

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-009452**Date Inspected:** 27-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:** Li Ming**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 and OBG**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-

This Caltrans QA Inspector observed ZPMC QC perform radiography of OBG segments 2AE and 2AW deck panel welds between panel points 13 and 14. ZPMC radiographers stated produced a list of welds of the following welds that were to be tested: Segment 2AW, Seg007-069 through 075 and Segment 2AE, Seg008-069 through 075.

Bay 10-

This QA Inspector observed the following work in progress: Flux Cored Arc Welding (FCAW) of South Tower Lift 3 bottom diaphragm corner plate weld, SSTL3-1 C/K 53 at the 89 meter mark. ZPMC welder was identified as 050041. ZPMC QC was identified as Li Ming. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-4332-TC-P4-F.

Shielded Metal Arc Welding (SMAW) of North Tower Lift 3 Skin Plate A to D corner weld, NSTL3-3 C/K-83A. ZPMC welder was identified as 050289. ZPMC QC was identified as Li Ming. The welding appeared to be in conformance with critical weld repair report 274 and welding procedure specification, WPS-345-SMAW-2G (2F)-Repair.

WELDING INSPECTION REPORT

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Bay 11-

This QA inspector performed Ultrasonic Testing (UT) verification of the areas previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members were identified as East Tower Lift 3 Skin plate D to E corner weld seam ESTL3-4 B/K 82A/B.

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

Summary of Conversations:

Only general conversation occurred between QC and QA this date.

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, 134 8257 0045, who represents the Office of Structural Materials for your project.

Inspected By:	Viars,Larry	Quality Assurance Inspector
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Reviewed By:	Dawson,Paul	QA Reviewer
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