

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-012211**Date Inspected:** 15-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Lin and Du Zhi Gun**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:** OBG Trial Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S. Manjunath Math was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

IN PROCESS INSPECTION:-

TOWER TRAIL ASSEMBLY AREA:-

NORTH SHAFT LIFT 1:-

This QA inspector observed the following work in progress:

ZPMC performed Weld metal repair of Interior Bearing Plate located on Skin E (NSD1-SA76F/F-04). The weld metal repair areas were approximately 2mm depth and 50mm length at 2 random locations. The material is A709M Grade 345 Non-SPCM. Welder is identified as 053829.ZPMC CWI is identified as Mr. You Qi Guo. SMAW welding was been performed. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-3G (3F)-Repair.

BAY 11:-

NORTH CONNECTING PLATE :-

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

This QA Inspector observed ZPMC welding personnel performing welding by Submerged Arc Welding (SAW) for Connection Plate. The Piece Mark was identified as ST-4-4 (485 Grade Steel) and ST-4-7 (345 Grade Steel) for East Lift E-139B-1/2-3A and North Lift 139B-1/2-3A. The welder is identified as 040699. In process SAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-4221-B-U3C-S-1. It was observed that the parameters noted down by ZPMC QC are in compliance with WPS.

BAY 10:-
STRUT PLATE:-

This QA Inspector observed ZPMC welding personnel performing welding by Shielded Metal Arc Welding (SMAW) for Strut Plate. The weld joint was identified as ED1-ST-SA3-2-109M-2-24B. The welder is identified as 057258. The welding was in progress against the TWR 3065 Rev.0 Date Feb 12, 2010. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-345-SMAW-2G (2F)-FCM-Repair. It was observed that the parameters noted down by ZPMC QC are in compliance with WPS.

BAY 11:-
STRUT PLATE:-

This QA Inspector observed ZPMC welding personnel performing welding by Submerged Arc Welding (SAW) for Connection Plate. The weld joint identified as ED1-SA4-68-135M-7-1B, ED1-SA4-68-135M-8-1B and ND1-SA4-68-135M-1-1B. The welder is identified as 042195. In process SAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-3221-Tc-U5-S-1. It was observed that the parameters noted down by ZPMC QC are in compliance with WPS, for more comprehensive information refer the attached pictures.

BAY 10:-
SOUTH TOWER LIFT 4:-

This QA Inspector observed ZPMC welding personnel performing welding by Shielded Metal Arc Welding (SMAW) for AE Diaphragm and Skin E. The weld joint was identified as SSSL4-1G/L-PP. The welders were identified as 052930 and 056364. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-345+485-SMAW-2G (2F)-Repair-2. It was observed that the parameters noted down by ZPMC QC are in compliance with WPS.

BAY 10:-
NORTH TOWER LIFT 4:-

This QA Inspector observed ZPMC welding personnel performing welding by Shielded Metal Arc Welding (SMAW). The weld joint was identified as NSTL4-3B/L-1B. The welder is identified as 066236. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-345-SMAW-1G(1F)-Repair. It was observed that the parameters noted down by ZPMC QC are in compliance with WPS.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Unless otherwise noted, all work observed on this date 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 Skyler Guest - 1500-0422-360, who represents the Office of Structural Materials for your project.

Inspected By:	Math,Manjunath	Quality Assurance Inspector
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Reviewed By:	Miller,Mark	QA Reviewer
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