

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-005749**Date Inspected:** 16-Mar-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:** Chen Xi and Shen Fu You**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.

This QA Inspector performed Ultrasonic Testing (UT) on approximately 15% of CJP on the East Tower Skin E stiffeners and OBG crossbeam's welds previously accepted by ZPMC ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3. The QA Inspector observed no rejectable indications at the time of testing. The QA Inspector generated a TL-6027 UT report on this date. Welds UT verified were identified as listed below.

Bay 11

ESD1-SA216F/K: ESD1-SA216A/H: ESD1-SA216H/K:
7A/B and 14A/B 67A/B and 66A/B 64A/B

ESD1-SA216G/K:
28A/B, 31A/B, 37A/B, 11A/B, 14A/B and 21A/B

Bay 3

FB210-004: FB210-003: FB210-1-004: FB210-004: CB204-001: FB009-004:
035 and 036 035 and 036 035 and 036 035 and 036 001 and 003 026 and 043

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This QA Inspector observed the following work in progress:

Bay 1

ZPMC qualified welding personnel identified as Mr. Li Lian (070212) performed FCAW welding on weld joint identified as CB205J-283/284-279/780-275/276-277/278. ZPMC QC identified Chen Xi 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-2132-3.

Bay 13

ZPMC welding personnel Mr. Liu Zipei (062406) performing groove welding of weld joint SEG008*-017, 018/K-44B filler passes. The personnel were observed welding in the 1G (flat) position utilizing a Submerged Arc Welding(SAW) process. 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-B-U2C-S-2.

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

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
Reviewed By:	Carreon,Albert	QA Reviewer
