

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-007357**Date Inspected:** 02-Jun-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:** Wu Zhi Cheng**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 3-

QA Inspector observed the following work in progress: FCAW welding of weld joint 019 on Side plate SP305-001. ZPMC welder was identified as 053742. ZPMC QC is identified as Wu Zhi Feng. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2132-3.

Bay 5-

QA Inspector observed the following work in progress: FCAW welding of weld joint 019 on Floor Beam FB016-045. ZPMC welder was identified as 048038. ZPMC QC is identified as Chen Xi. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2132-3.

Bay 7-

QA Inspector observed the following work in progress: FCAW welding of weld joints 013, 014, 023 and 024 located on Floor Beam FB01. ZPMC welders were identified as 053742 and 062447. ZPMC QC is identified as Wu Zhi Cheng. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2132-3.

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OBG Trial Assembly area-

QA Inspector observed the following work in progress: FCAW welding of weld joint 009 and 010 Side plate to Side Plate Butt Splice welds for OBG Segment 1AE to 1BE . ZPMC welder was identified as 045280. ZPMC QC is identified as Wu Zhi Cheng. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2233-B-U2-F.

Bay 11-

This QA inspector performed Visual Testing (VT) and Magnetic Particle Testing (MT) verification of the areas previously tested and accepted by ZPMC and ABF Quality Control personnel for Green Tagging . Their members were identified as West Tower Lift 3connection plates .The weld identification is as follows: WSD1-FDSA3-2 C/C- 1, 2, 8, 9, 13, 14, 18, 19, 22 through 037. This QA inspector verified the required testing was completed by all three parties and signed Green Tag 8211 along with ZPMC and ABF Quality Control Personnel.

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

Summary of Conversations:

As identified within the contents of this report.

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
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Reviewed By:	Carreon,Albert	QA Reviewer
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