

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-009418**Date Inspected:** 21-May-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:** Xu Xian ping**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 /Tower 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#2

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 OBG Floor Beam. The weld designations reviewed are as follows:

-(FB023-007) Green Tag#007550

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:

-(WSD1-FBSA3-2A/C-37A/B, 43A/B)

-(WSD1-FBSA3-2B/C-1A/B, 7A/B)

-(Stiffener to skin A- West Tower Lift3)

Bay#2

This QA inspector performed a visual and dimensional inspection on the area previously inspected and accepted by ZPMC Quality Control personnel. The member is identified as Segment 1AAW welds. The weld designations

WELDING INSPECTION REPORT

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reviewed are as follows:

-(1AAW- Seg1-017~34)

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

BAY#3

On going SMAW Welding of Weld Joint 2F -01 & 3F-02 Located on FB006-181 Welder no indentified as 051359 & 058102 and The welding variables recorded by QC ZMPC Mr. Zhang Yaxu to comply with the WPS-B-P-2112 & WPS-B-P-2133.

BAY#2

On going FCAW Welding of Weld Joint 1G-127 Located on FB020-005 Welder no indentified as 062708 and The welding variables recorded by QC ZMPC Mr. Zhan Hai Feng to comply with the WPS-B-T-2231-Tc-U4b-F.

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 your project.

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