

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-008609**Date Inspected:** 22-Apr-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 Le			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

This Q.A Inspector performed random Visual inspection of the area previously tested and accepted by ZPMC Quality control personnel. The member are identified as the Lift 1 East Tower. The welds Designation are as follows

Lift 1 East Tower, Bearing plate between skin E stiffeners.

ESD1-SA227A/E-73, 74, 75, 76, 77, 78, 79, 80, 81, 82, 83, 84, 85, 86

Gusset stiffener on skin C stiffeners-

ESD1-SA294 F/G-137, 138; ESD1-A167D/H-2, 3; ESD1-SA294G/G-19, 22; ESD1-A167D/H-26, 27;
ESD1-SA294G/G-139, 140; ESD1-SA294G/G-20, 21

13m Angle and channel 1 beam on skin a and b on 9m and 13m diaphragm

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

This QA Inspector randomly observed the following work in progress

Bay#11

FCAW welding process of the weld joint -36 located on PCMK ESD1-FDS A3- 2B/C. Welder is identified 070046 ZPMC QC is identified LILE. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P5-F.

FCAW welding process of the weld joint -37 located on PCMK ESD1-FDS A3- 2B/C. Welder is identified 069043 ZPMC QC is identified LILE. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P5-F.

Repair:

The Angle and channel on beam skin a and b on 9m and 13m diaphragm Found to be repair. That previously inspected by ZPMC Inspector.

Grinding and Welding Rectification:

Noticed Grinding and welding for visual imperfection being rectified for Lift 1 East Tower Bearing plate between skin E stiffeners. And Gusset stiffener on skin C stiffeners.

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
