

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-008972**Date Inspected:** 09-Sep-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:** Wan Wen Zhong**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:** 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 Trial Assembly:

During Magnetic Particle Testing (MT) verification, this Quality Control Inspector discovered a linear indication measuring approximately 15 mm in length in the base material of OBG Segment 1AAE deck panel lifting device weld removal area. The indication was located 8770 mm from the edge plate to deck panel weld on the bike path side. The base material at the lifting device removal area had been previously tested and accepted by ZPMC Quality Control (QC). Caltrans QA submitted an incident report this date for the above mentioned MT indication. Please see the attached photos.

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This QA Inspector observed the following work in progress: FCAW welding of the diaphragm fit lug weld NSTL3-3 C/K located on the North Tower Lift 3. ZPMC welder was identified as 057244. ZPMC QC is identified as Wan Wen Zhong. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2133.

SMAW tack welding of Skin plate A to Skin B, weld SSTL4-1 B/L-4A on the South Tower Lift 4. ZPMC welders were identified as 057186 and 052892. ZPMC QC is identified as Wan Wen Zhong. The welding appeared to be in

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conformance with welding procedure specification, WPS-B-P-2214-C-U2.

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
