

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-012054**Date Inspected:** 23-Jan-2010**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:	Yu Dong Ping, Liu Zhong An	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 day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This Quality Assurance (QA) Inspector observed the following work in progress:

Bay 11

EAST TOWER LIFT 4 A/E CORNER BACKFILL PLATE

SMAW welding of weld joint 105 located on ESTL4-2K/L.

Welder is identified as 040690. ZPMC CWI is identified as Mr. Peng Guo.

The welding variables recorded by QC appeared to comply with WPS-B-T-3213-B-U2a-1.

SMAW welding of weld joint 70 located on ESTL4-2J/L.

Welder is identified as 040656. ZPMC QC is identified as Mr. Xu Jin Long.

The welding variables recorded by QC appeared to comply with WPS-B-T-3213-B-U2a-1.

WEST TOWER LIFT 4 A/E CORNER SEAM REPAIR

FCAW welding of weld joint 60A/B(Repair) located on WSTL4-2B/L.

Welder is identified as 040759. ZPMC CWI is identified as Mr. Li Lin.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

The welding variables recorded by QC appeared to comply with WPS-345-FCAW-2G(2F)-REPAIR.

EAST TOWER LIFT 5 A/E CORNER SEAM

SMAW welding of weld joint 36A located on ESD1-TL5-2B/F.

Welder is identified as 040611. ZPMC QC is identified as Mr. Li Jun.

The welding variables recorded by QC appeared to comply with WPS-B-T-3211-Tc-U5b-1.

STRUT WEB PLATE

SAW welding of weld joint 3A located on ED1-STSA4-6-139M-2.

Welder is identified as 040699. ZPMC CWI is identified as Yu Dong Ping.

The welding variables recorded by QC appeared to comply with WPS-B-T-4211-B-U3c-S-1.

STRUT WEB PLATE REPAIR

SMAW welding of weld joint 8A/B(Repair) located on ED1-STSA4-6-131M-1.

Welder is identified as 040733. ZPMC QC is identified as Mr. Liu Dao Feng.

The welding variables recorded by QC appeared to comply with WPS-345+485-SMAW-1G(1F)-FCM-REPAIR-1.

BAY 10

NORTH TOWER LIFT 2 PADEYE ON SKIN B

SMAW welding of weld joint 31 located on NSD1-SA163A/D.

Welder is identified as 067656. ZPMC QC is identified as Mr. Yuan Hui Gang.

The welding variables recorded by QC appeared to comply with WPS-B-P-2114-PADEYE.

SOUTH TOWER LIFT 4 A/E CORNER BACKFILL PLATE

SMAW welding of weld joint 31 located on SSSL4-1K/L.

Welder is identified as 050289. ZPMC QC is identified as Mr. Sun Tian Liang.

The welding variables recorded by QC appeared to comply with WPS-B-T-3213-B-U2a-1.

FCAW welding of weld joint 30 located on SSSL4-1I/L.

Welder is identified as 066683. ZPMC QC is identified as Mr. Sun Tian Liang.

The welding variables recorded by QC appeared to comply with WPS-B-T-4333-Tc-P4-F.

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

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

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 Skyler Guest : 15000422360, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By:	Gaikwad,Umesh	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer