

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-008198**Date Inspected:** 04-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

CWI Name:	Li Lin			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# 10 located on PCMK WSD1 FDSA4-4 D/D. Welder is identified as 070212. ZPMC QC is identified as Li Lin. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-4332-TC-P5-F.

Welding of weld joint# 11 located on PCMK WSD1 FDSA4-4 D/D. Welder is identified as 070140. ZPMC QC is identified as Li Lin. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-4332-TC-P5-F.

Welding of weld joint# 34 located on PCMK WSD1 FDSA4-4 D/D. Welder is identified as 068864. ZPMC QC is identified as Chen Hong Yun. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2332-TC-P5-F.

Welding of weld joint# 16 located on PCMK WSD1 FDSA4-4 D/D. Welder is identified as 066882. ZPMC QC is identified as Chen Hong Yun. The welding variables recorded by QC appeared to comply with the specified WPS

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

no. B-T-2332-TC-P5-F.

Welding of weld joint# 33 located on PCMK WSD1 FDSA4-4 D/D. Welder is identified as 068683. ZPMC QC is identified as Chen Hong Yun. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2332-TC-P5-F.

Welding of weld joint# 17 located on PCMK WSD1 FDSA4-4 D/D. Welder is identified as 067184. ZPMC QC is identified as Chen Hong Yun. 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 WD1 A5001-1, 2, 3, 4. Welder is identified as 040634. ZPMC QC is identified as Yuan Wen Jie. 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# 1A located on PCMK SD1 A5012-29, 30, 31, 32. Welder is identified as 042195. ZPMC QC is identified as Yuan Wen Jie. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3221-TC-U5-S-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
Reviewed By:	Clifford,William	QA Reviewer
