

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-009082**Date Inspected:** 11-Sep-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:** Ma Yun.**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, North Tower, Struts.

SMAW welding of weld joint ND1-A6002-17-7A located on Bay10, North Tower. Welder is identified as 050289; ZPMC Quality Control Inspector (QC) is identified as Ma Yun. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-3212-TC-U5B-1.

Bay11, East Tower, Lift 3, C/D Corner Diagonal Plate.

FCAW welding of weld joint ESTL3-4B/K-78, 77 located on Bay11, East Tower, Lift 3. Welder is identified as 040759, 058792, 202821, 69043, 07550; ZPMC Quality Control Inspector (QC) is identified as Liu Xiao Zhong. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2332-TC-F.

Assembly Area (Heavy Dock), South Shaft, Lift 1.

Preparing for installation of Internal Splice Plate on Skin C.

Assembly Area (Heavy Dock), East Shaft, Lift 2.

Drilling holes on Doubler Plate between Double Diaphragm on Skin E & A.

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Assembly Area (Heavy Dock), East Shaft, Lift 2.

Preparing for installation of Internal Splice Plate on Skin C.

Drilling holes on Doubler Plate between Double Diaphragm on Skin E

This QA Inspector carried out NDE on following:

Bay 11, Tower Struts.

This QA inspector performs Random Visual Testing (VT), Magnetic Particle Testing (MT) of 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) WD1-A467-18M-2.

2) WD1-A467-38M-1.

GREEN TAG # 1)6724R1

2)6732R1

These Struts have been Rejected on date 09-06-09. QA Inspector found "Transverse linear indication" on the weld Identified as WD1-A467-38-1-88. But notification provided by ZPMC did not mentioned this; however QA Inspector checked for the Transverse Indications found in earlier Inspection & Foud welds satisfactory.

Bay 11, East Tower, Lift 3, Triangular Plate with Diagonal Stiffener of CD Corner.

This QA inspector performs Random Visual Testing (VT), Magnetic Particle Testing (MT) of 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 ESTL3-4-D/K-1,2.

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

Reviewed By: Clifford,William

QA Reviewer