

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-007990**Date Inspected:** 16-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			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

SMAW welding process of weld joint 42A located on PCMK SSD1-FDSA4-1C/C. Welder is identified as 050289 ZPMC QC is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS-B-T-3211-TC-U5B-1

SMAW welding process of weld joint 30A located on PCMK SSD1-FDSA4-1C/C. Welder is identified as 052930 ZPMC QC is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS-B-T-3211-TC-U5B-1

SAW welding process of weld joint 81B located on PCMK SSSL3-1B/K. Welder is identified as 052917 ZPMC QC is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-C-U2B-S-2

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress.

FCAW welding process of weld joint 011 located on PCMK FB017-001. Welder is identified as 048617 ZPMC QC is identified as Chen Bo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132.

SMAW welding process of weld joint 022 located on PCMK CA005. Welder is identified as 045138 ZPMC QC is identified as Chen Bo. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-3G (3F) Repair.

This QA Inspector observed ZPMC performing base metal repair on three stiffeners of the deck panel in segment 4BW south side at PP28-29, This repair going on with the help WPS-345-SMAW-3G (3F) Repair. This QA inspector also noted the weld repair report as B-WR-6259, The ZPMC (CWI) Li Jia.

This QA Inspector observed ZPMC performing weld repair on the weld joint between the deck panel stiffeners to floor beam at PP27 in segment 4BW.

This QA Inspector observed ZPMC performing air arc gouging on the splice weld joint between edge panels to edge panel (OBW 01-009) of segment 1BW-2AW south side.

This QA Inspector observed ZPMC performing free hand oxyacetylene gas cutting on the bottom panel stiffeners of segment 1AAW.

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.

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