

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-016517**Date Inspected:** 26-Aug-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:** Xu Le Feng**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 & OBG 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

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 006485

Magnetic Particle Testing (MT)

This QA inspector performed MT 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 Component. The weld designation/Location reviewed as follows:

REPAIR POINTS AFTER BLASTING (INTERNAL)

NSD1 – TL5H/L – 132; 134

2 points Inside the 77 M double diaphragm

Skin 'E' – 3rd Stiffener at 69 M elevation

NSD1 – TL8F/L - 75

Internal flange facing skin 'D'

This QA Inspector observed the following work in progress

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Shielded Metal Arc Welding (SMAW):

Weld joint # 4B located on West tower Lift-3 cross bracing gusset plate WD – GUSA3 – 3 – 89M – N. Welder is identified as 040365. ZPMC Quality Control (QC) Inspector is identified Zhao Chen Sun. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2214 – Tc – U5b – FCM.

Weld joint # 3A located on West tower Lift-3 cross bracing gusset plate WD – GUSA3 – 3 – 109M – W. Welder is identified as 040690. ZPMC Quality Control (QC) Inspector is identified Zhao Chen Sun. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2212 – Tc – U5b – FCM.

(See attached photo)

Weld joint # 4B located on West tower Lift-3 cross bracing gusset plate WD – GUSA3 – 3 – 89M – S. Welder is identified as 052910. ZPMC Quality Control (QC) Inspector is identified Zhao Chen Sun. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2214 – Tc – U5b – FCM.

Weld joint # 4A located on West tower Lift-3 cross bracing gusset plate WD – GUSA3 – 3 – 109M – W. Welder is identified as 040690. ZPMC Quality Control (QC) Inspector is identified Zhao Chen Sun. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2212 – Tc – U5b – FCM.

BAY#10

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint # 18 located on South tower Lift-5 Grillage Assembly SSD1 – TL5 – 1B/F. Welder is identified as 052493. 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 – 3213 – TC – U4c.

ORTHOTROPIC BOX GIRDER (OBG) AT BAY#10

This QA Inspector observed the following work in progress

Fluxcored Arc Welding (FCAW):

Weld joint # 95 located on Bike Path BK004A6 – 033. Welder is identified as 040759. ZPMC Quality Control (QC) Inspector is identified as Sun Tian Liang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2131.

BAY#11

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

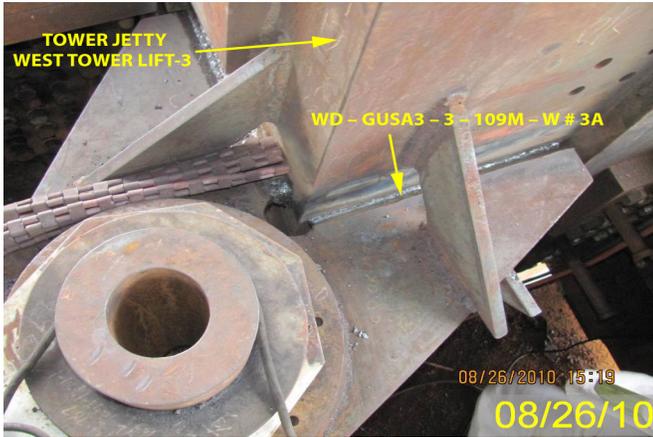
Weld joint # 17 located on East tower Lift-5 Grillage Assembly ESD1 – TL5 – 2B/F. Welder is identified as 040667. ZPMC Quality Control (QC) Inspector is identified as Xu Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3213 – TC – U4c.

Weld joint # 03 located on West tower Lift-5 Grillage Assembly WSD1 – TL5 – 4B/F. Welder is identified as 066471. ZPMC Quality Control (QC) Inspector is identified as Xu Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3213 – TC – U4c.

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



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
