

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-005140**Date Inspected:** 04-Jan-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**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 COMPONENTS**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Gady Rao, was present during the times noted above for observations relative to the work being performed.

Bay 10

SAW

1) SAW welding of weld joint NSD1-SA 61 G / G -3, 9 & NSD1 - SA 61 A / G - 11,14,16A,10A, 13A, 17A located on; SKIN-E; LIFT-2; PCMK P 129 to P 35 to P486. Welder is identified as 201750 / 207745. ZPMC QC is identified as Chen Shou Hau. The welding variables recorded by QC appeared to comply with the B-T -2221-B-U3C-S- 2 & B - T - 2321 - B - P3 - S - 2.

FCAW

1) FCAW welding of weld joint NSD1-SA 105 - 2B located on SKIN-D; LIFT-2; PCMK P709 to SA 105. Welder is identified as 057194. ZPMC QC is identified as Chen Shou Hau. The welding variables recorded by QC appeared to comply with the B-T-2231-TC-U5-F.

2) FCAW welding of weld joint NSD1-SA 223 D / E - 4B & NSD1 - SA 223 E / E located on SKIN-D; LIFT-2; PCMK P141 to P115 & P1416 to SA 105. Welder is identified as 054069 / 052075. ZPMC QC is identified as Jin Dong Liang. The welding variables recorded by QC appeared to comply with the B-T-2231-B-U3-F.

SMAW

Strut Connection Plate Angle: FCM - Materials:

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SMAW welding of weld joint ND1-SA 183 - 38M - 3 – 1A, SA 183 - 38M - 4 – 1A, SA 183 - 38M - 4 – 1A, SA 183 - 33M - 2 – 1A, SA 183 - 33M - 1 – 1A, located on; PCMK P286 to SA183; Welder is identified as 040500 / 053680 / 0561310 / 0561340. ZPMC QC is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the B – T – 3211 – TC – U5B - 1.

BAY 11

SAW

1) SAW welding of weld joint WSD1-SA 384 A / G– 3A, located on; SKIN – B; LIFT – 2; PCMK P787 to P1451. Welder is identified as 040634. ZPMC QC is identified as Pengguo. The welding variables recorded by QC appeared to comply with the B-T -2221-B-U3C-S-2.

2) SAW welding of weld joint WSD1-SA 388 A / D– 1A, located on; SKIN – C; LIFT – 2; PCMK P1089 to P1177. Welder is identified as 047304. ZPMC QC is identified as Huang Li. The welding variables recorded by QC appeared to comply with the B-T -2221-B-U3C-S-2.

FCAW

1)FCAW welding of weld joint WSD1-SA 294 A / G – 19,20 located on SKIN-C; LIFT-1; Welder is identified as 040736 / 066401. ZPMC QC is identified as Zhang Zhi Neng.. The welding variables recorded by QC appeared to comply with the B-T-2332-TC-P5-F.

Doubler Plate Welding:

2) FCAW welding of weld joint WSD1-SA 107 A / J – 13, 14 located on SKIN - A; LIFT – 1. Welders are identified as 067949 / 066687 / 066825 / 068206. ZPMC QC is identified as Xiao Yun. The welding variables recorded by QC appeared to comply with the B-T-4332- TC –P4-F.

3) FCAW welding of weld joint WSD1-SA 653 A / F – 19 located on SKIN - A; LIFT – 1. Welders are identified as 066165 / 066155 / 066328. ZPMC QC is identified as Xiao Yun. The welding variables recorded by QC appeared to comply with the B-T-4332- TC –P4-F.

4) FCAW welding of weld joint WSD1-SA 107 B / J – 13,14, located on SKIN - A; LIFT – 1. Welders are identified as 068916 / 067601. ZPMC QC is identified as Li Ming. The welding variables recorded by QC appeared to comply with the B-T-4332- TC –P4-F.

Unless otherwise noted, all work observed on this date 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 134-8257-0045., who represents the Office of Structural Materials for your project.

Inspected By:	Rao,Gady	Quality Assurance Inspector
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Reviewed By:	Clifford,William	QA Reviewer
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