

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-008257**Date Inspected:** 05-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**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

SAW welding process of weld joint 52B located on PCMK NSD1-A166E/J. Welder is identified as 050360 ZPMC QC is identified as Jin Dong Liang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-B-L2A-S

SAW welding process of weld joint 113B located on PCMK NSD1-A112B/H. Welder is identified as 040252ZPMC QC is identified as Jin Dong Liang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-B-L2A-S

SAW welding process of weld joint 32A located on PCMK NSD1-A166E/J. Welder is identified as 051413 ZPMC QC is identified as Jin Dong Liang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-CU2B-S-2

SAW welding process of weld joint 3B located on PCMK NSD1-A112B/H. Welder is identified as 050259 ZPMC QC is identified as Jin Dong Liang. The welding variables recorded by QC appeared to comply with the

WELDING INSPECTION REPORT

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WPS-B-T-2221-CU2B-S-2

SAW welding process of weld joint 15A located on PCMK NSD1-FESA4-3A/F. Welder is identified as 201750 ZPMC QC is identified as Zong Yi. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-B-U3C-S-2.

BAY#11

SAW welding process of weld joint 1A located on PCMK WSD1-TL6B/L. Welder is identified as 040634 ZPMC QC is identified as Peng Guo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2321-C-U2B-S-2.

SAW welding process of weld joint 27B located on PCMK ESD1-FCSA4-2AC. 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-2221B-U3C-S2.

SAW welding process of weld joint 42B located on PCMK ESD1-FCSA4-2AC. Welder is identified as 046772 ZPMC QC is identified as Xu Yumin. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221B-U3C-S2.

SAW welding process of weld joint 63B located on PCMK ESD1-FCSA4-2AC. Welder is identified as 067993 ZPMC QC is identified as Xu Yumin. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221B-U3C-S2

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
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Reviewed By:	Clifford,William	QA Reviewer
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