

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-008256**Date Inspected:** 04-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:** Jin Dong Liang**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

FCAW welding process of weld joint 8 located on PCMK NSD1-SA166B/F. Welder is identified as 201825 ZPMC QC is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2331-TC-P4-F

FCAW welding process of weld joint 1A located on PCMK NSD1-TL8B/L. Welder is identified as 040261 ZPMC QC is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231C-U-F

BAY#11

SAW welding process of weld joint 39 located on PCMK ESD1-FCSA4-2A/C. Welder is identified as 067888 ZPMC QC is identified as Xu Yumin. The welding variables recorded by QC appeared to comply with the WPS-B-T-2321B-P3-S2

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SAW welding process of weld joint 44B located on PCMK WSD1-FCSA-2AC. Welder is identified as 062611 ZPMC QC is identified as Ma Qian Li. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221B-U2C-S2.

OBG TRIAL ASSEMBLY YARD

FCAW welding process of weld joint 49 located on PCMK SEG014E. Welder is identified as 068599 ZPMC QC is identified as Zhang hai tao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U2-F

FCAW welding process of weld joint 59 located on PCMK 1AE-1BE-BP312 Welder is identified as 045280 ZPMC QC is identified as Zhang Zhen mao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U2-F

SMAW welding process of weld joint 008 located on PCMK OBW1A-008. Welder is identified as 068917 ZPMC QC is identified as Zhang hai tao. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-B-U2-FCM

TRIAL ASSEMBLY YARD

Visual Inspection

During the random visual inspection of OBG segment 1AE-1BE this Caltrans OSM Quality Assurance (QA) Inspector observed surface indications in the base material, transverse to the weld, where alignment plate had been welded adjacent to the bottom of weld OBW1A-008 between segment OBG 1AW and 1 BW. Subsequent MT inspections by QA confirmed a linear indication at approximately 2.8 meters and 3.6 meters from the bottom corner underneath the counterweight side of the OBG. ABF Representative Mr. Kelvin Cheung informed QA that ZPMC will be performing MT inspection of this temporary attachment weld removal area and all relevant indication will be repaired. An incident report was submitted for this.

Unless otherwise noted, all work observed on this dated 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 134-8257-0045, who represents the Office of Structural Materials for your project.

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