

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-005516**Date Inspected:** 09-Feb-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** As listed below**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 OSM Quality Assurance (QA) Inspector, Luis Hutchins, was present during the times noted above for observations relative to the work being performed.

In progress welding:

SMAW welding of weld joint NSD1-SA17 A/G 101, 103, 105, 107, 86, 87, 81, 91, 93, 95, 97 and 99. Welders are identified as 056200 and 040450. ZPMC QC is identified as Liu Young. The welding variables recorded by QC appeared to comply with the WPS #345-SMAW-1G (1F)-Repair.

FCAW welding of weld joint NSD1-SA166 E/F 1, 3, 8 and 12. Welders are identified as 053870, 057194 and 040261. ZPMC QC is identified as Chen Shou Hua. The welding variables recorded by QC appeared to comply with the WPS #B-T-2231-TC-U5-F.

FCAW welding of weld joint NSD1-SA166 D/F 16. Welder is identified as 044571. ZPMC QC is identified as Chen Shou Hua. The welding variables recorded by QC appeared to comply with the WPS #B-T-2231-TC-U5-F.
FCAW welding of weld joint NSD1-SA61 1, 2, 3, 6, 7, 8, 10, 11, 12 and 13. Welders are identified as 040475 and 206568. ZPMC QC is identified as Liu Young. The welding variables recorded by QC appeared to comply with the WPS #B-T-2312-TC-P5.

SAW welding of weld joint ND1-A476-77M-2-7 and 8. Welder is identified as 207746. ZPMC QC is identified as Wu Ming Kai. The welding variables recorded by QC appeared to comply with the WPS

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

#B-T-4221-B-U3C-S-1.

SAW welding of weld joint ND1-A476-65M-2-7 and 8. Welder is identified as 207746. ZPMC QC is identified as Wu Ming Kai. The welding variables recorded by QC appeared to comply with the WPS

#B-T-4221-B-U3C-S-1.

SAW welding of weld joint ND1-A476-53M-2-7. Welder is identified as 207746. ZPMC QC is identified as Wu Ming Kai. The welding variables recorded by QC appeared to comply with the WPS #B-T-4221-B-U3C-S-1.

FCAW welding of weld joint NSD1-SA180 A/E 33, 35, 40, 34, 30, 31, 32, 25, 17, 19, 9, 10, 12, 1, 34 and 5. Welders are identified as 052075, 057180, 201825 and 203977. ZPMC QC is identified as Chen Likun. The welding variables recorded by QC appeared to comply with the WPS #B-T-4332-TC-P5-F.

FCAW welding of weld joint NSD1-SA180 B/E 8, 9, 10 and 14. Welders are identified as 057244, 040338 and 054069. ZPMC QC is identified as Chen Likun. The welding variables recorded by QC appeared to comply with the WPS #B-T-4332-TC-P5-F.

FCAW welding of weld joint NSD1-SA180 C/E 23, 24, 25 and 26. Welders are identified as 057244, 040338 and 054069. ZPMC QC is identified as Chen Likun. The welding variables recorded by QC appeared to comply with the WPS #B-T-4332-TC-P5-F.

SAW welding of weld joint WD1-A476-33M-1-12. Welder is identified as 042195. ZPMC QC is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS #B-T-4221-B-U3C-S-1.

SAW welding of weld joint WD1-A476-33M-2-12. Welder is identified as 042195. ZPMC QC is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS #B-T-4221-B-U3C-S-1.

SAW welding of weld joint WD1-A476-38M-1-12. Welder is identified as 042195. ZPMC QC is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS #B-T-4221-B-U3C-S-1.

Ultrasonic Inspection:

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a UT report for this date. The members are identified in that report.

Magnetic Particle Inspection:

This QA inspector performed MT of approximately 25% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a MT report for this date. The members are identified in that report.

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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Summary of Conversations:

No significant conversations held during the course of inspection.

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 Serge Sinevod 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By:	Hutchins,Luis	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
