DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-011906
Date Inspected: 03-Feb-2010

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 645
OSM Departure Time: 1845
Location: Shanghai, China

CWI Name: You Qi Guo.

Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**CWI Present:**	☑ Yes	☐ No	
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☑ 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:

Heavy Dock(Tower Assembly), South Tower, Lift 1, Skin C, Bearing Stiffener(Inside Tower).
FCAW welding of Partial Penetration weld joint (PJP) SSD1-SA17F/G-27, 11; located on Heavy Dock(Tower Assembly), South Tower, Lift 1, Skin C. Welders are identified as 054069, 050041; ZPMC Quality Control Inspector (QC) is identified as You Qi Guo. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2333-TC-P4-F.

Heavy Dock(Tower Assembly), South Tower, Lift 1, Skin B, Bearing Stiffener(Inside Tower).
FCAW welding of Partial Penetration weld joint (PJP) SSD1-SA18-11; located on Heavy Dock(Tower Assembly), South Tower, Lift 1, Skin B. Welders are identified as 201825; ZPMC Quality Control Inspector (QC) is identified as You Qi Guo. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2333-TC-P4-F.

Heavy Dock(Tower Assembly), South Tower, Lift 1, Skin E, Bearing Stiffener(Inside Tower).
FCAW welding of Partial Penetration weld joint (PJP) SSD1-SA16F/G-15, 26; located on Heavy Dock(Tower Assembly), South Tower, Lift 1, Skin E. Welders are identified as 052075, 066733; ZPMC Quality Control Inspector (QC) is identified as You Qi Guo. The welding variables recorded by Quality Control Inspector (QC)

appeared to comply with the Applicable WPS: WPS-B-T-2333-TC-P4-F.

Heavy Dock(Tower Assembly), South Tower, Lift 1, Skin A, Bearing Stiffener(Outside Tower).

SMAW Repair welding of Partial Penetration weld joint (PJP) SSD1-SA15D/F-14 (CWR # T-CWR560); located on Heavy Dock(Tower Assembly), South Tower, Lift 1, Skin A. Welders are identified as 050038; ZPMC Quality Control Inspector (QC) is identified as You Qi Guo. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-345-SMAW-3G(3F)-REPAIR.

The attached photographs provide additional detail.

This QA Inspector carried out NDE on following

Heavy Dock(Tower Assembly), West Tower, Lift 1, Skin C, Interior Bearing Plate.

This QA inspector performs Random Visual Testing (VT), Magnetic Particle Testing (MT)of approximately 15%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 WSD1-SA294F/G-2, 4, 6, 8, 10, 12, 14, 16, 18, 20, 22, 24, 26.

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