

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-009528**Date Inspected:** 07-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:	Wang Chuan Ging , Tu Jun	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.

Flux cored arc welding (FCAW) process of weld joint 4A located on PCMK NSD1-SPSA3-56. Welder is identified as 040533 ZPMC QC (CWI) is identified as Wang Chuan Ging. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-TC-U5-F.

Flux cored arc welding (FCAW) process of weld joint 2A located on PCMK NSD1-SPSA3-4. Welder is identified as 053870 ZPMC QC (CWI) is identified as Wang Chuan Ging. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-TC-U5-F

NORTH TOWER LIFT #3

Flux cored arc welding (FCAW) process of weld joint 4 located on PCMK NSTL3-3C/K. Welder is identified as 057266 ZPMC QC (CWI) is identified as Tu Jun. The welding variables recorded by QC appeared to comply with the WPS-B-T-4333-TC-U5-F.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Flux cored arc welding (FCAW) process of weld joint 5 located on PCMK NSTL3-3C/K. Welder is identified as 057244 ZPMC QC (CWI) is identified as Tu Jun. The welding variables recorded by QC appeared to comply with the WPS-B-T-4333-TC-U5-F.

Flux cored arc welding (FCAW) process of weld joint 114 located on PCMK NSTL3-3I/K. Welder is identified as 050041 ZPMC QC (CWI) is identified as Tu Jun. The welding variables recorded by QC appeared to comply with the WPS-B-T-4333-TC-U5-F.

Flux cored arc welding (FCAW) process of weld joint 81 located on PCMK NSTL3-3G/K. Welder is identified as 052075 ZPMC QC (CWI) is identified as Tu Jun. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-U5-F.

Flux cored arc welding (FCAW) process of weld joint 82 located on PCMK NSTL3-3G/K. Welder is identified as 057180 ZPMC QC (CWI) is identified as Tu Jun. The welding variables recorded by QC appeared to comply with the WPS-B-T-4333-TC-U5-F.

BAY#14

OBG SEGMENT 10CW

Flux cored arc welding (FCAW) process of weld joint 106 located on PCMK SSD10-PP92. Welder is identified as 050316 ZPMC QC is identified as Liu Wan Ning. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132.

TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress.

OBG SEGMENT 5AW

This Quality assurance (QA) Inspector observed ABF NDT Inspector performing magnetic particle inspection on the hold back weld of 'T' stiffener to side panel at field splice location of OBG segment 4BW and 5AW.

OBG SEGMENT 5AE

This Quality assurance (QA) Inspector observed ABF NDT Inspector performing magnetic particle inspection on the hold back weld of 'T' stiffener to side panel at field splice location of OBG segment 4BE and 5AE.

OBSERVATIONS

OBG SEGMENT 1AW-1BW

This Quality Assurance (QA) Inspector observed the side panel splice joint between OBG segment 1AW and 1BW (cross beam side) observed excavated inside at 'Y' location approximately 2200mm to 2360mm from bottom panel towards edge panel.

OBG SEGMENT 1AAW-1AW

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

This Quality Assurance (QA) Inspector observed the side panel splice joint between OBG segment 1AAW and 1AW (cross beam side) observed excavated inside at 'Y' location approximately 700 mm to 4000 mm from edge panel towards bottom panel.

This Quality Assurance (QA) Inspector observed the bottom panel splice joint between OBG segment 1AAW and 1AW observed excavated outside at 'Y' location approximately 5670 mm to 5800 mm from cross beam side towards counter weight side.

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.

Inspected By:	Utekar,Shrikant	Quality Assurance Inspector
Reviewed By:	Dawson,Paul	QA Reviewer
