

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-009550**Date Inspected:** 04-Oct-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:** Wang Chuan Qing**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 and 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.

Trial Assembly-

This QA Inspector observed the following work in progress: Flux Cored Arc Welding (FCAW) welding of horizontal stiffener weld OBW1-239. ZPMC welder was identified as 220066. ZPMC QC is identified as Li Jia. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2233-TC-U5-F.

Bay 9-

This Caltrans QA Inspector performed Magnetic Particle Testing (MT) verification of OBG Deck Panel DP3020-001-001 through 008 and DP 3016-001-001 through 008 tack welds after ZPMC initial MT inspection. ZPMC personnel have made repairs of areas found unacceptable. ZPMC has not performed the final MT of the repair areas. No relevant indications were found during inspection. This is considered an in process verification and a TL-6028 report was not generated for the above mentioned MT verification.

Bay 10-

This QA Inspector observed the following work in progress: Flux Cored Arc Welding (FCAW) repair welding of South Tower Lift 4 Skin B to C corner weld SSTL4-1 B/L-5A. ZPMC welder was identified as 056200. ZPMC

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QC is identified as Wang Chuan Qing. The welding appeared to be in conformance with welding procedure specification, WPS-345-SMAW-4G (4F)-Repair.

Bay 11-.

This QA Inspector observed the following work in progress: Flux Cored Arc Welding (FCAW) welding of East Tower Skirt Weld, ESD1-A65 B/B-5. ZPMC welder was identified as 049220. ZPMC QC is identified as Li Lin. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2133.

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 Serge Sinevod, 134 8257 0045, 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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