

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-009086**Date Inspected:** 17-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1745**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

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|------------------------------------|--------------------------------|-----------|------------|----------------------------------|------------------|-----------|------------|
| CWI Name: | Chen Ying Xing, Lin Xiaozhong. | | | 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:

Bay11, East Tower, Struts.

SMAW welding of weld joint ED1-A6003-4-30A located on Bay11, East Tower. Welder is identified as 037779, 070432; ZPMC Quality Control Inspector (QC) is identified as Chen Ying Xing. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-4113-1.

Bay11, West Tower, Internal Splice Plate.

FCAW Repair welding of weld joint WSD1-SPSA3-3-3A/B (WRR # T-WR2176) located on Bay11, West Tower. Welder is identified as 048810; ZPMC Quality Control Inspector (QC) is identified as Lin Xiaozhong. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-345-FCAW-2G(2F)-REPAIR.

Bay10, North Tower, Lift 3, CD Corner Diagonal Plate.

FCAW welding of weld joint NSTL3-3K/K-47 located on Bay10, West Tower. Welder is identified as 048784; ZPMC Quality Control Inspector (QC) is identified as li Ming. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2233-B1-U2A-F.

This QA Inspector carried out NDE on following:

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Bay 11, West Tower, Lift 4, Skin A.

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)WSD1-FASA4-2C/E-16, 17.

2)WSD1-FASA4-2B/E-15.

GREEN TAG # 10427.

This QA inspector Observed linear Indications at weld WSD1-FASA4-2C/E-16. This QA inspector also submitted Incident Report on this issue. ZPMC have repaired that area on the same date. This QA inspector checked the same area for the Indications found earlier; weld found in compliance.

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.

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