

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-008963**Date Inspected:** 30-Aug-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:** Zhu Tian Shu**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 and OBG**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.

Bay 2:

This QA Inspector observed the following work in progress: FCAW welding of Floor beam web plate to flange fillet weld FB3063-001-026. ZPMC welder was identified as 045203. ZPMC QC is identified as Chen Xi. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2133.

Bay 6:

This QA Inspector observed the following work in progress: SMAW welding of Strut assembly flange to stiffener fillet weld WD1-A305-77-2-050 and 51. ZPMC welder was identified as 049769. ZPMC QC is identified as Zhao Chen Sun. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2112.

Bay 3:

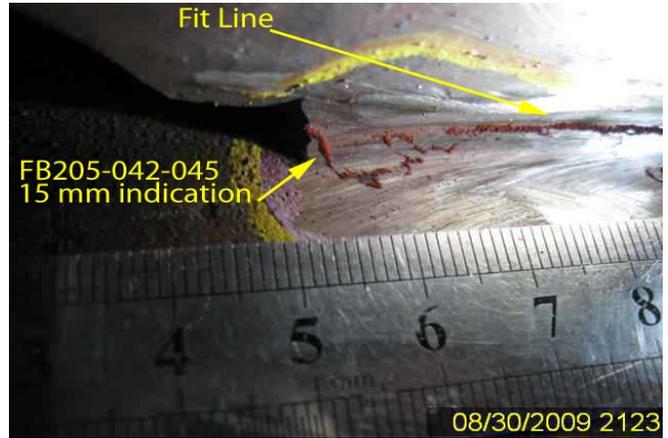
During visual inspection prior to Magnetic Particle Testing (MT), this Quality Control Inspector discovered two linear indications in the base material of Floor Beam fillet weld FB205-042-045 excavation area. The indications were verified with MT. The indications were measured to be approximately 15 mm and 4 mm in length. The excavation area had been previously tested and accepted by ZPMC Quality Control (QC). ZPMC QC stated that

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fillet weld FB205-042-045 had been inadvertently welded and this weld was intended to be completed after segment fit up. ZPMC Quality Control (QC) relayed that a Critical Weld Repair for the base metal repair would be submitted for engineering approval. Note: This inspection was performed as referenced on ZPMC NDT Inspection Notification Sheet 4110. QA inspector generated an MT report and Incident report for this date. Please see attached photos below.

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



Summary of Conversations:

As identified within the contents of this report.

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 Eric Tsang, 150 0042 2372, who represents the Office of Structural Materials for your project.

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