

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-009388**Date Inspected:** 03-Oct-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:** Liu Xiao Zhong**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#11

FCAW welding process of weld joint 68 located on PCMK ED1-A149A/C. Welder is identified as 042218 ZPMC QC is identified as You Qi Guo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132.

FCAW welding process of weld joint 61A located on PCMK ESTL4-2B/L. Welder is identified as 070254 ZPMC QC is identified as Liu Xiao Zhong. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-TC-U4B-F.

FCAW welding process of weld joint 59B located on PCMK ESTL4-2B/L. Welder is identified as 049220 ZPMC QC is identified as Liu Xiao Zhong. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231

FCAW welding process of weld joint 69 located on PCMK ED1-A149A/C. Welder is identified as 070140 ZPMC QC is identified as You Qi Guo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132.

WELDING INSPECTION REPORT

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INCIDENT

TRIAL ASSEMBLY YARD

OBG SEGMENT-1AW-1BW

During the random visual inspection this Quality Assurance (QA) Inspector observed ZPMC personnel have performed critical weld repairs on the side panel splice weld OBW1A-007 between OBG segment 1AW-1BW without Engineer's approval. Prior to making this weld repair this QA Inspector had performed magnetic particle inspections and found transverse linear indications in the excavated areas. The 'Y' location of the transverse linear indications measured approximately 3130mm and 1750mm from the counter weight side longitudinal diaphragm. The length of indications measured approximately 8mm and 5mm. For additional information see attached photos.

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



Summary of Conversations:

No relevant conversations.

WELDING INSPECTION REPORT

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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:	Dawson,Paul	QA Reviewer
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