

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-009136**Date Inspected:** 18-Sep-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:** Xu Yumin, Li Ming**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/OBG**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.

BAY #10

This QA Inspector randomly observed the following work in progress.

SMAW welding process of weld joint 5A located on PCMK SSSL4-1B/L. Welder is identified as 040256ZPMC QC is identified as Wang Hao. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-C-U2.

SMAW welding process of weld joint 5A located on PCMK SSSL4-1B/L. Welder is identified as 057242ZPMC QC is identified as Wang Hao. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-C-U2.

SMAW welding process of weld joint 5A located on PCMK SSSL4-1B/L. Welder is identified as 040453ZPMC QC is identified as Wang Hao. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-C-U2.

TRIAL ASSEMBLY YARD

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This QA Inspector randomly observed the following work in progress.

OBG SEGMENT 1AAE-1AE

SMAW welding process of weld joint 003 located on PCMK OBE1A. Welder is identified as 058242 ZPMC QC is identified as Zhang Hai Tao. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F) Repair. The weld repair report noted as B-WR7665 and ZPMC Ultrasonic report noted as B787-UT-8332-3.

SMAW welding process of weld joint 003 located on PCMK OBE1A. Welder is identified as 045196 ZPMC QC is identified as Zhang Hai Tao. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F) Repair. The weld repair report noted as B-WR7665 and ZPMC Ultrasonic report noted as B787-UT-8332-3.

This QA Inspector observed ZPMC NDT Inspector was performing Magnetic particle inspection on the excavated (gouged) area of bottom panel splice weld joint between OBG segment 1AAE and 1AE.

OBG SEGMENT 1AAW-1AW

This QA Inspector observed ZPMC was excavated (gouged) on deck panel splice weld joint between OBG segment 1AAW and 1AW at various 18th location for ultrasonic repair with the help of carbon air arc gouging.

This QA Inspector observed ZPMC was excavated (gouged) on bottom panel splice weld joint between OBG segment 1AAW and 1AW at various 5th location for ultrasonic repair with the help of carbon air arc gouging.

This QA Inspector observed ZPMC was excavated (gouged) on south side (cross beam side) side panel splice weld joint between OBG segment 1AAW and 1AW at various 7th location for ultrasonic repair with the help of carbon air arc gouging.

OBG SEGMENT 4AW-1BW

This QA Inspector observed ZPMC personnel performing spray painting in OBG segment 4AW and 4BW

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 Serge Sinevod 13482570045, 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