

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-007986**Date Inspected:** 21-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 Pin**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.

This QA Inspector randomly observed the following work in progress

BAY#10

FCAW welding process of weld joint 33 located on PCMK ND1-A166E/J. Welder is identified as 052923 ZPMC QC is identified as Du Zhi Gun. The welding variables recorded by QC appeared to comply with the WPS-B-T-4333-TC-P5-F.

FCAW welding process of weld joint 34 located on PCMK ND1-A166E/J. Welder is identified as 020185 ZPMC QC is identified as Du Zhi Gun. The welding variables recorded by QC appeared to comply with the WPS-B-T-4333-TC-P5-F.

BAY#11

FCAW welding process of weld joint 147 located on PCMK WSTL3-4G/K Welder is identified as 066479 ZPMC QC is identified as Yuan Wen Jie. The welding variables recorded by QC appeared to comply with the WPS-B-T-4333-TC-P4-F.

WELDING INSPECTION REPORT

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TRIAL ASSEMBLY YARD

This Q.A Inspector observed ZPMC performing miss drill hole repair in segment 3AW-3BW at PP 20, 21, 22 on the top 4 rib at FL3 Welder is identified as 220064 ZPMC QC is identified as Li Jia. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-1G (FCM) repair.

This Q.A Inspector observed ZPMC performing Magnetic Particle repairs on various locations of the weld joint between 'T' stiffener to bottom plate and side plate in segment 2BW at PP 19.

This QA Inspector observed ZPMC personnel installed bolt and snug tightening in progress on deck panel stiffener clip plate at PP13 in segment 1BW south section.

Unless otherwise noted, all work observed on this dated appeared to 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 Eric Tsang + (86) 15000422372, who represents the Office of Structural Materials for your project.

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| Inspected By: | Utekar,Shrikant | Quality Assurance Inspector |
| Reviewed By: | Clifford,William | QA Reviewer |
