

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-008291**Date Inspected:** 28-Jul-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name: Liu Zhong An
Inspected CWI report: Yes No N/A
Electrode to specification: Yes No N/A
Qualified Welders: Yes No N/A
Approved Drawings: Yes No N/A

CWI Present: Yes No
Rod Oven in Use: Yes No N/A
Weld Procedures Followed: Yes No N/A
Verified Joint Fit-up: Yes No N/A
Approved WPS: Yes No N/A
Delayed / Cancelled: Yes No N/A

Bridge No: 34-0006**Component:** OBG and Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Larry Viars was present during the times noted above for observations relative to the work being performed.

OBG Trail Assembly:

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as OBG 3AW stiffener welds at panel point 19. The weld identification numbers are as follows: SP009-001-044 through 057, SP017-001-038 through 049, SP025-001-038 through 049, SP045-001-086 through 099, SP057-001-095 through 106, SP069-001-086 through 097, EP001-001-008 through 011, SP001-001-017 through 026, EP005-001-014 through 017, SP033-001-021 through 030, DP009-001-011 through 016 and DP011-001-011 through 016.

QA observed ZPMC Personnel performing MT of excavation areas on OBG segment 3AW Deck Panel Diaphragm to Floor beam welds.

Bay 10:

This QA Inspector observed the following work in progress: FCAW welding of weld joint NSTL3-3 B/K 83B located on the North Tower Lift 3. ZPMC welder was identified as 054069. ZPMC QC is identified as Liu Zhong An. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2231-C-U2-F.

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FCAW welding of weld joint NSTL3-3 B/K 81A located on the North Tower Lift 3. ZPMC welder was identified as 066733. ZPMC QC is identified as Liu Zhong An. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2232-TC-U4b-F.

SAW welding of weld joint NSTL3-3 B/K 82B located on the North Tower Lift 3. ZPMC welder was identified as 050295. ZPMC QC is identified as Liu Zhong An. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2221-TC-U2b-S-2.

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

Summary of Conversations:

Only general conversation occurred between QA and QC this date.

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:	Viars,Larry	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
