

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-008086**Date Inspected:** 07-Jul-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 COMPONENTS**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Gady Rao, was present during the times noted above for observations relative to the work being performed.

Magnetic Particle Testing:

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) & the weld designations reviewed are as follows:

Bay 2

Inspection part

Section

Inspection Area.

SEG2F-023 (As per Notification 003624)

OBG 1AAE

Bay-2

Bay 10

SAW – Strut connection plates.

SAW welding of weld joint ED1-A6001-1-1A; ED1-A6001-2-1A; ED1-A6001-3-1A; ED1-A6001-4-1A; ED1-A6001-5-1A located on East Tower. Welder is identified as 052917. ZPMC QCI is identified as Yu Zhi Lai.

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The welding variables recorded by QC appeared to comply with the WPS- B-T-4221-B-U3C-S-1.

FCAW–South Tower Lift-3

1)FCAW welding of weld joint SSSL3-11/K – 40/45 &132/135 located on South Tower; Lift-3. Welding of fit-lugs in progress on Skin-A. Welder is identified as 052075/201825. ZPMC QCI is identified as Li Ming. The welding variables recorded by QC appeared to comply with the WPS-B-T-4333-TC-P4-F.

FCAW–North Tower Lift-3

2)FCAW welding of weld joint NSTL3-3I/K – 158/168 located on North Tower; Lift-3; 109M elevation; welding of Diaphragm to Skin-D. Welder is identified as 054069/053116. ZPMC QCI-CWI is identified as Wan Wen Zhong. The welding variables recorded by QC appeared to comply with the WPS- B-T-4333-TC-P4-F.

Bay 11

SAW

SAW welding of weld joint WSD1-FDSA4-4D/D-32A located on West Tower; Lift-4; Skin-D; welding of Stiffener to Stiffener welding. Welder is identified as 044560. ZPMC QCI is identified as Zhang Zhi Neng. The welding variables recorded by QC appeared to comply with the WPS- B-T-2221-B-U3C-S-2.

FCAW –West Tower Lift-2

FCAW welding of weld joint WSD1-TL6-J/L -55/56 located on West Shaft; Lift-2. Welding of Diagonal plate to Skin-B is in progress. Welder is identified as 066439/068494/066683. ZPMC QCI-CWI is identified as Zhang Zhi Neng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P4-F.

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

Inspected By:	Rao,Gady	Quality Assurance Inspector
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Reviewed By:	Clifford,William	QA Reviewer
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