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

Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-014734
Date Inspected: 05-Jun-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: 1900
Location: Shanghai,China

CWI Name: Mr.An Qing Xiang/Ye yang jun

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:-
Trail Assembly Area:-
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 Cross Bracing Gusset Plate. The weld designations reviewed are as follows:-

WD1-GUSA3-3-53M-E-3,4A/B
WD1-GUSA3-3-53M-W-3,4A/B

IN PROCESS INSPECTION:-
Trail Assembly Area:-

This QA inspector observed the following work in progress:
SMAW welding of weld joint no: SSD1-SA164B/F-9,12 located on Doubler strut plate at 53M elevation. Welder is identified as 040690. ZPMC QC is identified as Mr.Zhu Feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-3212-B-U2a-2.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: NSD1-SA166B/F-9,12 located on Doubler strut plate at 53M elevation. Welder is identified as 052930. ZPMC QC is identified as Mr.Zhu Feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-3212-B-U2a-2.

Bay#10:-

This QA inspector observed the following work in progress:
SMAW welding of weld joint no: SSD1-SPSA5-16-3B located on Lift 5 Interior Splice Plate. Welder is identified as 050289.ZPMC QC is identified as Mr. Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS-B-T-3211-TC-U5b-1.

This QA inspector observed the following work in progress:
SMAW welding of weld joint no: SSD1-SPSA5-19-1A located on Lift 5 Interior Splice Plate. Welder is identified as 052930.ZPMC QC is identified as Mr. Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS-B-T-3211-TC-U5b-1.

Bay#11:-

This QA inspector observed the following work in progress:
SMAW welding of weld joint no: ESD1-SPSA5-7-3A located on Lift 5 Interior Splice Plate. Welder is identified as 041271.ZPMC QC is identified as Mr. Xu Jin long. The welding variables recorded by QC appeared to comply with the WPS-B-T-3211-TC-U5b-1.

This QA inspector observed the following work in progress:
SMAW welding of weld joint no: ED1-STSA4-6-143M-1-47 located on Strut Plate. Welder is identified as 040655.ZPMC QC is identified as Mr. Mao bin bin. The welding variables recorded by QC appeared to comply with the WPS-B-T-2112.

This QA inspector observed the following work in progress:
SMAW welding of weld joint no: ED1-STSA4-10-119M-1-54 located on Strut Plate. Welder is identified as 046769.ZPMC QC is identified as Mr. Mao bin bin. The welding variables recorded by QC appeared to comply with the WPS-B-T-4113-1.

This QA inspector observed the following work in progress:
SMAW welding of weld joint no: ND1-STSA4-6-139M-2-43 located on Strut Plate. Welder is identified as 040611.ZPMC QC is identified as Mr. Mao bin bin. The welding variables recorded by QC appeared to comply with the WPS-B-T-2112.

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

WELDING INSPECTION REPORT

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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