

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-005330**Date Inspected:** 29-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:	Chen Likun, Qi Guo You, Xu Le Feng			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, Luis Hutchins, was present during the times noted above for observations relative to the work being performed.

Inprogress welding:

FCAW welding of welds joint NSD1-SA11 A/F- 51, 49, 45, and 41 located on SKIN – B, Lift - 1. Welder are identified as 0066751, 066481, 0666683 and 052075. ZPMC QC is identified as Chen Likun. The welding variables recorded by QC appeared to comply with the WPS #345-FCAW-2F-REPAIR.

FCAW welding of welds joint NSD1-SA97 A/G- 2 and 4. Welder are identified as 067949. ZPMC QC is identified as Qi Guo You. The welding variables recorded by QC appeared to comply with the WPs-B-T-2231-TC-U5-F.

FCAW welding of welds joint NSD1-SA22 B/E- 44, 46, 48, 50, 52 and 54. Welders are identified as 053469 and 040586. ZPMC QC is identified as Qi Guo You. The welding variables recorded by QC appeared to comply with the WPs-B-T-2331-TC-P4-F.

SMAW welding of welds joint WSD1-SA388 C/D- 23 and 24. Welders are identified as 046704. ZPMC QC is identified as Xu Le Feng. The welding variables recorded by QC appeared to comply with the WPS #345-1G (1F)-REPAIR.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

SAW welding of welds joint WSD1-A467-23M-2-24B, WSD1-467-23M-1-23B, WSD1-A467-23M-2-23B, WSD1-A467-28M-1-24B, and WSD1-A467-28M-2-24B. Welders are identified as 042195. ZPMC QC is identified as Xu Le Feng. The welding variables recorded by QC appeared to comply with the WPS #B-T-4221-B-U3C-S-1.

SAW welding of welds joint WSD1-SA384 A/D-14B. Welder is identified as 056975. ZPMC QC is identified as Xu Le Feng. The welding variables recorded by QC appeared to comply with the WPS #B-T-2221-B-U3C-S-2.

FCAW welding of welds joint WSD1-SA340 D/F- 31A, 17A, 18A, and 20A. Welders are identified as 046706 and 066239. ZPMC QC is identified as Yun Xian. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-TC-U5-F.

FCAW welding of welds joint WSD1-SA340 E/F- 30A, and 26A. Welders are identified as 062782 and 068852. ZPMC QC is identified as Yun Xian. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-TC-U5-F.

FCAW welding of welds joint NSD1-SA106 - 3 and 5. Welders are identified as 067876 and 066401. ZPMC QC is identified as Qi Guo You. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-TC-U5-FCAW.

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

Summary of Conversations:

No significant conversations held during the course of inspection.

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:	Hutchins,Luis	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
