

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-008529**Date Inspected:** 16-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:	CWI: Wang Chuan Qing/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 components		

Summary of Items Observed:

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

Bay# 10- Tower Assembly:

This QA Inspector randomly observed the following work in progress:

FCAW Process:

Welding of weld joint# 84B located on PCMK NSTL3-3 B/K. Welder is identified as 052075. ZPMC QC is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2231-TC-U5-F.

Welding of weld joint# 84B located on PCMK NSTL3-3 B/K. Welder is identified as 050041. ZPMC QC is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2231-TC-U5-F.

Welding of weld joint# 3 located on PCMK NSD1 FDSA4-3 D/D. Welder is identified as 053116. ZPMC QC is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2332-TC-P5-F.

SMAW Process:

Welding of weld joint# 95 located on PCMK NSD1 TL8 H/C. Welder is identified as 052930. ZPMC QC is

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identified as Wang Chuan Qing. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3212-B-U2a-2.

Welding of weld joint# 1 located on PCMK NSD1 TL8 H/C. Welder is identified as 056200. ZPMC QC is identified as Wang Chuan Qing. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3212-B-U2a-2.

Welding of weld joint# 2 located on PCMK NSD1 TL8 F/C. Welder is identified as 057259. ZPMC QC is identified as Wang Chuan Qing. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3212-B-U2a-2.

Welding of weld joint# 59 located on PCMK NSD1 TL8 E/C. Welder is identified as 040333. ZPMC QC is identified as Wang Chuan Qing. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3212-B-U2a-2.

Welding of weld joint# 200 located on PCMK NSD1 TL8 H/C. Welder is identified as 057220. ZPMC QC is identified as Wang Chuan Qing. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3212-B-U2a-2.

Welding of weld joint# 108 located on PCMK NSD1 TL8 H/C. Welder is identified as 040269. ZPMC QC is identified as Wang Chuan Qing. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3212-B-U2a-2.

Bay# 11- Tower Assembly:

This QA Inspector randomly observed the following work in progress:

FCAW Process:

Non critical repair welding of Diaphragm located on PCMK ESTL3-4 H/K. Welder is identified as 070212. ZPMC QC is identified as Shao Hai Long. The welding variables recorded by QC appeared to comply with the specified WPS no. WPS-345-FCAW-3G 3(F)-Repair.

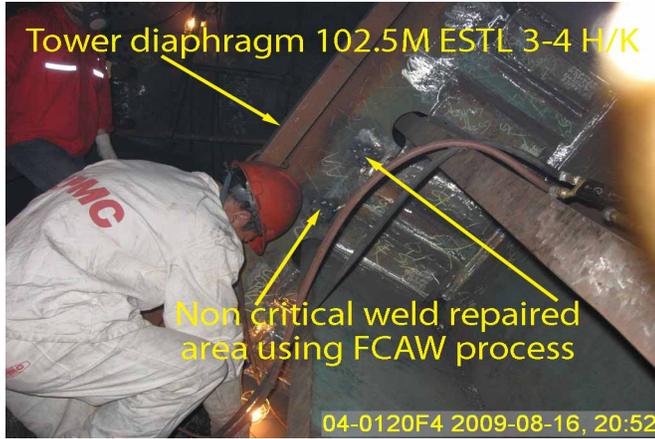
Non critical repair welding of skin plate & stiffeners located on PCMK WSD1 FCSA4. Welder is identified as 068858. ZPMC QC is identified as You Qi Guo. The welding variables recorded by QC appeared to comply with the specified WPS no. WPS-345-FCAW-3G 3(F)-Repair.

Non critical repair welding of skin plate & stiffeners located on PCMK WSD1 FCSA4. Welder is identified as 070254. ZPMC QC is identified as You Qi Guo. The welding variables recorded by QC appeared to comply with the specified WPS no. WPS-345-FCAW-2G 2(F)-Repair.

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

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

Inspected By: Chakrabarti,Dilip Kumar

Quality Assurance Inspector

Reviewed By: Clifford,William

QA Reviewer