

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-011949**Date Inspected:** 05-Feb-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:	Mr. You Qi Guo, Zhao Chen Sun	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.

Magnetic Particle Testing:-

BAY #10:-

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an MT report for this date. The member is identified as Tower Strut Plate. The weld designations reviewed are as follows:-

ND1-STSA3-1-109M-1-9A,10B,11A,12B,15,23,25A,26B,33,39,46

IN PROCESS INSPECTION:-

TOWER TRAIL ASSEMBLY AREA:-

SOUTH SHAFT LIFT 1:-

This QA inspector observed the following work in progress:

FCAW welding of weld joint no: SSD1-SA18-5 located on Skin B Bearing Plate. Welder is identified as 068047. ZPMC QC is identified as Mr. Sun Zi Wang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

This QA inspector observed the following work in progress:

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FCAW welding of weld joint no: SSD1-SA16F/G-24 located on Skin E Bearing Plate. Welder is identified as 066733.ZPMC QC is identified as Mr. Sun Zi Wang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

NORTH SHAFT LIFT 1:-

This QA inspector observed the following work in progress:

ZPMC performed Base metal repair of Bearing Plate located on Skin C (NSD1-SA17 -14, 16). The base metal repair areas were approximately 3mm depth and 50mm length at 2 random locations. The material is A 709M Grade 345 Non-SPCM. Welder is identified as 053829.ZPMC CWI is identified as Mr. Zhao Chen Sun. Welding was been performed against welding repair report T-WR3044. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-3G(3F)-Repair.

WEST SHAFT LIFT 1:-

This QA inspector observed the following work in progress:

ZPMC performed Base metal repair of Bearing Plate located on Skin E (WSD1-SA225F/G -2). The base metal repair area is approximately 4mm depth and 120mm length. The material is A 709M Grade 345 Non-SPCM. Welder is identified as 066674.ZPMC CWI is identified as Mr. You Qi Guo. Welding was been performed against Critical Weld Repair report T-CWR572 and MT report number- T787-MT-7952. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-3G(3F)-Repair.

This QA inspector observed the following work in progress:

ZPMC performed Base metal repair of Bearing Plate located on Skin E (WSD1-SA225F/G -2). The base metal repair area is approximately 3mm depth and 45mm length. The material is A 709M Grade 345 Non-SPCM. Welder is identified as 066674.ZPMC CWI is identified as Mr. You Qi Guo. Welding was been performed against Critical Weld Repair report T-CWR573 and MT report number- T787-MT-7952. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-3G(3F)-Repair.

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



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

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