

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-008243**Date Inspected:** 20-Jun-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:** Cheng Ying Xing**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.

This QA Inspector randomly observed the following work in progress

BAY#10

SMAW welding process of weld joint 59 located on PCMK SSD1-FBSA4-1A/C. Welder is identified as 040269 ZPMC QC is identified as Jiang Xiao Bo. The welding variables recorded by QC appeared to comply with the WPS-B-T-3212-TC-U5B-1.

SAW welding process of weld joint 1A located on PCMK ND1-SA250-47M-2. Welder is identified as 0503060 ZPMC QC is identified as Jiang Xiao Bo. The welding variables recorded by QC appeared to comply with the WPS-B-T-3221-TC-U5B-S-1

FCAW welding process of weld joint 13A located on PCMK NSD1-FESA4-1F/F. Welder is identified as 040338 ZPMC QC is identified as Yuan Hui Gang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-B-U3-F.

SAW welding process of weld joint 7B located on PCMK NSD1-FASA-1E/E. Welder is identified as 040252 ZPMC QC is identified as Yuan Hui Gang. The welding variables recorded by QC appeared to comply with the

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WPS-B-T-2221-B-U3C-S-2.

FCAW welding process of weld joint 27B located on PCMK NSD1-FASA4-1E/E. Welder is identified as 052075 ZPMC QC is identified as Jiang Xiao Bo. The welding variables recorded by QC appeared to comply with the WPS-B-T-4231-B-U3-F.

SAW welding process of weld joint 9A located on PCMK SSD1-FDSA4-1A/C. Welder is identified as 207745 ZPMC QC is identified as Wang Hao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-B-U3C-S-2.

SAW welding process of weld joint 66A located on PCMK NSD1-FCSA4-1A/C. Welder is identified as 050295 ZPMC QC is identified as Wang Hao. The welding variables recorded by QC appeared to comply with the WPS-B-T-4221-B-U3-S-3.

BAY#11

FCAW welding process of weld joint 22 located on PCMK ESD1-FASA4-2D/E. Welder is identified as 070046 ZPMC QC is identified as Zhang Bo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P5-F.

FCAW welding process of weld joint 23 located on PCMK ESD1-FASA4-2D/E. Welder is identified as 049220 ZPMC QC is identified as Zhang Bo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P5-F.

FCAW welding process of weld joint 55 located on PCMK ESD1-FASA4-2E/E. Welder is identified as 059525 ZPMC QC is identified as Zhang Bo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P5-F.

FCAW welding process of weld joint 56 located on PCMK ESD1-FASA4-2E/E. Welder is identified as 068206 ZPMC QC is identified as Zhang Bo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P5-F.

BAY#14

SAW welding process of weld joint 001 located on PCMK SEG-047-001. Welder is identified as 044755 ZPMC QC is identified as Li Li Ging. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-B-L2C-S-2.

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

Summary of Conversations:

No relevent Conversation.

Comments

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