

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-009834**Date Inspected:** 28-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:** Wan Wen Zhong**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.

NORTH TOWER LIFT # 3

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 050038 performing Shielded Metal Arc Welding process for the weld joint NSTL3-3G/K-55 located on PCMK North tower lift #3. ZPMC QC Mr. Wan Wen Zhong monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-3212-B-U2A-2.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 052493 performing Shielded Metal Arc Welding process for the weld joint NSTL3-3G/K-142 located on PCMK North tower lift # 3. ZPMC QC Mr. Wan Wen Zhong monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-3212-B-U2A-2.

TRIAL ASSEMBLY YARD

WELDING INSPECTION REPORT

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This QA Inspector randomly observed the following work in progress.

OBG SEGMENT 1AW- 1BW

This Quality Assurance (QA) Inspector observed ZPMC qualified welders 049769, 048659 performing Shielded Metal Arc Welding process for the weld joint OBW1A-007 on the excavated areas located on PCMK side panel splice weld joint between of OBG segment 1AW and 1BW counter weight side. The Y location measured approximately 4245mm and 4630mm. ZPMC QC Mr. Xu Yumin monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-3G (3F) FCM-Repair-1. The critical weld repair report identified as B-CWR875.

OBG SEGMENT 1AAE- 1AE

This Quality Assurance (QA) Inspector observed ZPMC qualified welders 045138, 045196 performing Shielded Metal Arc Welding process for the weld joint OBEA-003 on the excavated areas located on PCMK bottom panel splice weld joint between of OBG segment 1AAE and 1AE. The Y location measured approximately 105mm, 900, 2410 and 1960 from bike path side longitudinal diaphragm. ZPMC QC Mr. Zhang Hai Tao monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F) FCM-Repair-1. The weld repair report identified as B-CWR868.

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
