

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-014939**Date Inspected:** 14-Jun-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:** 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 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 JETTY

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint # 11 located on North tower Lift-2 cross bracing connection plate to doubler strut plate NSD1 – SA116C/F. Welder is identified as 040582. ZPMC Quality Control (QC) Inspector is identified Qiu Wen. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3212 – B – U2a – 1. (See attached photo)

Weld joint # 12 located on South tower Lift-2 cross bracing connection plate to doubler strut plate SSD1 – SA164C/F. Welder is identified as 040365. ZPMC Quality Control (QC) Inspector is identified Qiu Wen. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3212 – B – U2a – 1.

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This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint # 2B located on Lift-5 Splice Plate Stiffener SSD1 – SPSA5 – 6. Welder is identified as 050266.

ZPMC Quality Control (QC) Inspector is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3211 – Tc – U5b – 1.

Weld joint # 1B located on Lift-5 Splice Plate Stiffener NSD1 – SPSA5 – 16. Welder is identified as 057258.

ZPMC Quality Control (QC) Inspector is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3211 – Tc – U5b – 1.

Weld joint # 41A located on Lift – 5 north tower A/E corner to Grillage plate NSD1 – TL5 – 4B/F. Welder is identified as 052493. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3213 – B – U3b.

(See attached photo)

Weld joint # 1B located on Lift-5 Splice Plate Stiffener NSD1 – SPSA5 – 19. Welder is identified as 050289.

ZPMC Quality Control (QC) Inspector is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3211 – Tc – U5b – 1.

Weld joint # 24B located on Lift – 5 north tower A/E corner to Grillage plate NSD1 – TL5 – 4B/F. Welder is identified as 052930. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3213 – B – U3b.

MEASUREMENTS ON TOWER STRUTS

This QA Inspector carried out the measurements on Tower Struts to check the length, flange to flange distance, stiffener to stiffener distance and 1:1 fillet weld termination & 10mm minimum clearance from fillet to CJP at stiffeners. Measurements were recorded on the data sheet and submitted to the assigned task leader. The identified component designations reviewed are as follows

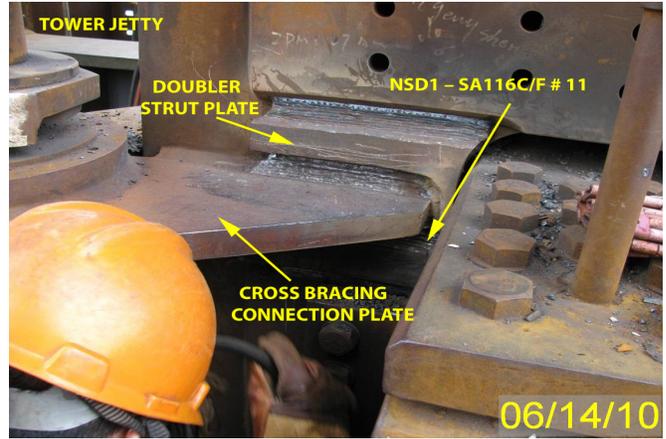
TOWER STRUTS

1. ED1 – A6003 – 8
2. WD1 – A6001 – 6
3. ND1 – A6002 – 3
4. SD1 – A6002 – 18
5. WD1 – A6003 – 3
6. WD1 – A6003 – 5
7. WD1 – A6001 – 1

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

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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 Michael Ng - 15921845703, who represents the Office of Structural Materials for your project.

Inspected By: Kumar,Sandeep

Quality Assurance Inspector

Reviewed By: Clifford,William

QA Reviewer