

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-008197**Date Inspected:** 03-Aug-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

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|------------------------------------|--------------------------------|-----------|------------|----------------------------------|------------------|-----------|------------|
| CWI Name: | Guo Peng, Li Lin, Yu Dong Ping | | | 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:

FCAW Process:

Welding of weld joint# 11 located on PCMK WSD1 FDSA4-4 D/D. Welder is identified as 070212. ZPMC QC is identified as Fu Wei Min. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2332-TC-P5-F.

Welding of weld joint# 10 located on PCMK WSD1 FDSA4-4 D/D. Welder is identified as 070140. ZPMC QC is identified as Fu Wei Min. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2332-TC-P5-F.

Welding of weld joint# 52 located on PCMK WSD1 FDSA4-4 D/D. Welder is identified as 069043. ZPMC QC is identified as Fu Wei Min. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2332-TC-P5-F.

Welding of weld joint# 53 located on PCMK WSD1 FDSA4-4 D/D. Welder is identified as 070046. ZPMC QC is identified as Fu Wei Min. The welding variables recorded by QC appeared to comply with the specified WPS no.

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B-T-2332-TC-P5-F.

Welding of weld joint# 44 located on PCMK WSD1 FDSA4-4 D/D. Welder is identified as 068864. ZPMC QC is identified as Guo Peng. The welding variables recorded by QC appeared to comply with the specified WPS no.

B-T-2332-TC-P5-F.

Welding of weld joint# 2 located on PCMK WSD1 FDSA4-4 D/D. Welder is identified as 066882. ZPMC QC is identified as Guo Peng. The welding variables recorded by QC appeared to comply with the specified WPS no.

B-T-2332-TC-P5-F.

Welding of weld joint# 45 located on PCMK WSD1 FDSA4-4 D/D. Welder is identified as 068683. ZPMC QC is identified as Guo Peng. The welding variables recorded by QC appeared to comply with the specified WPS no.

B-T-2332-TC-P5-F.

Welding of weld joint# 3 located on PCMK WSD1 FDSA4-4 D/D. Welder is identified as 067184. ZPMC QC is identified as Guo Peng. The welding variables recorded by QC appeared to comply with the specified WPS no.

B-T-2332-TC-P5-F.

SAW Process:

Welding of weld joint# 1A located on PCMK SD1 A5002-17,18,19,20. Welder is identified as 040634. ZPMC QC is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3221-TC-U5-S-1.

Welding of weld joint# 83B located on PCMK WSTL3-4 B/K. Welder is identified as 041716. ZPMC QC is identified as Li Lin. The welding variables recorded by QC appeared to comply with the specified WPS no.

B-T-2221-U2b-S-2.

Welding of weld joint# 83B located on PCMK WSTL3-4 B/K. Welder is identified as 052642. ZPMC QC is identified as Li Lin. The welding variables recorded by QC appeared to comply with the specified WPS no.

B-T-2221-U2b-S-2.

SMAW Process:

Welding of weld joint# 12 located on PCMK WSD1 FCSA4-2 C/C. Welder is identified as 040669. ZPMC QC is identified as Chen Hong Yun. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3212-TC-U5b-1.

Welding of weld joint# 14A located on PCMK WSD1 FCSA4-2 C/C. Welder is identified as 052642. ZPMC QC is identified as Chen Hong Yun. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3312-TC-P5.

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

Summary of Conversations:

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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.

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| Inspected By: | Chakrabarti,Dilip Kumar | Quality Assurance Inspector |
| Reviewed By: | Clifford,William | QA Reviewer |
