

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-008299**Date Inspected:** 06-Aug-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:** Li Zhi Jiang**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 and OBG**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 QA Inspector observed the following work in progress: SAW welding Floor Beam weld FB03078-001-001. ZPMC welder was identified as 045265. ZPMC QC is identified as Li Zhi Jiang. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2221-B-L2c-S-2.

Bay 3-

This QA inspector performed Ultrasonic Testing (UT) verification of the areas previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members were identified as Floor Beams. The weld identification numbers are as follows: FB3054-001-108, FB3081-001-108, FB3059-003-006, FB3065-001-006, FB3003-003-001 and FB3003-001-001.

Bay 9-

This QA Inspector observed the following work in progress: FCAW welding U rib splice weld DP3045-001-017. ZPMC welder was identified as 201250. ZPMC QC is identified as Sun Bo. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2233-B-U2-F.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

FCAW welding of U rib diaphragm plate welds DP3045-001-033, 034, 036 and 037. ZPMC welder was identified as 062265. ZPMC QC is identified as Sun Bo. The welding appeared to be in conformance with welding procedure specifications, WPS-B-T-2133 and WPS-B-T-2233-TC-U4b-F.

Bay 11-

This QA Inspector observed the following work in progress: SMAW repair welding of EastTower Lift 4 Skin E longitudinal stiffener weld joints, ESD1-FESA4-2 F/F 17 A/B and 53 A/B . ZPMC welders were identified as 053916 and 047470. ZPMC QC is identified as Li Lin. The welding appeared to be in conformance with ZPMC Weld repair report T-WR 1908 and welding procedure specification, WPS-345-FCAW 2G (2F)-Repair.

FCAW welding of West Tower Lift 2 fit lug to diaphragm weld, WSD1-TL6 E/L 115 located on West Tower Lift 2. ZPMC welder was identified as 067184. ZPMC QC is identified as Li Lin. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-3221-TC-U5-S-1.

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

Summary of Conversations:

Only general conversation occurred between QA and QC this date.

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:	Viars,Larry	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
