

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-008163**Date Inspected:** 07-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu yang.**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, Amit K. Juvekar, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Bay10, Lift 4, Skin D, North Tower.

FCAW welding of weld joint NSD1-FDSA4-3D/D-33, 34, 19, 20; located on Bay10, Lift 4, Skin D, North Tower. Welder is identified as 067036, 067037, 066328, 06713; ZPMC Quality Control Inspector (QC) is identified as Liu yang. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2332-TC-P5-F.

Bay10, Lift 4, Skin A, North Tower.

SMAW & FCAW welding of weld joint NSD1-FASA4-1E/E-33B, 60B, 14B, 43B, 34B; located on Bay10, Lift 4, Skin A, North Tower. Welder is identified as 056200(SMAW), 048784, 058629, 040345, 040533; ZPMC Quality Control Inspector (QC) is identified as Chen Ying Xin. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: 1)WPS-B-T-3211-TC-U5B-1 (SMAW), 2)WPS-B-T-2231-TC-U5-F-1..

Outside Yard, Lift 1 & 2, Skin A, East Tower.

ZPMC Started Drilling Holes on Skin A for bolting. Hole size Informed by ZPMC Quality Control Inspector (QC) is 30mm Dia.

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This QA Inspector carried out NDE on following:

Bay 10, North Tower, Lift 1, A/E Corner Seam.

This QA inspector performs Random Ultrasonic Testing (UT) of approximately 10% area previously tested and accepted by ZPMC Quality Control personnel, FOR GREEN TAG. This QA Inspector generated an UT report (TL-6027) for this date. The members are identified as

- 1) NSD1-A166C/J-257A/B. A/E Corner Seam 13M to 47.6M.
- 2) NSD1-A166E/J-73A/B. A/E Corner Seam 13M to 47.6M

Bay 10, North Tower, Lift 1.

This QA inspector performs Random Visual Testing (VT), Magnetic Particle Testing (MT) of approximately 10% area previously tested and accepted by ZPMC Quality Control personnel, FOR GREEN TAG. This QA Inspector generated an MT report (TL-6028) for this date. The members are identified as

- 1) NSD1-SA20-112 TO 117, 111, 119, 124, 116. Perimeter Channel of 9M Diaphragm.
- 2) NSD1-SA126-117 TO 122. Perimeter Channel of 9M Diaphragm.
- 3) NSD1-SA33D/F-38 TO 42, 27 TO 37. Angle Steel of 9M Diaphragm.
- 4) NSD1-SA11D/F-3 to 11. Angle Steel of 9M Diaphragm.
- 5) NSD1-SA11E/F-14 TO 21, 26. Angle Steel of 9M Diaphragm.
- 6) NSD1-SA17F/G-129 TO 141. Angle Steel of 9M Diaphragm.
- 7) NSD1-SA17G/G-41 TO 53. Angle Steel of 9M Diaphragm.
- 8) NSD1-SA22C/E-16 TO 19, 22, 6 TO 12, 3, 13 TO 15. Angle Steel of 9M Diaphragm.
- 9) NSD1-SA76F/H-81 TO 94. Angle Steel of 9M Diaphragm.
- 10) NSD1-SA76A/H-22 TO 35. Angle Steel of 9M Diaphragm.
- 11) NSD1-SA17F/G-119, 156, 120 TO 126, 157 TO 163. Bracing Plate of Skin C Stiffener near 9M Diaphragm.
- 12) NSD1-SA17G/G-5 to 36. Bracing Plate of Skin C Stiffener near 9M Diaphragm.
- 13) NSD1-SA22B/E-60, 61, 64, 65, 68 TO 73, 78 TO 81, 86, 87, 90 TO 93, 96, 97, 100 TO 105. Bracing Plate of Skin D Stiffener near 9M Diaphragm.

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, 13482570045, who represents the Office of Structural Materials for your project.

Inspected By:	Juvekar,Amit	Quality Assurance Inspector
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Reviewed By:	Clifford,William	QA Reviewer
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