

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-008061**Date Inspected:** 19-Jul-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhang Bo, Lin Li.**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 Components**Summary of Items Observed:**

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

This QA Inspector observed the following work in progress:

Bay11, West Tower, Lift 1, Inside.

FCAW welding of weld joint WSD1-A115J/J-55, 56, 53, 54; located on Bay11, West Tower, Lift 1, Inside. Welder is identified as 070022, 068087, 070006; ZPMC Quality Control Inspector (QC) is identified as Zhang Bo. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2332-TC-P4-F.

Bay11, West Tower, Lift 3, Inside.

FCAW welding of weld joint WSTL3-4C/K-44, 54 & WSTL3-4G/K-43 & WSTL3-4D/K-43; located on Bay11, West Tower, Lift 3, Inside. Welder is identified as 059525, 042218; ZPMC Quality Control Inspector (QC) is identified as Lin Li. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-4333-TC-P4-F.

This QA Inspector carried out NDE on following:

Bay 11, North Tower, Lift 2, B/C Corner Diagonal Plate.

This QA inspector performs Random Visual Testing (VT) of area previously tested and accepted by ZPMC Quality Control personnel. The members are identified as

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

- 1) NSD1-TL8C/L-36, 38, 138, 140. 53M ELEVATION.
- 2) NSD1-TL8D/L-24, 26. 56M ELEVATION.
- 3) NSD1-TL8D/L-78, 80. 59M ELEVATION.
- 4) NSD1-TL8E/L-21, 23, 92, 94. 62M, 65M ELEVATION.
- 5) NSD1-TL8F/L-35, 37, 115, 117. 65M, 68M ELEVATION.
- 6) NSD1-TL8G/L-21, 23, 74, 76. 71M, 74M ELEVATION.
- 7) NSD1-TL8H/L-38, 40, 127, 129. 77M ELEVATION.
- 8) NSD1-TL8J/L-19, 21. 80.75M ELEVATION.

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

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:	Juvekar,Amit	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
