

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-008301**Date Inspected:** 09-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:** Sun Bo**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 observed the following work in progress: FCAW welding OBG Segment 1AAW to 1AW longitudinal diaphragm welds, SEG003B-050 and SEG003C-050. ZPMC welders were identified as 220063 and 053609. ZPMC QC is identified as Li Jia. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2233-B-U2-F.

Bay 2-

This QA Inspector observed the following work in progress: SMAW tack welding Floor Beam weld FB03059-003-095. ZPMC welder was identified as 205098. ZPMC QC is identified as Zhu Tian Shu. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2113.

Bay 9-

This QA Inspector observed the following work in progress: FCAW welding of U rib diaphragm plate welds DP3016-001-190 and DP3003-001-259. ZPMC welders were identified as 059443 and 201840. ZPMC QC was identified as Sun Bo. The welding appeared to be in conformance with welding procedure specifications,

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WPS-B-T-2133.

Bay 10-

This QA Inspector observed the following work in progress: FCAW repair welding Skin A to Skin E corner joint weld NSD1-TL8 B/L-1A on the North Tower Lift 2. ZPMC welder was identified as 040343. ZPMC QC is identified as Tu Jun. The welding appeared to be in conformance with welding procedure specification, WPS-345-FCAW-2G (2F)-Repair.

FCAW welding Skin A to Skin E corner joint weld NSD1-TL8 B/L-1A on the North Tower Lift 2. ZPMC welder was identified as 040343. ZPMC QC is identified as Tu Jun. The welding appeared to be in conformance with welding procedure specification, WPS-345-FCAW-2G (2F)-Repair.

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
