

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-007998**Date Inspected:** 07-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:** Zhong Yi**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.

TRIAL ASSEMBLY YARD

VISUAL INSPECTION

This QA noted the following Observation during the random visual inspection in Trial assembly yard.

This QA Inspector observed ZPMC was performed Heat straitening on short Longitudinal Diaphragm at PP28 North side in segment 4BW.

This QA Inspector observed ZPMC was performed Heat straitening on short Longitudinal Diaphragm at PP28 South side in segment 4BW.

This QA Inspector observed ZPMC removing 37X plate at PP26-27 corner section south in segment 4BE.

This QA Inspector randomly observed the following work in progress.

BAY#11

FCAW welding process of weld joint 55 located on PCMK WSD1-TL6J/L. Welder is identified as 066239 ZPMC

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

QC is identified as Cao Cheng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P4-F.

FCAW welding process of weld joint 57 located on PCMK WSD1-TL6J/L. Welder is identified as 068494 ZPMC QC is identified as Cao Cheng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P4-F.

BAY#10

FCAW welding process of weld joint 41 located on PCMK SSSL3-1C/K. Welder is identified as 057266 ZPMC QC is identified as Li Ming. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

FCAW welding process of weld joint 46 located on PCMK SSSL3-1G/K. Welder is identified as 057244 ZPMC QC is identified as Li Ming. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

SMAW welding process of weld joint 1B located on PCMK ND1SA250M-1. Welder is identified as 056200 ZPMC QC is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS-B-T-3211-TC-U5-B-1.

FCAW welding process of weld joint 44 located on PCMK SSSL3-1D/K. Welder is identified as 203977 ZPMC QC is identified as Li Ming. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

FCAW welding process of weld joint 135 located on PCMK SSSL3-1G/K. Welder is identified as 050041 ZPMC QC is identified as Li Ming. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

FCAW welding process of weld joint 46 located on PCMK SSSL3-1I/K. Welder is identified as 052075 ZPMC QC is identified as Li Ming. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

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.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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