

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:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017394**Date Inspected:** 16-Sep-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. Xu le feng
Inspected CWI report: Yes No N/A
Electrode to specification: Yes No N/A
Qualified Welders: Yes No N/A
Approved Drawings: Yes No N/A

CWI Present: Yes No
Rod Oven in Use: Yes No N/A
Weld Procedures Followed: Yes No N/A
Verified Joint Fit-up: 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.

In process Inspection

Bay #11

This QA Inspector observed the following work in progress:

SMAW in the 3G position for the Tower Lift 5 Bracket Plate to Stiffener, weld No: ND1-BRSA5-2-13A. The welder is identified as #054469. ZPMC QC is identified as Mr. Zhao mao mao. The welding variables recorded by QC appear to comply with WPS-B-T-3213-TC-U4b. Please see the attached pictures.

This QA Inspector observed the following work in progress:

SMAW in the 3G position for the Tower Lift 5 Bracket Plate to Stiffener, weld No: ND1-BRSA5-2-9B. The welder is identified as #044541. ZPMC QC is identified as Mr. Zhao mao mao. The welding variables recorded by QC appear to comply with WPS-B-T-3213-TC-U4b. Please see the attached pictures.

Bay #10

FCAW in the 2F position for the OBG Segment 14 Bottom Plate, weld No: BP3094-001-170/171. The welders are identified as #052075/057180. ZPMC QC is identified as Mr. Deng zhi bing. The welding variables recorded by

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QC appear to comply with WPS-B-T-2132-3. Please see the attached pictures.

This QA inspector observed the following work in progress:

SMAW welding of weld joint No: BK004A1-027-009 located on Bike Path 027. Welder is identified as #500363. ZPMC QC is identified as Mr. Li Jun. Welding was performed with the temporary weld repair report. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G(4F)-Repair.

FCAW in the 2F position for the Bike Path 025, weld No: BK004A4-025-036/037. The welders are identified as #057266/054069. ZPMC QC is identified as Mr. Li Jun. The welding variables recorded by QC appear to comply with WPS-B-T-2132.

FCAW in the 2F position for the Bike Path 025, weld No: BK004A4-025-014/015. The welders are identified as #053869. ZPMC QC is identified as Mr. Li Jun. The welding variables recorded by QC appear to comply with WPS-B-T-2132.

Magnetic Particle Testing:-

Bay #10

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 South Tower Lift 5 Grillage. The weld designation reviewed is as follows:

SSD1-TL5-1F-F-7,8,9,10,11A,11B,12A,12B,23A,23B,24A,24B.

SSD1-TL5-1E-F-7,8,9,10,11A,12A,12B,25A,25B,26A.

SSD1-TL5-1B-F-12,20,25A,25B,26A,26B,31A,32A,32B,33A.

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



Summary of Conversations:

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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 Micheal Ng- 159-2184-5703 , who represents the Office of Structural Materials for your project.

Inspected By:	Pillai,Pandaram	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
