

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-010803**Date Inspected:** 21-Dec-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:** Guo Peng, Yuan Hui Gang**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**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.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 057258 performing Shielded Metal Arc Welding process for the weld 19 located on PCMK ED1-A6003-8. ZPMC QC Mr. Yuan Hui Gang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2113.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 056364 performing Shielded Metal Arc Welding process for the weld 58 located on PCMK ED1-A6003-8. ZPMC QC Mr. Yuan Hui Gang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2113.

HEAVY DOCK

This QA Inspector randomly observed the following work in progress.

SOUTH TOWER LIFT # 1

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This Quality Assurance (QA) Inspector observed ZPMC qualified welder 058075 performing Flux Cored Arc Welding process for the weld SSD1-SA17F/G-14 located on PCMK the weld between P389 and P1144 on skin C of South tower lift 1. ZPMC QC Mr. He Gen monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 050041 performing Flux Cored Arc Welding process for the weld SSD1-SA17F/G-16 located on PCMK the weld between P389 and P1144 on skin C of South tower lift 1. ZPMC QC Mr. He Gen monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 057244 performing Flux Cored Arc Welding process for the weld SSD1-SA17F/G-22 located on PCMK the weld between P393 and P1144 on skin C of South tower lift 1. ZPMC QC Mr. He Gen monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 054069 performing Flux Cored Arc Welding process for the weld SSD1-SA17F/G-24 located on PCMK the weld between P393 and P1144 on skin C of South tower lift 1. ZPMC QC Mr. He Gen monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 201825 performing Flux Cored Arc Welding process for the weld SSD1-SA16F/G-10 located on PCMK the weld between P503 and P169 on skin E of South tower lift 1. ZPMC QC Mr. He Gen monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 053116 performing Flux Cored Arc Welding process for the weld SSD1-SA16F/G-25 located on PCMK the weld between P503 and P169 on skin E of South tower lift 1. ZPMC QC Mr. He Gen monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

EAST TOWER LIFT # 1

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 062126 performing Flux Cored Arc Welding process for the weld ESD1-SA294F/G-16 located on PCMK the skin C of East tower lift 1. ZPMC QC Mr. Guo Peng monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 049541 performing Flux Cored Arc Welding process for the weld ESD1-SA294F/G-18 located on PCMK the skin C of East tower lift 1. ZPMC QC Mr. Guo Peng monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 040704 performing Flux Cored Arc Welding process for the weld ESD1-SA227F/H-8 located on PCMK the skin E of East tower lift 1. ZPMC QC Mr. Guo Peng monitoring this welding. The welding variables recorded by QC appeared to comply with the

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WPS-B-T-2333-TC-P4-F.

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

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