

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-014148**Date Inspected:** 09-May-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. Qiu Wen**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:-

TOWER TRAIL ASSEMBLY AREA:-

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 North Tower Skin D Elevator Connection Plate. The weld designations reviewed are as follows:

NSD1-A112E/H-251,252

IN PROCESS INSPECTION:-

TOWER TRAIL ASSEMBLY AREA:-

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: P475-W-3 located on Doubler Strut Plate. Welders are identified as 040724.

ZPMC QC is identified as Mr. Li Jun. The welding variables recorded by QC appeared to comply with the WPS-B-T-4213-TC-U4c.

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This QA inspector observed the following work in progress:

SMAW welding of weld joint no: ND1-STSA4-6-127M-1-5B located on Strut Plate. Welder is identified as 041271.ZPMC QC is identified as Mr.Mao Bin Bin. The welding variables recorded by QC appeared to comply with the WPS-B-T-3212-TC-U5b-1.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: ED1-STSA4-10-119M-2-10B located on Strut Plate. Welder is identified as 044551.ZPMC QC is identified as Mr.Mao Bin Bin. The welding variables recorded by QC appeared to comply with the WPS-B-T-2212-TC-U5b.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: ED1-STSA4-10-119M-2-36A located on Strut Plate. Welder is identified as 044551.ZPMC QC is identified as Mr.Mao Bin Bin. The welding variables recorded by QC appeared to comply with the WPS-B-T-3212-TC-U5b-1.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: ND1-STSA4-6-135M-1-19 located on Strut Plate. Welder is identified as 251194.ZPMC QC is identified as Mr.Liu Dao Feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2113.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: ED1-STSA4-6-123M-1-84 located on Strut Plate. Welder is identified as 046769.ZPMC QC is identified as Mr. Liu Dao Feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-4113-1.

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



Summary of Conversations:

No Relevant Conversation.

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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
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Reviewed By:	Clifford,William	QA Reviewer
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