

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-008300**Date Inspected:** 08-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.

OBG Trial Assembly:

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as OBG Segment 3AE Deck Panel Diaphragm to Floor beam weld. The weld identification numbers are as follows: SSD17A-PP021-003 and 004.

Bay 2-

This QA Inspector observed the following work in progress: SMAW of weld CB202A-010-019 located on OBG cross beam # 10. ZPMC welder was identified as 040581. ZPMC QC is identified as Li Zhi Jiang. The welding appeared to be in conformance with welding procedure specification, WPS-B-P-2112.

Bay 10:

This QA Inspector observed the following work in progress: Semi Auto FCAW welding of Longitudinal stiffener to Skin Plate welds, NSD1-FDSA4-3 located on North Tower Lift 4 Skin Plate D. ZPMC welders were identified as 057266 and 050041. ZPMC QC is identified as Tu Jun. The welding appeared to be in conformance with

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welding procedure specification, WPS-B-T-2332-TC-P5-F.

Bay 11-

This QA Inspector observed the following work in progress: SAW welding of West Tower Lift 3 Corner weld joint WSTL3-4 B/K- 81B . ZPMC welders were identified as 044558, 044550 and 202756. ZPMC QC is identified as Li Lin. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2221-C-U2b-S.

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
