

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-006311**Date Inspected:** 25-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 Le / Yu Dongping / Xiao Yun			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, the Caltrans OSM Quality Assurance (QA) Inspector, "Victor" KS Narayan was present during the time noted above for observations relative to the following work performed.

Bay 11 – TOWER ASSEMBLY:

I. Lift 3 – Skin Plates' butt welding:

Weld process, SAW of butt weld joints located on Lift 3-East Tower Skin "C/E" plate butt welds:

The weld designation numbers and the welders were identified as follows.

ESD1-FCSA3-2B/C-24, 28B-(1), 28B-(2) (CJP): The welder was identified as Li Xiaoqing and the welder number was identified as 044560.

ESD1-FCSA3-2B/C-19B (CJP) & 16 (PJP): The welder was identified as Qin Xiulan and the welder number was identified as 044550.

ESD1-FESA3-2B/D-7A (CJP): The welder was identified as Qin Xiulan and the welder number was identified as 044550.

ESD1-FCSA3-2B/C-10B-2 (CJP): The welder was identified as Xia Wenying and the welder number was identified as 044558.

ESD1-FCSA3-2B/C-33, 41 (PJP) & 38B (CJP): The welder was identified as Wu Aixiang and the welder number was identified as 040772.

ESD1-FCSA3-2B/C-65A (CJP): The welder was identified as Wu Aixiang and the welder number was identified as 040772.

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ESD1-FESA3-2B/D-7A (CJP): The welder was identified as Zou Xiaohua and the welder number was identified as 207463.

ESD1-FCSA3-2B/C-46A (CJP): The welder was identified as Zou Xiaohua and the welder number was identified as 207463.

The ZPMC CWIs were identified as Li Le & Xiao Yun and the ABF representatives were identified as Zhang Jicai & Wang Chenjun. 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.

II. Struts' welding:

Weld process, SMAW of PJP weld joints located on West Tower struts:

The weld designation numbers and the welders were identified as follows.

WD1-A467-47.6M-1-79, 80, 15, 16: The welder was identified as Ge Hongqi and the welder # was identified as 037780.

WD1-A467-47.6M-2-93, 94: The welder was identified as Shen Zhihua and the welder # was identified as 062772.

WD1-A467-47.6M-2-43, 44: The welder was identified as Xu Yiping and the welder # was identified as 040655.

WD1-A467-47.6M-2-55, 56: The welder was identified as Qing Zhenhan and the welder # was identified as 062975.

The ZPMC CWI was identified as Yu Dongping and the ABF representative was identified as Bi Dewei. The welding variables recorded by QC appeared to comply with applicable WPS, WPS-B-T-4113-1 & WPS-B-T-2113-1 for PJP weld joints.

II. East Tower 2 Skin plate "E" – Skin plate "A" corner joint welding:

Weld process, SAW of CJP corner weld joint located between skin "E" & "A":

The weld designation numbers and the welders were identified as follows.

ESD1-TL7B/L-1A: The welders were identified as Cao Xiaohua (welder #: 056975), Yang Meizhan (welder #: 042195) and Deng Junfeng (welder #: 202756)

The ZPMC CWI was identified as Peng Guo and the ABF representative was identified as Xing Xiaoguang. The welding variables recorded by QC appeared to comply with applicable WPS, WPS-B-T-2221-C-U2b-S-2

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

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.

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