

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-006392**Date Inspected:** 08-Apr-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Liang**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**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Larry Viars was present during the times noted above for observations relative to the work being performed.

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This QA inspector received NDT Inspection Notification Sheet 002576 for Quality Assurance verification of Visual Testing (VT), Magnetic Particle Testing (MT) of South Tower Lift 1 (Skin C to D) Diagonal stiffeners. QA performed Visual inspection of welds and performed MT. During MT inspection intermittent cracking (250 of 300 mm) was found on weld SSD1-A164 A/J-002. ZPMC QC stated that MT had not been performed by ZPMC MT. ZPMC personnel removed approximately 5 mm of base metal and cracks were still present. ZPMC QC stated that MT would be performed on the remainder of welds and that a critical weld repair report would be submitted for approval prior to weld repair. Please see the attached photos below of the above mentioned Tower crack. Testing results were submitted to Caltrans Quality Assurance Lead inspector Mr. William Clifford.

This QA Inspector observed the following work in progress: FCAW welding of weld joint 146 and 147 located on Tower component NSD1-TL8E-L. ZPMC welder was identified as Jia Quan. ZPMC QC is identified as Liu liang. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-4132

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

WELDING INSPECTION REPORT

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Summary of Conversations:

As identified within the contents of this report.

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:	Viars,Larry	Quality Assurance Inspector
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Reviewed By:	Carreon,Albert	QA Reviewer
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