

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-008971**Date Inspected:** 08-Sep-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:** Xu Yumin**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 and Tower**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 2AW center and counter weight Deck Panel Diaphragm to Floor beam and upper diaphragm web to flange weld. The weld identification numbers are as follows: FB073-002-003, 004, FB059-004-004, 005, SD041-PP13-003, 004, SSD43-PP13.5-003, 004, FB053-002-010, 011, FB045-004-004, 005, SSDPP14-003, 004, FB003-007-004, 005, FB041-001-003, 004, SSD042-PP14.5-004, FB048-001-011, FB045-001-004. Numerous areas were marked for repair by ZPMC and ABF QC. This MT inspection was performed on areas not marked for repair.

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This QA Inspector observed the following work in progress: FCAW repair welding of OBG segment 1AAE to 1AE splice weld at Y locations 190 mm and 1200 mm. ZPMC welder was identified as 045280. ZPMC QC is identified as Xu Yumin. The welding appeared to be in conformance with welding procedure specification, WPS-345-FCAW-3G (3F)-Repair.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

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

Summary of Conversations:

As identified within the contents of this report.

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, 150 0042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Viars,Larry	Quality Assurance Inspector
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Reviewed By:	Carreon,Albert	QA Reviewer
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