

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-011156**Date Inspected:** 24-Dec-2009**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:** Mr. Chen Ying Xin**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**Summary of Items Observed:**

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

Ultrasonic Testing:-**BAY # 10:-**

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an UT report for this date. The member is identified as Strut Plate. The weld designations reviewed are as follows:

ND1-A6002-13-7A/B, 8A/B, 11A/B, 12A/B.

ND1-A6002-14-9A/B, 10A/B, 11A/B, 12A/B

Visual Testing:-**BAY # 10:-**

This QA inspector performed random Visual Testing of area previously tested and accepted by ZPMC Quality Control Personnel. The members are identified as Lift 5 Skin Plates.

SSD1-TL5-1C-F-9A/B Green Tag#11563

SSD1-TL5-1E-F-13A/B Green Tag#11564

SSD1-TL5-1C-F-7A/B Green Tag#11565

NSD1-TL5-3C-F-8A/B Green Tag#11561

NSD1-TL5-3C-F-7A/B Green Tag#11562

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IN PROCESS INSPECTION:-

BAY #10:-

This QA inspector observed the following work in progress:

SMAW Welding of weld joint no:-ND1-BPSA5-2-1-3 located on Transverse Diaphragm Beam. Welder is identified as 050038. ZPMC CWI is identified as Mr.Gang Liang Zhu. The welding variables recorded by QC appeared to comply with the WPS-B-T-3312-TC-P5.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no:-ND1-SA3-16-89M-1-1A/B located on Connecting Angle Plate. Welder is identified as 040582. ZPMC CWI is identified as Mr.Chen Ying Xin. Welding was been performed against Critical Weld Repair Report T-CWR494 and UT report number: - T787-UT-2464R2.The welding variables recorded by QC appeared to comply with the WPS-485-SMAW-2G(2F)-FCM-Repair-1.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no:-ED1-SA3-18-99M-7-1A/B located on Connecting Angle Plate. Welder is identified as 053050. ZPMC CWI is identified as Mr.Chen Ying Xin. Welding was been performed against Critical Weld Repair Report T-CWR493 and UT report number: - T787-UT-2469R2.The welding variables recorded by QC appeared to comply with the WPS-485-SMAW-2G(2F)-FCM-Repair-1.

BAY #11:-

This QA inspector observed the following work in progress:

FCAW welding of weld joint no: ESD1-SPSA4-3-3A located on Interior Splice Plate. Welder is identified as 040775.ZPMC QC is identified as Mr.Li Jun. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-TC-U5-F.

This QA inspector observed the following work in progress:

SAW welding of weld joint no: WSTL4-2-B/L-60A located on "AE" Corner Seam. Welder is identified as 202756. ZPMC CWI is identified as Mr. Yu Liang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-C-U2b-S-2.

Unless otherwise noted, all work observed on this date appeared to generally comply with the applicable contract documents.

Summary of Conversations:

No Relevant Conversation.

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:	Pillai,Pandaram	Quality Assurance Inspector
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Reviewed By:	Clifford,William	QA Reviewer
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