

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-007984
Date Inspected: 23-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:	Li Jia, 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&OBG	

Summary of Items Observed:

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

BAY#10

This QA Inspector randomly observed the following work in progress

FCAW welding process of weld joint 81B located on PCMK SSSL3-1B/K. Welder is identified as 040338 ZPMC QC is identified as Liu Zhongan. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-TC-U4-B.

SAW welding process of weld joint 82B located on PCMK SSSL3-1B/K. Welder is identified as 207745 ZPMC QC is identified as Wang Hao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-C-U2B-S-2.

FCAW welding process of weld joint 56 located on PCMK NSD1-TL-8J/L. Welder is identified as 057244 ZPMC QC is identified as Du Zhigun. The welding variables recorded by QC appeared to comply with the WPS-B-T-2331-TC-P4-F-2.

SAW welding process of weld joint 83B located on PCMK SSSL3-1B/K. Welder is identified as 051413 ZPMC QC is identified as Wang Hao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-C-U2B-S-2.

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FCAW welding process of weld joint 56 located on PCMK NSD1-TL-8J/L. Welder is identified as 040349 ZPMC QC is identified as Du Zhigun. The welding variables recorded by QC appeared to comply with the WPS-B-T-2331-TC-P4-F-2.

BAY#11

FCAW welding process of weld joint 83A located on PCMK WSTL3-4B/K. Welder is identified as 066420 ZPMC QC is identified as Yuan Wen Jie. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-TC-U4B-F.

TRIAL ASSEMBLY YARD

Visual Inspection

During the random visual inspection this Quality Assurance inspector (QA) observed that the contractor appears to have neglected to cut the specified cope hole on floor beam stiffener identified as X7M. This condition exists on OBG segment 3AW at or near the intersection of panel point 22 and line W4. The floor beam is identified as FB25

For this issue the incident report was sent to task leader and other supervisor.

This QA Inspector randomly observed the following work in progress.

FCAW welding process of weld joint 004 located on PCMK SSD20-PP025. Welder is identified as 050242, 051356, and 044801 ZPMC QC is identified as Xu Yumin. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-2G (2F) Repair.

This QA Inspector observed the ZPMC performing Magnetic Particle Testing on the weld joint between Edge panel's stiffeners to Floor beam in segment 1AW at PP10 south section.

This QA Inspector observed the ABF performing Magnetic Particle Testing on the gouged excavation area of weld joint between Deck panel diaphragms to floor beam flange in segment 3AE at PP21.

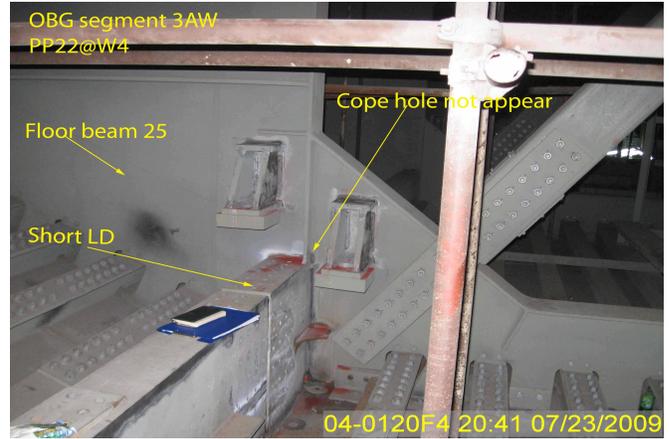
This QA Inspector observed the ZPMC performing bolt tightening with the help of torque wrench on 'U' rib at PP14 in segment 2AW.

This QA Inspector observed the ZPMC install the bolt and snug tightening in progress on 'U' rib at PP16 in segment 2AW.

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

WELDING INSPECTION REPORT

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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 Eric Tsang + (86) 15000422372, who represents the Office of Structural Materials for your project.

Inspected By: Utekar,Shrikant

Quality Assurance Inspector

Reviewed By: Clifford,William

QA Reviewer