

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-009532**Date Inspected:** 12-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:	Wang Chuan Ging , 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:	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.

Flux Core Arc welding process of weld joint 129 located on PCMK SSSL4-1C/L. Welder is identified as 057180 ZPMC QC is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

Flux Core Arc welding process of weld joint 130 located on PCMK SSSL4-1F/L. Welder is identified as 057266 ZPMC QC is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

Flux Core Arc welding process of weld joint 127 located on PCMK SSSL4-1G/L. Welder is identified as 054069 ZPMC QC is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

Flux Core Arc welding process of weld joint 63 located on PCMK SSSL4-1H/L. Welder is identified as 053869 ZPMC QC is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the

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WPS-B-T-2333-TC-P4-F.

Flux Core Arc welding process of weld joint 45 located on PCMK SSSL4-1B/L. Welder is identified as 053870 ZPMC QC is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

Flux Core Arc welding process of weld joint 128 located on PCMK SSSL4-1K/L. Welder is identified as 040343 ZPMC QC is identified as Wang Chuan Ging. The welding variables recorded by QC appeared to comply with the WPS-B-T-4333-TC-P4-F.

Flux Core Arc welding process of weld joint 124 located on PCMK SSSL4-1J/L. Welder is identified as 040533 ZPMC QC is identified as Wang Chuan Ging. The welding variables recorded by QC appeared to comply with the WPS-B-T-4333-TC-P4-F.

Flux Core Arc welding process of weld joint 125 located on PCMK SSSL4-1I/L. Welder is identified as 052075 ZPMC QC is identified as Wang Chuan Ging. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

OBSERVATIONS

This Quality Assurance (QA) Inspector observed the north tower lift 4 skin plate 'D' excavated various location at temporary attachment removed area. The depth of excavation measured approximately 5mm to 8mm.

TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress.

This Quality Assurance (QA) Inspector observed ZPMC welders 049769, 054467, 048659 are performing Shielded Metal Arc Welding (SMAW) on the weld joint OBE2A-003 bottom panel splice weld joint between OBG segment 2AE and 2BE. ZPMC QC (CWI) is identified as Xu Yumin. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCM-Repair-1. The critical weld repair report identified as B-CWR827.

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.

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Inspected By:	Utekar,Shrikant	Quality Assurance Inspector
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Reviewed By:	Dawson,Paul	QA Reviewer
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