

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-008607**Date Inspected:** 08-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:** Ju Jum**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.

Bay#11

Visual Inspection and Magnetic Particle Inspection

This Q.A Inspector performed random Visual Inspection and approximately 15% Magnetic particle testing of the area previously tested and accepted by ZPMC Quality control personnel. The members are identified as the East Tower Lift 2. The welds Designation are as follows.

Skin E/A Corner on double Diaphragm 65m, 53m, 77m

BAY#10

Visual Inspection and Magnetic Particle Inspection

This Q.A Inspector performed random Visual Inspection and approximately 15% Magnetic particle testing of the area previously tested and accepted by ZPMC Quality control personnel. The members are identified as the South Tower Lift 3 Doubler plate. The welds Designation are

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SSD1-FESA3-1D/D-10, 11, 18, 1, 2, 9; SSD1-FESA3-1C/D-1, 2, 9

This QA Inspector randomly observed the following work in progress

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SMAW welding process of weld joint 7A located on PCMK SSD1-FASA-4-1A/E. Welder is identified as 040582ZPMC QC is identified as Yuan Hui gang. The welding variables recorded by QC appeared to comply with the WPS-B-T-4211-B-U3-B2.

FCAW welding process of weld joint 22 located on PCMK NSD1-FASA3-1E/E. Welder is identified as 057206 ZPMC QC is identified as Ju Jum. 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 NSD1-FASA3-1E/E. Welder is identified as 040330 ZPMC QC is identified as Ju Jum. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P5-F.

FCAW welding process of weld joint 54 located on PCMK NSD1-FASA3-1E/E. Welder is identified as 040345 ZPMC QC is identified as Ju Jum. 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 NSD1-FASA3-1E/E. Welder is identified as 048784 ZPMC QC is identified as Ju Jum. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P5-F.

SAW welding process of weld joint 6A located on PCMK NSD1-PASA4-1A/E. Welder is identified as 250522 ZPMC QC is identified as Lu Wei chao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-B-U3C-S-2.

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FCAW welding process of weld joint 25 located on PCMK ESD1-FSDA-3-2C/C. Welder is identified as 067500 ZPMC QC is identified as Zhang Zhi neng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P5-F

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 13482570045, who represents the Office of Structural Materials for

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your project.

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