

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-009390**Date Inspected:** 06-Oct-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:** Tu Jun, Xi Yumin**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/OBG**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

This QA Inspector randomly observed the following work in progress.

SMAW welding process of weld joint 1A located on PCMK ND1-15012-31. Welder is identified as 057258 ZPMC QC is identified as Sun Jian Liang. The welding variables recorded by QC appeared to comply with the WPS-485-SMAW-1G (1F) Repair. The weld repair report noted as T-WR 2377 and ZPMC ultrasonic report identified as T787-UT-2256-R1.

FCAW welding process of weld joint 115 located on PCMK NSTL3-3I/K. Welder is identified as 052075 ZPMC QC is identified as Wang Chuan Ging. The welding variables recorded by QC appeared to comply with the WPS-B-T-4333-TC-P4-F.

FCAW welding process of weld joint 96 located on PCMK NSTL3-3I/K. Welder is identified as 053116 ZPMC QC is identified as Wang Chuan Ging. The welding variables recorded by QC appeared to comply with the WPS-B-T-4333-TC-P4-F.

FCAW welding process of weld joint 77 located on PCMK NSTL3-3B/K. Welder is identified as 057180 ZPMC

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

QC is identified as Wang Chuan Ging. The welding variables recorded by QC appeared to comply with the WPS-B-T-2331-TC-P4-F.

FCAW welding process of weld joint 80 located on PCMK NSTL3-3B/K. Welder is identified as 052075 ZPMC QC is identified as Wang Chuan Ging. The welding variables recorded by QC appeared to comply with the WPS-B-T-2331-TC-P4-F.

TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress.

OBG SEGMENT 1AAW- 1AW

This Quality assurance (QA) Inspector observed ZPMC welders 220063 and 220067 performing buttering with the help of FCAW process on deck panel 'I' rib stiffener of OBG segment 1AAW and 1AW. ZPMC QC (CWI) is identified as Xu Yumin. The welding variables recorded by QC appeared to comply with WPS -345-FCAW-4G (4F) Repair. The critical weld report identified as B-CWR778. For additional information see attached photo.

OBG SEGMENT 5CW

This Quality assurance (QA) Inspector observed that ZPMC personnel performing the match drill hole on side panel 'T' stiffener at PP 35 in OBG segment 5CW.

OBSERVATIONS

OBG SEGMENT-1AAE-1AE

This Quality Assurance (QA) Inspector observed the deck panel splice joint between OBG segment 1AAE and 1AE observed excavated at 10 different locations. The lengths of excavations and locations are as below from bike path side.

Excavation located	Length of excavation
1) 1150mm to 1300mm	150mm
2) 2670mm to 2820mm	150mm
3) 5230mm to 5390mm	160mm
4) 5730mm to 5870mm	140mm
5) 6340mm to 6480mm	140mm
6) 8850mm to 9000mm	150mm
7) 9730mm to 9870mm	140mm
8) 10000mm to 10120mm	120mm
9) 10240mm to 10370mm	130mm
10) 10780mm to 10970mm	190mm

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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



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.

Inspected By:	Utekar,Shrikant	Quality Assurance Inspector
----------------------	-----------------	-----------------------------

Reviewed By:	Dawson,Paul	QA Reviewer
---------------------	-------------	-------------