

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-008617**Date Inspected:** 08-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:** OBG & Tower**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

OBG segment 3AE-3BE

Ultrasonic Inspection

This Q.A Inspector performed Ultrasonic Testing of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated a (UT) report for this date. The members are identified as the OBG segment 3AE the welds Designation are as follows.

SSD17A-PP021-003, 004

BAY#10

This QA Inspector randomly observed the following work in progress

FCAW welding process of weld joint 49 located on PCMK NSD1-FDSA4-3D/D. Welder is identified as 057266 ZPMC QC is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the

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

FCAW welding process of weld joint 50 located on PCMK NSD1-FDSA4-3D/D. Welder is identified as 050041 ZPMC QC is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P5-F.

BAY#11

This QA Inspector randomly observed the following work in progress

SAW welding process of weld joint 81B located on PCMK WSTL3-4B/K. Welders are identified as 044558 ZPMC QC is identified as Youqi Guo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-C-U2B-S.

SAW welding process of weld joint 81B located on PCMK WSTL3-4B/K. Welders are identified as 044550 ZPMC QC is identified as Youqi Guo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-C-U2B-S.

SAW welding process of weld joint 81B located on PCMK WSTL3-4B/K. Welders are identified as 044560 ZPMC QC is identified as Youqi Guo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-C-U2B-S.

TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress.

OBG SEGMENT-1AAE-1AE

FCAW welding process of weld joint 002 located on PCMK OBW1. Welder is identified as 053609 ZPMC QC is identified as Chen Bo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233T-1.

FCAW welding process of weld joint 003 located on PCMK OBW1. Welder is identified as 220068 ZPMC QC is identified as Chen Bo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233T-1.

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

Summary of Conversations:

No relevant conversations.

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 Eric Tsang + (86) 15000422372, who represents the Office of Structural Materials for your project.

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