

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-008621**Date Inspected:** 13-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:	Wu Zhi Chen, Wang Chuan Ging			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.

OUTSIDE YARD**OBG CATWALK RAIL**

Visual Inspection

This Q.A Inspector performed random Visual Testing of the area previously tested and accepted by ZPMC Quality control personnel. The members are identified as the OBG catwalk rail the welds Designation are as follows.

CATW-0 (Q2-W, TYPE 13- 10 no's)

TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress.

OBG SEGMENT-1AAW-1AW

FCAW welding process of weld joint 012 located on PCMK SEG1E-EP179-001. Welder is identified as 220069

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ZPMC QC is identified as Chen Bo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132.

FCAW welding process of weld joint 45 located on PCMK SP399-001. Welder is identified as 220066 ZPMC QC is identified as Chen Bo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132.

FCAW welding process of weld joint 516 located on PCMK SEG1E. Welder is identified as 220067ZPMC QC is identified as Chen Bo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U3-F.

OBG SEGMENT-1AAE-1AE

SAW welding process of weld joint 001 located on PCMK OBE1. Welder is identified as 050323ZPMC QC is identified as Chen Bo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-B-L2A-S-3.

SAW welding process of weld joint 001 located on PCMK OBE1. Welder is identified as 250050ZPMC QC is identified as Chen Bo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-B-L2A-S-3.

OBG SEGMENT-2AE-2BE

SMAW welding process of weld joint 034 located on PCMK OBE2B. Welder is identified as 062772ZPMC QC is identified as Wang Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2114-FCM-1.

This QA Inspector observed ZPMC performed heat straitening on longitudinal diaphragm between the PP15 and PP14 bike path side.

OBG SEGMENT-4AE-4BE

This QA Inspector observed ZPMC performing sand blasting in OBG segment 4AE and 4BE

BAY #10

This QA Inspector randomly observed the following work in progress.

FCAW welding process of weld joint 2B located on PCMK SSD1-SPSA3-52. Welder is identified as 040358ZPMC QC is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-TC-U5-F.

FCAW welding process of weld joint 45 located on PCMK SSD1-FDSA4-1B/C. Welder is identified as 201825ZPMC QC is identified as Wang Chuan Ging. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-U5-F.

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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 Jim Simonis - 134-7246-3441, who represents the Office of Structural Materials for your project.

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