

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-005189**Date Inspected:** 03-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:** Fu Guo gang**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 the date Caltrans OSM Quality Assurance (QA) inspector Mike Blair was present during the times noted above for observations relative to the work being performed.

Bay 10-Tower

Ultrasonic Testing

The QA Inspector performed Ultrasonic Testing (UT) on approximately 25% of the area previously tested and accepted by ZPMC Quality Control personnel. The QA Inspector generated an Ultrasonic report for this date. The member is identified as NSD1-166A/F. The weld designations are as follows: 2 repair.

Ultrasonic Testing

The QA Inspector performed Ultrasonic Testing (UT) on approximately 25% of the area previously tested and accepted by ZPMC Quality Control personnel. The QA Inspector generated an Ultrasonic report for this date. The members are identified as

NSD1-SA171 C/D-1

NSD1-SA171 A/D-16, 23, 18, 22, 15, 19, 17, 24

NSD1-SA163 A/D-10, 6, 9, 12, 5

Work in progress

This QA Inspector observed the following work in process: SAW welding of weld joint 17 located on NSD1-SA171C/D. Welder is identified as 209051. ZPMC QC is identified as Liu Zhang An. The welding variables recorded by QC appeared to comply with the WPS-B-T-2321-B-P3-S-2.

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This QA Inspector observed the following work in process: SAW welding of weld joint 12 located on NSD1-SA171C/D. Welder is identified as 050295. ZPMC QC is identified as Liu Zhang An. The welding variables recorded by QC appeared to comply with the WPS-B-T-2321-B-P3-S-2.

This QA Inspector observed the following work in process: FCAW welding of weld 3 joint located on NSD1-SA105. Welder is identified as 040343. ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-Tc-U5-F.

This QA Inspector observed the following work in process: FCAW welding of weld joint 1 located on NSD1-SA105. Welder is identified as 057194. ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-Tc-U5-F.

This QA Inspector observed the following work in process: SAW welding of weld joint 25 located on NSD1-SA223A/E. Welder is identified as 040489. ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2321-B-P3-S-2.

This QA Inspector observed the following work in process: SAW welding of weld joint 13 located on NSD1-SA61A/G. Welder is identified as 201750. ZPMC QC is identified as Li Zhang An. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-B-U3c-S-2.

Bay 11-Tower

Ultrasonic Testing

The QA Inspector performed Ultrasonic Testing (UT) on approximately 25% of the area previously tested and accepted by ZPMC Quality Control personnel. The QA Inspector generated an Ultrasonic report for this date.

The member is identified as ESD1-SA176. The weld designations are as follows: 1, 2

The member is identified as ESD1-SA355. The weld designations are as follows: 1, 2

Work in progress

This QA Inspector observed the following work in process: FCAW welding of weld joint 14 located on WSD1-SA107 A/J. Welders are identified as 066477, 066165, and 048206. ZPMC QC is identified as Li Ming. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-Tc-P4-F.

This QA Inspector observed the following work in process: FCAW welding of weld joint 14 located on WSD1-SA107 B/J. Welder is identified as 068929. ZPMC QC is identified as Li Ming. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-Tc-P4-F.

Unless otherwise noted, all 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

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remedial efforts please contact Serge Sinevod, 134-8257-0042, who represents the Office of Structural Materials for your project.

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| Inspected By: | Blair, Mike | Quality Assurance Inspector |
| Reviewed By: | Clifford, William | QA Reviewer |
