

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-006270**Date Inspected:** 08-Apr-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:** Liu Yang**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

ED1-A27A/E-51A/B; Lift-3; East Tower; Base Shear Plate.

Bay 11

WSD1-FCSA3-2B/C-20A/B,18A/B,25A/B,29A/B,35A/B,39A/B; Lift-3; West Tower; Skin C;.

Bay 10

SAW

WELDING INSPECTION REPORT

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SAW welding of weld joint SSD1 – FDSA3 – 1B/C – 40A located on PCMK LS3-29 to LS3-40; SKIN-D; Lift – 3; Stiffener D1;. Welder is identified as 052917. ZPMC QC is identified as Ye Yong Jun. The welding variables recorded by QC appeared to comply with the B – T – 2221 – B – U3C - S – 2.

FCAW

FCAW welding of Shear base plate B2 weld joint # WD1-A22A/B-49,50,53,and 54. Welders are identified as 067037, 066825,066733 & 068919. ZPMC QC is identified as Chen Ying Xin. The welding variables recorded by QC appeared to comply with the WPS B-T-2332-TC-P5-F.

SMAW

1)SMAW welding of welds joint ND1-A476–53M–2–14A, 3A, located on PCMK P50 to P 12; LIFT-3. Welders are identified as 057258 / 056364. ZPMC QC is identified as Wu Ming Kai/ Liu Yang. The welding variables recorded by QC appeared to comply with the B-T-3212–TC–U5B-1.

2)SMAW welding of welds joint WD1-A468–33M–2–26B, located on PCMK A468 to P 234, LIFT-3. Welders are identified as 053671. ZPMC QC is identified as Wu Ming Kai / Liu Yang. The welding variables recorded by QC appeared to comply with the B-T-2212–TC–U5B-1.

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

Summary of Conversations:

No Relevant Convesations.

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:	Rao,Gady	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
