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-012566
Date Inspected: 18-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:	Yu Qi Guo			**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 Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

Tower Trial Assembly

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW):
Weld joint # 017 located on South Tower Lift-1 Bearing stiffener Plate SSD1 – SA18. Welder is identified as 068047. ZPMC Quality Control (QC) Inspector is identified as Gong Liang Zhu. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2333 – Tc – P4 – F.

Weld joint # 007 located on East Tower Lift-1 Bearing stiffener Plate ESD1 – SA233. Welder is identified as 066674. ZPMC Quality Control (QC) Inspector is identified as Yuan Hui Gang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2333 – Tc – P4 – F.
(See attached photo)

Weld joint # 020 located on South Tower Lift-1 Bearing stiffener Plate SSD1 – SA16. Welder is identified as 053116. ZPMC Quality Control (QC) Inspector is identified as Gong Liang Zhu. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2333 – Tc – P4 – F.

(See attached photo)

BAY 10

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW):
Repair welding of a weld joint # 5B located on North Tower Lift-4 B/C corner NSTL4-3B/C. Welder is identified as 057258. ZPMC Quality Control (QC) Inspector is identified as Du Zhi Quin. The welding variables recorded by QC appeared to comply with the WPS – 345 – SMAW – 2G (2F) – Repair.

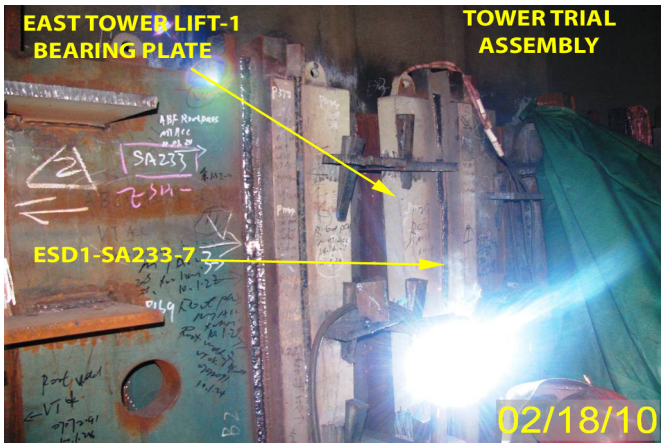
Repair welding of a weld joint # 1B located on North Tower Lift-4 C/D corner NSTL4-3B/C. Welder is identified as 066733. ZPMC Quality Control (QC) Inspector is identified as Du Zhi Quin. The welding variables recorded by QC appeared to comply with the WPS – 345 – SMAW – 1G (1F) – Repair.

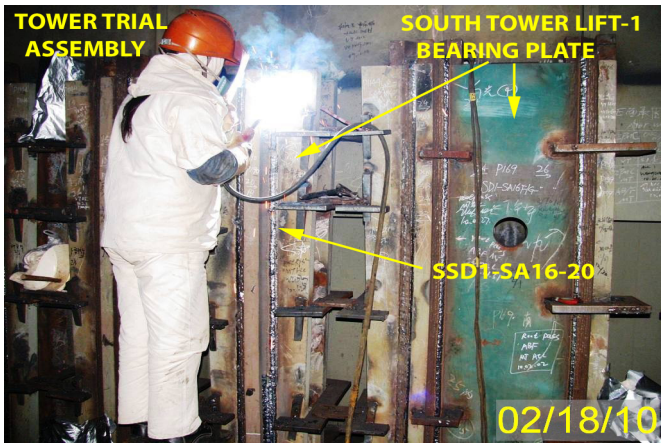
BAY 11

This QA Inspector observed the following work in progress:

Sub-Merged Arc Welding (SAW):
Weld joint # 6-1B located on Strut Splice Plate ED1 – SA4 – 68 – 139M. Welder is identified as 041716. ZPMC Quality Control (QC) Inspector is identified as Mao Bin Bin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3221 – Tc – U5 – S – 1.

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





Summary of Conversations:
No Relevant Conversations.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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 Eric Tsang - 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Sandeep	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer