

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-005523**Date Inspected:** 03-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:** 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 COMPONENTS**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Gady Rao, was present during the times noted above for observations relative to the work being performed.

Magnetic Particle Testing:

This QA inspector performed 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(s) & the weld designations reviewed are as follows:

Bay 10

SSD1 – SA 17 F/G 63,64, 70, 75, 76, 81, 82, 35, 36, 39, 40, 45, 46, 51, 52, 57, 58 SOUTH TOWER; SKIN-C; LIFT-1; Dearing plate MT – Repair (grinding) in – complete. Shaft rotated.

BAY 11

WSD1 – SA355 1A / B, 2A / B TOWER STIFFENER SPLICE PLATE; Completed.

ESD1 – SA355 1A / B, 2A / B TOWER STIFFENER SPLICE PLATE; Completed.

ESD1 – SA355 1A / B, 2A / B TOWER STIFFENER SPLICE PLATE; Completed.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

WSD1 – SA384 1A / D - 14A / B WEST TOWER; SKIN - B; LIFT – 2; Completed.

In-process inspection:

Bay 11

SAW -FCM – Materials:

1) SAW welding of weld joint ED1- SA 250 –13M – 2 – 1A, located on; PCMK P49 - 1 to SA250. Welder is identified as 041716. ZPMC QC is identified as Yu Dong Ping / Xu Le Feng. The welding variables recorded by QC appeared to comply with the B – T – 3221 – B – U3C - S – 1.

2) SAW welding of weld joint WD1- A 467 –47.6M – 1 – 11A, A 467 – 47.6M – 2 – 11A located on; PCMK P1107 to A 467. Welder is identified as 042195. ZPMC QC is identified as Yu Dong Ping / Xu Le Feng. The welding variables recorded by QC appeared to comply with the B – T – 4221 – B – U3C - S – 1.

FCAW

1)FCAW welding of welds joint WSD1-SA 340 E / F – 17A, 18, 21A, 26A, 30A located on PCMK ; SKIN – A, LIFT - 2. Welder is identified as 068852 / 062782 / 066155. ZPMC QC is identified as Li Ming / Xu Le Feng. The welding variables recorded by QC appeared to comply with the B-T-2232-TC-U5-F & B-T-2332-TC-P5-F.

2)FCAW welding of welds joint WSD1-SA 298 F / G – 7, 8 & SA 298 E / G – 15, 16 located on PCMK ; SKIN – E, LIFT - 2. Welder is identified as 067036 / 067184. ZPMC QC is identified as Huang Li / Xu Le Feng. The welding variables recorded by QC appeared to comply with the B-T-2332-TC-P5-F.

FCAW – Buttering.

3) FCAW welding of welds joint West Tower PCMK; SKIN – E, LIFT - 1. Welder is identified as 066164 / 066420. ZPMC QC is identified as An Qing Xiang / Xu Le Feng. The welding variables recorded by QC appeared to comply with the WPS – 345 – 2G / 2F - Repair.

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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By:	Rao,Gady	Quality Assurance Inspector
----------------------	----------	-----------------------------

Reviewed By:	Clifford,William	QA Reviewer
---------------------	------------------	-------------
