

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-009412**Date Inspected:** 24-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Xi**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 Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Hiranch Patel, was present during the times noted above for observations relative to the work being performed.

Bay#6

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member is identified as Tower Components. The weld designations reviewed are as follows:

-(WSD1-DPSA4-4B/B-009, 011, 014, 015, 018, 019)

-(WSD1-SA4-52-3~8)

-(WSD1-DPSA4-4B/B-2)

-(WSD1-DPSA4-4A/B-3~8, 1)

Bay#11

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member is identified as Tower Components. The weld designations reviewed are as follows:

-(WSTL3-4B/K-83A/B)

This QA inspector observed the following work in progress:

Bay#2

FCAW welding of weld joint FB3093-001-042, 043, 052, 053 located on FB3093-001. Welder is identified as 062438 (2G/2F). ZPMC QC is identified as Xang Qing Feng. The welding variables recorded by QC appeared to

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comply with the Applicable WPS.

FCAW welding of weld joint FB3012-003-018, 019, 024, 025 located on FB3012-003. Welder is identified as 045203 (2G/2F). ZPMC QC is identified as Xang Qing Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint FB3089-001-067, 068, 071, 072 located on FB3089-001. Welder is identified as 206358 (2G/2F). ZPMC QC is identified as Xang Qing Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint FB3079-001-008, 035, 036 located on FB3079-001. Welder is identified as 045209 (2G/2F). ZPMC QC is identified as Xang Qing Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Bay#5

FCAW welding of weld joint CB202G-031-043, 044 located on CB011. Welder is identified as 217185(3F). ZPMC QC is identified as Zheng Zhi Wei. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint CB202G-029/030/031-001 located on CB011. Welder is identified as 217185(3G). ZPMC QC is identified as Zheng Zhi Wei. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Bay#6

FCAW welding of weld joint FB204-024-087 located on CB-009. Welder is identified as 220688(3G). ZPMC QC is identified as Zhou Jie. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint FB204-023-088, 087 located on CB-009. Welder is identified as 220688(3G). ZPMC QC is identified as Zhou Jie. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint FB204-022-088, 087 located on CB-009. Welder is identified as 220688(3G). ZPMC QC is identified as Zhou Jie. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint FB204-021-088 located on CB-009. Welder is identified as 220688(3G). ZPMC QC is identified as Zhou Jie. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Unless otherwise noted, all observed on this date 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 Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for

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your project.

Inspected By:	Patel,Hiranch	Quality Assurance Inspector
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Reviewed By:	Patterson,Rodney	QA Reviewer
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