

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-009391**Date Inspected:** 02-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:** 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 #11

This QA Inspector randomly observed the following work in progress.

FCAW welding process of weld joint 57A located on PCMK ESTL4-2B/L. Welder is identified as 069043 ZPMC QC is identified as Cao Cheng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P4-F.

FCAW welding process of weld joint 59B located on PCMK ESTL4-2B/L. Welder is identified as 070254 ZPMC QC is identified as Liu Xiao Zhang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-B-U4b-F.

FCAW welding process of weld joint 57A located on PCMK ESTL4-2B/L. Welder is identified as 070140 ZPMC QC is identified as Cao Cheng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P4-F.

BAY #10

WELDING INSPECTION REPORT

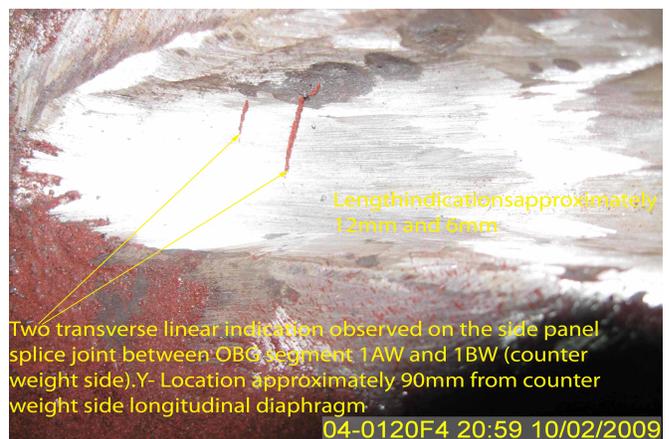
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FCAW welding process of weld joint 3B located on PCMK NSD1-SPSA3-56. Welder is identified as 040533 ZPMC QC is identified as Li Ming. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-TC-U5-F.

TRIAL ASSEMBLY YARD

During the random visual inspection this QA Inspector observed the side panel splice joint between OBG segment 1AW and 1BW (counter weight side) observed excavated on various location by ZPMC personnel. This QA Inspector performed magnetic particle inspection over excavated area. During the magnetic particle inspection this QA Inspector found 9 transverse indications. Regarding this issue this QA Inspector informed to task leader and other supervisor. For additional information see photos below.

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



WELDING INSPECTION REPORT

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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

Reviewed By: Dawson,Paul

QA Reviewer