

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-008557**Date Inspected:** 19-May-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 Ming**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 30 located on PCMK NSD1-FDSA3-1B/C. Welder is identified as 066484 ZPMC QC is identified as Li Ming. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P5-F

FCAW welding process of weld joint 29 located on PCMK NSD1-FDSA3-1B/C. Welder is identified as 070046 ZPMC QC is identified as Li Ming. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P5-F

FCAW welding process of weld joint 43 located on PCMK NSD1-FDSA3-1B/C. Welder is identified as 068206 ZPMC QC is identified as Li Ming. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P5-F

FCAW welding process of weld joint 44 located on PCMK NSD1-FDSA3-1B/C. Welder is identified as 067499 ZPMC QC is identified as Li Ming. The welding variables recorded by QC appeared to comply with the

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WPS-B-T-2332-TC-P5-F.

OBG TRIAL ASSEMBLY YARD

FCAW welding process of weld joint 02 located on PCMK OBW2A. Welder is identified as 220063 ZPMC QC is identified as Chen Bo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333T

FCAW welding process of weld joint 02 located on PCMK OBW2A. Welder is identified as 220069 ZPMC QC is identified as Chen Bo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231T.

OBG TRIAL ASSEMBLY YARD

Visual Inspection

During random in-process visual inspection in OBG Assembly yard the Joint between T stiffeners of segment 2AW to 2BW, the Caltrans Quality Assurance (QA) Inspector observed the root opening 8 to 10mm. This root opening exceeds the tolerances specified in AWS D1.5 2002. The Weld Designations as Follows:

BP193A-001-020; SP174A-001-023; SP-172A-001-052

For this the incident report was send to task leader and other supervisor.

Unless otherwise noted, all work observed on this dated appeared to 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:	Utekar,Shrikant	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
