

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-009563**Date Inspected:** 14-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 , Xu 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 day CALTRANS OSM Quality Assurance Inspector (QA) Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

BAY #10

This QA Inspector randomly observed the following work in progress.

SOUTH TOWER LIFT # 4

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 040345 performing Flux Core Arc Welding process for the weld joint SSSL4-1C/L -1 located on PCMK South tower lift #4. ZPMC QC Mr. Sun Tian Liang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P4-F.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 057266 performing Flux Core Arc Welding process for the weld joint SSSL4-1C/L -4 located on PCMK South tower lift #4. ZPMC QC Mr. Sun Tian Liang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P4-F.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 052075 performing Flux Core Arc

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Welding process for the weld joint SSTL4-1G/L -8 located on PCMK South tower lift #4. ZPMC QC Mr. Sun Tian Liang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P4-F.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 053870 performing Flux Core Arc Welding process for the weld joint SSTL4-1C/L -15 located on PCMK South tower lift #4. ZPMC QC Mr. Sun Tian Liang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P4-F.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 053116 performing Flux Core Arc Welding process for the weld joint SSTL4-1K/L -132 located on PCMK South tower lift #4. ZPMC QC Mr. Wang Chuang Ging monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P5-F.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 054069 performing Flux Core Arc Welding process for the weld joint SSTL4-1K/L -133 located on PCMK South tower lift #4. ZPMC QC Mr. Wang Chuang Ging monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P5-F.

TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress.

OBG SEGMENT 1BW- 1AW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 048659 performing Shielded Metal Arc Welding process for the weld joint OBW1A-007 (out-side) on excavated area located on PCMK side panel splice weld joint between of OBG segment 1AW and 1BW Counter weight side. The Y location measured approximately 0 to 5000mm from bottom panel towards edge panel. ZPMC QC Mr. Feng Yangjun monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F) Repair-1. The critical weld repair report identified as B-CWR831.

OBG SEGMENT 1AAW- 1AW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 220067 performing Shielded Metal Arc Welding process for the weld joint OBW1A-004 (out- side) on the excavated areas located on PCMK side panel splice weld joint between of OBG segment 1AAW and 1AW counter weight side. The Y location measured approximately 2500 to 2600mm from bottom panel towards edge panel. ZPMC QC Mr. Xu Yumin monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F) Repair-1. The weld repair report identified as B-WR7918.

OBG SEGMENT 2AE- 2BE

This Quality Assurance (QA) Inspector observed ZPMC qualified welders 049769 performing Shielded Metal Arc Welding process for the weld joint OBW2A-003(in-side) on the excavated areas located on PCMK bottom panel splice weld joint between of OBG segment 2AE and 2BE. The Y location measured approximately 3000 to 3120mm and 3900 to 4700mm from cross beam side longitudinal diaphragm. ZPMC QC Mr. Xu Yumin

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monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F)-FCM- Repair-1. The critical weld repair report identified as B-CWR827.

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
