panel to 'I' rib of segment 1AAW in south side.

OBG segment 1BE-2AE

This QA Inspector Observed ZPMC personnel performing the SMAW welding on the base metal excavation area due to removing of temporary attachments on the on the edge panel at the weld joint between segment 1BE and segment 2AE. Welder is identified as 220067 ZPMC QC is identified as Wang Li Yang. The welding variable recorded by QC appeared to comply with the WPS-345-SMAW-2G (2F) Repair.

OBG segment 2BW

This QA Inspector observed ZPMC NDT Inspector performing Magnetic Particle Inspection on the hold back area of the weld joint between 'T' stiffeners to bottom panel and side panel at PP18-19.

OBG segment 1AE

This QA Inspector observed ZPMC performing heat straitening on deck panel 'I' ribs at PP8.5-PP9 on south side.

BAY#11

This QA Inspector randomly observed the following work in progress

FCAW welding process of weld joint 52 located on PCMK WSD1-FDSA4-4D/D. Welders are identified as 069043 ZPMC QC is identified as Fu Wei Min. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P5-F.

FCAW welding process of weld joint 53 located on PCMK WSD1-FDSA4-4D/D. Welders are identified as 070046 ZPMC QC is identified as Fu Wei Min. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P5-F.

FCAW welding process of weld joint 10 located on PCMK WSD1-FDSA4-4D/D. Welders are identified as 07140 ZPMC QC is identified as Fu Wei Min. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P5-F.

FCAW welding process of weld joint 11 located on PCMK WSD1-FDSA4-4D/D. Welders are identified as 070212 ZPMC QC is identified as Fu Wei Min. The welding variables recorded by QC appeared to comply with

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the WPS-B-T-2332-TC-P5-F.

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

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