

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-009132**Date Inspected:** 10-Sep-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:** Lvli Qing, 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:** 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#10

Ultrasonic Inspection

This Q.A Inspector performed Ultrasonic Testing of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated a (U.T) report for this date. The members are identified as North tower lift #3. The weld designation is as follows.

NSTL3-3C/K-65

BAY#10

This QA Inspector randomly observed the following work in progress.

FCAW welding process of weld joint 03 located on PCMK NSD1-FESA4-3E/F. Welder is identified as 053869 ZPMC QC is identified as Wan Wen Zhong. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P4-F.

FCAW welding process of weld joint 10 located on PCMK NSD1-FESA4-3D/F. Welder is identified as 057180

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ZPMC QC is identified as Wan Wen Zhong. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P4-F.

SMAW welding process of weld joint 26 located on PCMK ED1-A6003-3. Welder is identified as 050289 ZPMC QC is identified as Yuan Hui Gang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2112.

SMAW welding process of weld joint 30 located on PCMK ED1-A6003-2. Welder is identified as 040581 ZPMC QC is identified as Yuan Hui Gang. The welding variables recorded by QC appeared to comply with the WPS-B-T-4113-1.

SMAW welding process of weld joint 60 located on PCMK ED1-A6003-2. Welder is identified as 056364 ZPMC QC is identified as Yuan Hui Gang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2113.

SMAW welding process of weld joint 32 located on PCMK ED1-A6003-2. Welder is identified as 057258 ZPMC QC is identified as Yuan Hui Gang. The welding variables recorded by QC appeared to comply with the WPS-B-T-4113-1.

SMAW welding process of weld joint 77 located on PCMK SSSL3-1B/K. Welder is identified as 040582 ZPMC QC is identified as Jiang Xiao Bo. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F) Repair.

SMAW welding process of weld joint 78 located on PCMK SSSL3-1B/K. Welder is identified as 053829 ZPMC QC is identified as Jiang Xiao Bo. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G (2F) Repair.

BAY#11

This QA Inspector randomly observed the following work in progress.

This QA Inspector observed ZPMC performing build up with the help of FCAW welding process on skin 'A' strut plate of west tower lift four. Welder is identified as 068206, 067184 ZPMC QC is identified as Li Hong Fei. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-2G (2F) Repair.

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 your project.

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