

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-006308**Date Inspected:** 26-Mar-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:	Li Ming / Yu Dongping / Huang Li			CWI Presentation:	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, the Caltrans OSM Quality Assurance (QA) Inspector, KS Narayan (Victor) was present during the times noted above for observations relative to work performed.

Bay 11 – Tower Assembly

Lift 3 – Skin Plates' butt welding:

Weld process, SAW of butt weld joints located on PCMK: Lift 3-East & West Tower Skin plate butt welds. The weld designation numbers and welders were identified as follows.

- (1) ESD1-FESA3-2A/D-8B, 12B, 17B (CJP) & 11, 15 (PJP) – skin "E": The welder was identified as Xue Yian and the welder number was identified as 040634.
- (2) ESD1-FESA3-2A/D-17B, 21B (CJP) & 20, 24 (PJP) – skin "D": The welder was identified as Shen Mei and the welder number was identified as 041716.
- (3) WSD1-FCSA3-2B/C-2B, 10B (CJP) – skin "C": The welder was identified as Yang Meizhan and the welder number was identified as 042195.

The ZPMC CWIs were identified as Li Ming & Huang Li and the ABF representatives were identified as Zhao Xianhe & Xie Yan. The welding variables recorded by QC appeared to comply with applicable WPS, WPS-B-T-2221-B-P3-S-Z for PJP weld joints & WPS-B-T-2221-B-U3C-S-Z for CJP weld joints.

Shear link plates' welding:

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Weld process, SMAW of weld joints located on PCMK (1) ED1-SA250-28M-2-1B , (2) WD1-SA250-33M-1-1B & (3) ED1-SA250-65M-1-1B. The welder numbers were identified as 040669, 053916 & 047470 respectively. The ZPMC CWI was identified as Yu Dongping and ABF representative was identified as You Yuanmao. The welding variables recorded by QC appeared to comply with applicable WPS, WPS-B-T-2221-B-P3-S-Z for PJP weld joints & WPS-B-T-2221-B-U3C-S-Z for CJP weld joints.

Bay 10 – Tower Assembly:

Lift 3 – Skin Plates’ butt welding:

Weld process, SAW of butt weld joint located on PCMK Lift 3 plate – SSD1-FDSA3-1A/C-5B (CJP) & 4(PJP). The welder was identified as Zhang Suqin and the welder number was identified as 209051. The ZPMC CWI was identified as Liu Zhongan and the ABF representative was identified as Jiang Ziwen. The welding variables recorded by QC appeared to comply with applicable WPS, WPS-B-T-2221-B-U3C-S-Z for CJP weld joints.

Bay 11 – Tower Assembly:

Ultrasonic Testing:

This QA Inspector performed 10% UT of area previously tested by ZPMC UT personnel. This QA Inspector generated a TL-6027 MT report on this date. The member was identified as Lift 3 – East Tower Skin “B” butt weld joint.

The weld designation number is as follows.

ESD1-FBSA3-2A/C-17A

Magnetic Particle Testing:

This QA Inspector performed 100% VT (visual inspection/testing) & 15% MT of area previously tested by ZPMC MT personnel. This QA Inspector generated a TL-6028 MT report on this date. The member was identified as Lift 3 – East Tower Skin “B” butt weld joint.

The weld designation number is as follows.

ESD1-FBSA3-2A/C-17A

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

Summary of Conversations:

No relevant conversations

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.

Comments

WELDING INSPECTION REPORT

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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 (134-825-70045), who represents the Office of Structural Materials for your project.

Inspected By:	Narayan, Victor	Quality Assurance Inspector
Reviewed By:	Clifford, William	QA Reviewer
