

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-007326**Date Inspected:** 18-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Sun Wei / Sun Bo**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**Summary of Items Observed:**

The Caltrans (CT) Quality Assurance (QA) Inspector Charlie Franco was present at the time requested to randomly observe welding and associated operations being performed for the Tower and Orthotropic Box Girders (OBG).

Outside Yard at Vertical Mill:

The QA Inspector randomly observed that ZPMC milling was idle and no work was being performed on Lift 1 South Tower Shaft. The QA Inspector randomly observed that no other contract was being performed on the interior or exterior of Lift 1 South Tower Shaft.

Blast Shop:

The QA Inspector attempted to follow up to verify conditions observed by the previous shift of backing bars behind the fill plates of 47.6M and 43M Diaphragms during an after blast Visual Testing (VT) Inspection in Lift 1 East Tower Shaft. The QA Inspector was not able to enter the area because it had just been coated. The QA Inspector exited the blast shop at this time.

Heavy Equipment Shop Bay 11:

The QA Inspector randomly observed ZPMC welder Li Xiao Qing ID 044560, utilizing the Submerged Arc Welding (SAW) Process with ZPMC Weld Procedure specification (WPS) WPS-B-T-2221-C-U2b-S in the 1G

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(Flat Groove) Position, to weld the fill pass in the long seam between Skin Plate B and Skin Plate C in Lift 1 West Tower at WJ WSD1-A115E/J-90A. The QA Inspector randomly observed ZPMC QC monitoring weld parameters.

The QA Inspector also randomly monitored weld parameters and recorded them as follows: 679 amps, 30.6 volts with a travel speed of 580 millimeters (mm) per minute. Weld parameters appeared to comply with contract requirements.

The QA Inspector randomly observed ZPMC welder Deng Jun Feng ID 202756, utilizing the SAW Process with ZPMC WPS WPS-B-T-2221-C-U2b-S in the 1G (Flat Groove) Position, to weld the fill pass in a long seam in Lift 1 West Tower at WJ WSD1-TL6B/L-2A. The QA Inspector randomly observed ZPMC QC monitoring weld parameters. Weld parameters appeared to comply with contract requirements.

The QA Inspector randomly observed ZPMC welder Xue Yan ID 040634, utilizing the SAW Process with ZPMC WPS WPS-B-T-2221-C-U2b-S in the 1G (Flat Groove) Position, to weld the fill pass in a long seam in Lift 1 West Tower at WJ WSD1-TL6B/L-2A. The QA Inspector randomly observed ZPMC QC monitoring weld parameters. Weld parameters appeared to comply with contract requirements.

The QA Inspector randomly observed ZPMC welder Yang Mei Zhen ID 042195, utilizing the SAW Process with ZPMC WPS WPS-B-T-2221-C-U2b-S in the 1G (Flat Groove) Position, to weld the fill pass in a long seam in Lift 1 West Tower at WJ WSD1-TL6B/L-2A. The QA Inspector randomly observed ZPMC QC monitoring weld parameters. Weld parameters appeared to comply with contract requirements.

Unless otherwise noted, all work 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 remedial efforts please contact Serge Sinevod 13482570045, who represents the Office of Structural Materials for your project.

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Inspected By:	Franco,Charlie	Quality Assurance Inspector
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Reviewed By:	Clifford,William	QA Reviewer
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