

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-008191**Date Inspected:** 27-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:** Liu Yang, Li Hong Fei**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, Dilip Chakrabarti was present during the times noted above for observations relative to the work being performed.

Bay# 11- Tower Assembly:

This QA Inspector randomly observed the following work in progress:

SAW Process:

Welding of weld joint# 85B located on PCMK WSTL3-4 B/K. Welder is identified as 044560. ZPMC QC is identified as Li Hong Fei. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2231-C-B-L2a-S.

Welding of weld joint# 85B located on PCMK WSTL3-4 B/K. Welder is identified as 006975. ZPMC QC is identified as Li Hong Fei. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2231-C-B-L2a-S.

Bay# 10- Tower Assembly:

This QA Inspector randomly observed the following work in progress:

FCAW Process:

Welding of weld joint# 51 located on PCMK NSD1 FESA4-3 F/F. Welder is identified as 070046. ZPMC QC is identified as Shi Jing Wei. The welding variables recorded by QC appeared to comply with the specified WPS no.

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B-T-2232-TC-U5-F.

Welding of weld joint# 52 located on PCMK NSD1 FESA4-3 F/F. Welder is identified as 070046. ZPMC QC is identified as Shi Jing Wei. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2232-TC-U5-F.

Welding of weld joint# 48A located on PCMK NSD1 FBSA4-1 A/C. Welder is identified as 066733. ZPMC QC is identified as Deng Zhi Bing. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2232-TC-U5-F.

Welding of weld joint# 3 located on PCMK SSD1 FESA4-1 E/F. Welder is identified as 068865. ZPMC QC is identified as Du Zhi Qun. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-4332-TC-P4-F.

Welding of weld joint# 3 located on PCMK SSD1 FESA4-1 E/F. Welder is identified as 069043. ZPMC QC is identified as Du Zhi Qun. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-4332-TC-P4-F.

Welding of weld joint# 3 located on PCMK SSD1 FESA4-1 D/F. Welder is identified as 052075. ZPMC QC is identified as Du Zhi Qun. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-4332-TC-P4-F.

Welding of weld joint# 3 located on PCMK SSD1 FESA4-1 D/F. Welder is identified as 050041. ZPMC QC is identified as Du Zhi Qun. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-4332-TC-P4-F.

SMAW Process:

Welding of weld joint# 61A located on PCMK NSD1 FBSA4-1 A/C. Welder is identified as 050289. ZPMC QC is identified as Guo Zhi Chun. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3212-TC-U5b-1.

Unless otherwise noted, all work observed on this date appeared to be 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 Serge Sinevod 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By: Chakrabarti,Dilip Kumar

Quality Assurance Inspector

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Reviewed By: Clifford, William

QA Reviewer