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-014426
Date Inspected: 23-May-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: 700
OSM Departure Time: 1600
Location: Shanghai, China

CWI Name:	Yu Dong Ping	**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.

BAY#10

This QA Inspector observed the following work in progress:
Flux cored Arc Welding (FCAW):
Weld joint # 59 located on Bearing Stiffener of Shear plate WD1 – A28A/B. Welder is identified as 053869. ZPMC Quality Control (QC) Inspector is identified as You Qi Guo. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2331 – Tc – P4 – F.

Weld joint # 73 located on Bearing Stiffener of Shear plate WD1 – A28A/B. Welder is identified as 040533. ZPMC Quality Control (QC) Inspector is identified as You Qi Guo. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2331 – Tc – P4 – F.
(See attached photo)

Weld joint # 62 located on Bearing Stiffener of Shear plate WD1 – A28A/B. Welder is identified as 057266. ZPMC Quality Control (QC) Inspector is identified as You Qi Guo. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2331 – Tc – P4 – F.

BAY#11

This QA Inspector observed the following work in progress
Shielded Metal Arc Welding (SMAW):
Weld joint # 5A located on Tower Strut ND1 – STSA4 – 6 – 143M – 1. Welder is identified as 046704. ZPMC Quality Control (QC) Inspector is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3212 – Tc – U5b – 1.

Weld joint # 13 located on Tower Strut ND1 – STSA4 – 6– 139M – 2. Welder is identified as 040614. ZPMC Quality Control (QC) Inspector is identified as Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2212 – Tc – U5b.

Weld joint # 48B located on Tower Strut SD1 – STSA4 – 5– 119M – 1. Welder is identified as 040690. ZPMC Quality Control (QC) Inspector is identified as Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3212 – Tc – U5b – 1. (See attached photo)

Submerged Arc Welding (SAW):
Weld joint # 6B located on Grillage Top Plate GTSA5 – B/G. Welder is identified as 044550. ZPMC Quality Control (QC) Inspector is identified as Shang Hai Long. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2221 – B – U3c – S – 2. (See attached photo)

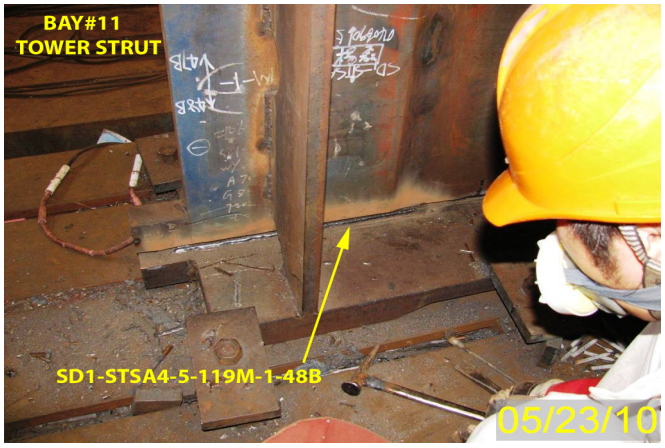
Weld joint # 3B located on Grillage Top Plate GTSA5 – B/G. Welder is identified as 042195. ZPMC Quality Control (QC) Inspector is identified as Shang Hai Long. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2221 – B – U3c – S – 2.

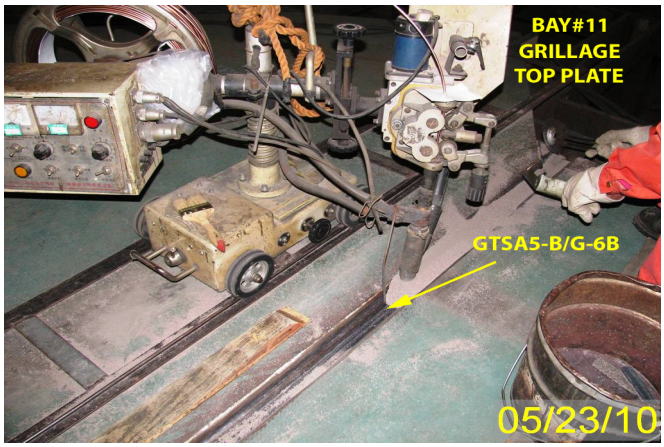
Weld build-up by Shielded Metal Arc Welding (SMAW):
According to the Critical Weld Repair report T-CWR 626 weld build-up being performed onTower Strut Plate ND1 – A468 – 23M – 1. Welder is identified as 202100. ZPMC Quality Control (QC) Inspector is identified as Shang Hai Long. The welding variables recorded by QC appeared to comply with the WPS – 485 – SMAW – 1G (1F) – Repair – 1.

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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)





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

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