

**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-023831**Date Inspected:** 19-Apr-2011**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:** OBG & 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#11

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 08865

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 reviewed as follows:

TOWER COMPONENTS

WSD1-TL6-4B/D-01; 05; 06; 027

WSD1-CSA6-35-1

WSD1-CSA6-37-6

WSD1-CSA6-39-7

WSD1-CSA6-41-3

WSD1-CSA6-43-5

WSD1-CSA6-49-1

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ESD1-TL6-2B/D-1-31; 32; 65; 66  
ESD1-CSA6-35-7  
ESD1-CSA6-37-6  
ESD1-CSA6-41-3  
ESD1-CSA6-47-1  
ESD1-CSA6-50-1

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 08866

## 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 reviewed as follows:

### TOWER COMPONENTS

ESD1-FFSA6-2-20~22  
WSD1-FFSA6-4-17  
WSD1-FFSA6-4-22  
ESD1-FFSA6-2-17  
WSD1-FASA6-4-20; 21

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 08868

## 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 reviewed as follows:

### TOWER COMPONENTS

WSD1-TPSA6-3-5

This QA Inspector observed the following work in progress

### Shielded Metal Arc Welding (SMAW):

Weld joint #014 located on Lift-6 Tower head component ESD1-FGSA6-2. Welder is identified as 046704.

ZPMC Quality Control (QC) Inspector is identified as Shang Hai Lang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2213-Tc-U4c.

Weld joint #002 located on Lift-6 Tower head component WSD1-TL6-4A/D. Welder is identified as 041271.

ZPMC Quality Control (QC) Inspector is identified as Shang Hai Lang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2112.

Weld joint #004 located on Lift-6 Tower head component ESD1-TL6-2A/D. Welder is identified as 040614.

ZPMC Quality Control (QC) Inspector is identified as Shang Hai Lang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2112.

### Submerged Arc Welding (SAW):

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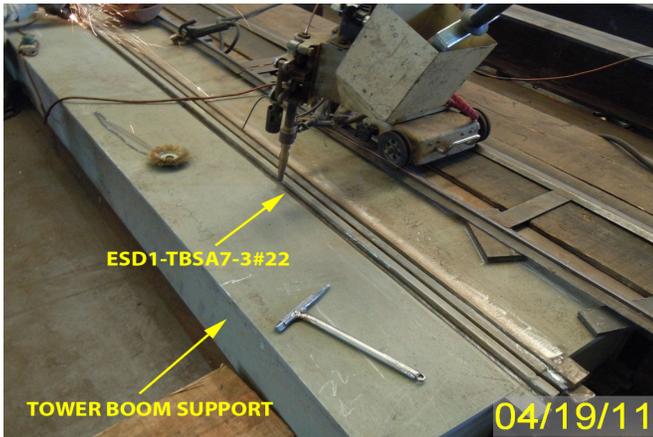
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Weld joint #022 located on ESD1-TBSA7-3. Welder is identified as 044550. ZPMC Quality Control (QC) Inspector is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-Tc-U4c-S. (See attached photo)

Weld joint #020 located on NSD1-TBSA7-3. Welder is identified as 044550. 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-2221-Tc-U4c-S.

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 Thomas Ho - 15002048250, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Kumar,Sandeep	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

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