

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-006980**Date Inspected:** 09-May-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 11

Inspection part	Section	Inspection Area.
Fit Lugs on 43M Upper Diaphragm and Skin-B	East Tower; Lift-1	near Bay-11
Fit Lugs on Skin-A 18M to 47.6M	East Tower; Lift-1	near Bay-11
Backfill plates welds 18M to 47.6M Skin-A&E	East Tower; Lift-1	near Bay-11

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SAW

SAW welding of weld joint NSD1-FBSA4-1A/C-35A, located on PCMK FB4-18 to FB4-1; Lift-4; North Tower. Welder is identified as 040252. ZPMC QC is identified as Maa Yun. The welding variables recorded by QC appeared to comply with the B-T-2221-B-U3C-S-2.

FCAW

1)FCAW welding of weld joint # NSD1-FASA3-1E/E-26, 27, 58, and 59 located on North Tower, Lift-3, Skin-A. Welders are identified as 067138 / 066236/037873/066155. ZPMC QC is identified as Jin Dong Liang. The welding variables recorded by QC appeared to comply with the WPS B-T-2332-TC-P5-F.

2)FCAW welding of weld joint # ED1-A27A/E-5,7,13, and 14 located on East Tower. Welders are identified as 067037/066399/068554/069866. 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.

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.

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