

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-007784**Date Inspected:** 05-Jul-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:** Xu Le Feng, Yu Dong Ping**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).

Heavy Equipment Shop Bay 10:

The QA Inspector randomly observed ZPMC welder Yu Jun ID 201825, utilizing the Flux Cored Arc Welding (FCAW) Process in the 3F (Vertical Fillet) Position with ZPMC Weld Procedure Specification (WPS) WPS-B-T-2133, to weld the fit lugs to Lift 3 South Tower 92.5 M Upper Diaphragm at Weld Joint (WJ) SSTL3-1F/K-40. The QA Inspector randomly observed ZPMC Quality Control (QC) monitoring weld parameters. Weld parameters appeared to comply with contract requirements.

The QA Inspector randomly observed ZPMC welder Zhang Song Lin ID 057266, utilizing the FCAW Process in the 3G (Vertical Groove) Position with ZPMC WPS WPS-B-T-4333-TC-P4-F, to weld the longitudinal stiffeners to Lift 3 South Tower 89 M Upper Diaphragm at WJ SSTL3-1C/K-47. The QA Inspector randomly observed ZPMC QC monitoring weld parameters. Weld parameters appeared to comply with contract requirements. The attached photograph provides additional detail.

The QA Inspector randomly observed 2 ZPMC torch cutters utilizing track mounted torch cutting apparatus to burn the double diaphragm cutouts in Lift 4 South Tower Skin Plate A. The attached photograph provides additional detail.

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Heavy Equipment Shop Bay 11:

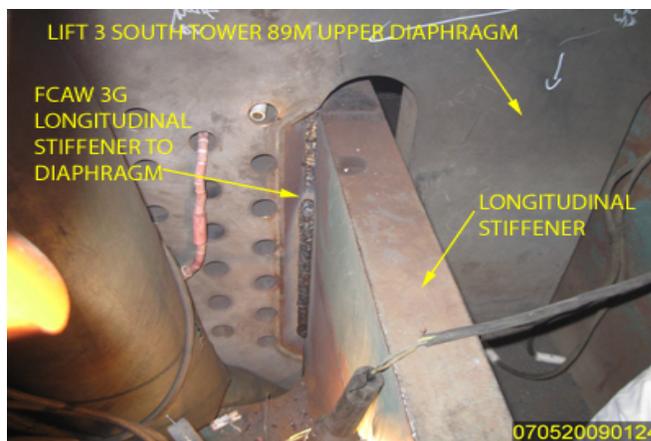
The QA Inspector randomly observed ZPMC welder ID 041716, utilizing the Submerged Arc Welding (SAW) Process in the 1G (Flat Groove) Position with ZPMC WPS WPS-B-T-4221-B-U3c-S-1, to weld the seam between flange sections piece marks p5001 and p5002 of West Tower shear link strut spares at WJ's WD1-A6001-3-4A, WD1-A6001-5-4A, WD1-A6003-4-2B, WD1-A6003-4-4A and WD1-A6003-5-2B. The QA Inspector randomly observed ZPMC QC monitoring weld parameters. Weld parameters appeared to comply with contract requirements. The attached photograph provides additional detail.

The QA Inspector randomly observed ZPMC welder Xue Yan ID 040634, utilizing the SAW Process in the 1G (Flat Groove) Position with ZPMC WPS WPS-B-T-2221-B-U3c-S-2, to weld the seam between piece marks FD4-12W and FD4-6 of Lift 4 West Tower Skin D at WJ's WD1-FDSA4-4A/D-21, 23 and 25. 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 Ai Xiang ID 040772, utilizing the SAW Process in the 1G (Flat Groove) Position with ZPMC WPS WPS-B-T-2221-B-U3c-S-2, to weld the seam between piece marks FD4-18W and FD4-5 of Lift 4 West Tower Skin D at WJ's WD1-FDSA4-4A/D-9B. 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 Qin Xia Lan ID 044550, utilizing the SAW Process in the 1G (Flat Groove) Position with ZPMC WPS WPS-B-T-2221-B-U3c-S-2, to weld the seam between piece marks FD4-13W and FD4-5 of Lift 4 West Tower Skin D at WJ's WD1-FDSA4-4A/D-12B. 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.



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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.

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