

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-007538**Date Inspected:** 24-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhang 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:** OBG & TOWER components**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector, Dilip Chakrabarti was present during the times noted above for observations relative to the work being performed.

Bay# 11-Tower Assembly

This QA Inspector randomly observed the following work in progress:

SAW Process:

Welding of weld joint# 75 & 87A located on PCMK WSD1 FESA4-2 A/C. Welder is identified as 040634. ZPMC QC is identified as Mao Bin Bin. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2321-B-P3-S-2.

Welding of weld joint# 66A located on PCMK WSD1 FESA4-2 A/C. Welder is identified as 202756. ZPMC QC is identified as Mao Bin Bin. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2321-B-P3-S-2.

Welding of weld joint# 6B located on PCMK SD1 A6002-12. Welder is identified as 056975. ZPMC QC is identified as Mao Bin Bin. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-4221-B-U3C-S-1.

Welding of weld joint# 28B, 29B & 30B located on PCMK ESD1 FCSEA4-2. Welder is identified as 044558. ZPMC QC is identified as Mao Bin Bin. The welding variables recorded by QC appeared to comply with the

WELDING INSPECTION REPORT

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specified WPS no. B-T-2221-B-U3C-S-2.

Bay# 10-Tower Assembly

This QA Inspector randomly observed the following work in progress:

FCAW Process:

Welding of weld joint# 89 located on PCMK SSTL 3-1C/K. Welder is identified as 057244. ZPMC QC is identified as Chen Ying Xin. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-4332-TC-P5-F.

Welding of weld joint# 59,60 located on PCMK SSTL 3-1F/K. Welder is identified as 053116. ZPMC QC is identified as Chen Ying Xin. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2133.

Welding of weld joint# 57,58 located on PCMK SSTL 3-1B/K. Welder is identified as 050041. ZPMC QC is identified as Chen Ying Xin. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2133.

Welding of weld joint# 74,75 located on PCMK SSTL 3-1H/K. Welder is identified as 201825. ZPMC QC is identified as Guo Zhi Chun. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2133.

Welding of weld joint# 79,90 located on PCMK SSTL 3-1I/K. Welder is identified as 057266. ZPMC QC is identified as Guo Zhi Chun. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-4332-TC-P5-F.

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

Summary of Conversations:

No relevant conversation

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

Inspected By:	Chakrabarti,Dilip Kumar	Quality Assurance Inspector
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Reviewed By:	Clifford,William	QA Reviewer
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