

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-006503**Date Inspected:** 12-Apr-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:	Li Lin			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 and Tower		

Summary of Items Observed:

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector Larry Viars was present during the times noted above for observations relative to the work being performed.

Bay 11-

This QA inspector performed Visual Testing (VT) of welds previously accepted by ZPMC and ABF Quality Control personnel. The member is identified East Tower Lift 1 fit lugs. The weld identification numbers are as follows: ESD1-A165 F/J 056, 057, 058, 059, ESD1-A165 E/J 182, 183, 184, 185, ESD1-A165 F/J 177, 178, 179, 180, ESD1-A165 G/J 056, 057, 058, 059, 147, 168, 169, 170 and ESD1-A165 H/J 054, 055, 057, 058.

This QA Inspector observed the following work in progress: SAW welding of weld joints WSD1-FCSA3-2 B/C-10A-2, 15, 19A, 28A-1, 28A-2, 32, 38A and 40 located on Lift 3 Skin C. ZPMC welder was identified as 044550. ZPMC QC is identified as Li Lin. The welding appeared to be in conformance with welding procedure specifications, WPS-B-T-2221-B-U3C-3-S-2 and WPS-B-T-2321-B-P3-S-2.

Bay 2-

This QA inspector performed Ultrasonic Testing (UT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member is identified as FB004-038, FB013-037, FB014-037, FB013-039, FB013-038. The weld identification number is as follows: 043 and 044 for the above mentioned components.

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

Summary of Conversations:

Only general conversations between QC and QA this date.

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 150 0042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Viars,Larry	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
