

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-005743**Date Inspected:** 09-Mar-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 630**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Chen Chien and Huaq Wein Pang			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:	OBG Assembly, Tower		

Summary of Items Observed:

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

Bay 11

This QA Inspector performed Magnetic Particle Testing (MT) of approximately 25% of the area previously tested by ZPMC MT personnel. This QA Inspector generated a TL-6028 MT report on this date. The weld designation numbers is as follows:

WSDI-SA340E/F:

21(A/B), 22, 23, 6, 5 and 4

WSDI-SA340D/F:

20 (A/B), 17A, 1 (A/B), 21, 22, 5 and 6

Bay 2

This QA Inspector observed the following work in progress:

ZPMC qualified welding personnel's identified as Mr. Wang (0067275), Mr. Wang Youxiang (066912) and Mr. Qi Huanhuan (067184) performed FCAW welding on weld joint identified as SEG2C-447, 112 and 040. ZPMC QC identified Mr. Liu Wei Wei and was present to monitor the welding process. The welding parameters as

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measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-YC-U4b-F and WPS-B-T-2233-C0U4b-F.

Bay 13

ZPMC qualified welding personnel's identified as Mr. Wang Quanlin (066746) performed FCAW welding on weld joint identified as CA100-004. ZPMC QC identified Mr. Shen Fu You and was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2231-TC-U4B.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

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 Eric Tsang (134-8257-0045), who represents the Office of Structural Materials for your project.

Inspected By:	Alaniz,Joe	Quality Assurance Inspector
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Reviewed By:	Carreon,Albert	QA Reviewer
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