

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-009268**Date Inspected:** 29-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:** 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:** OBG**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 observed ZMPC Quality Control (QC) performing radiography of 2AW and 2AE Deck panel welds between panel point 13 and 14 for both segments. This the 4th night in row QA has observed ZMPC QC perform radiography of these same locations.

Bay 10-

This QA Inspector observed the following work in progress: FCAW welding of South Tower Tower Lift 3 diaphragm to skin plate E weld, SSTL3-1-C/K-54 on the 89 meter double diaphragm bottom plate exterior. ZPMC welder was identified as 053116. ZPMC QC is identified as Li Ming. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-4333-TC-P4-F.

FCAW welding of South Tower Tower Lift 3 diaphragm to skin plate A weld, SSTL3-1-D/K-49 on the 89 meter double diaphragm top plate exterior. ZPMC welder was identified as 054069. ZPMC QC is identified as Li Ming. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-4332-TC-P4-F.

Bay 11-

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

This QA Inspector observed the following work in progress: FCAW welding of West Tower Tower Lift 3 diagonal plate to diaphragm plate weld on the 109 meter double diaphragm top . ZPMC welder was identified as 058792. ZPMC QC is identified as You Qi Guo. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-4333-TC-P5-F.

Bay 14-

This QA Inspector observed the following work in progress: FCAW repair welding of OBG Segment 9BW Deck Panel DP123A to DP258 Butt splice weld SEG051-005. ZPMC welder was identified as 202122. ZPMC QC is identified as LiuWan Ning. The welding appeared to be in conformance with welding procedure specification, WPS-345-FCAW-1G (1F)-Repair.

FCAW welding of OBG segment 10AW lower floor beam to bottom panel fillet welds at panel point 88. ZPMC welder was identified as 044779. ZPMC QC is identified as Liu Wan Ning. The welding appeared to be in conformance with welding procedure specifications, WPS-B-T-2132.

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

Summary of Conversations:

Only general conversation occurred between QC and QA this date.

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:	Dawson,Paul	QA Reviewer
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