

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-007686**Date Inspected:** 06-Jul-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wan Wen Zhong**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 2

Inspection part	Section	Inspection Area.
FB020-005--(As per Notification 003612)	OBG Floor Beam 10 Lifting	Bay-2
FB020-006--(As per Notification 003612)	OBG Floor Beam 10 Lifting	Bay-2
FB028-010--(As per Notification 003612)	OBG Floor Beam 10 Lifting	Bay-2

Bay 01

WELDING INSPECTION REPORT

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FCAW

1)FCAW welding of weld joint CB201A-007-008/019. Welder is identified as 216575. ZPMC QCI is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

2)FCAW welding of weld joint FB205-016-029/030. Welder is identified as 054460. ZPMC QCI is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-B-U2-F & B-T-2233-B-U2-F.

Bay 06

SMAW-Strut Connection Plates.

1)SMAW welding of weld joint WD1-A305-53M-2-12/13 & 58/59. Welder is identified as 068924/068691. ZPMC QCI-CWI is identified as Zou Liu Hai. The welding variables recorded by QC appeared to comply with the WPS- B-T-2113.

2)SMAW welding of weld joint WD1-A305-53M-3-8A&2B. Welder is identified as 066268/037932. ZPMC QCI-CWI is identified as Zou Liu Hai. The welding variables recorded by QC appeared to comply with the WPS-B-T-3212-TC-U5b-1.

Bay 10

FCAW –South Tower Lift-3

1)FCAW welding of weld joint SSSL3-1G/K -46 located on South Tower; Lift-3. Welding of fit-lugs in progress on Skin-A. Welder is identified as 053116. ZPMC QCI is identified as Wan Wen Zhong. The welding variables recorded by QC appeared to comply with the WPS-B-T-4333-TC-P4-F.

2)FCAW welding of weld joint SSSL3-1I/K -133/134 located on South Tower; Lift-3. Welding of fit-lugs in progress on Skin-A. Welder is identified as 052075. ZPMC QCI is identified as Wan Wen Zhong. The welding variables recorded by QC appeared to comply with the WPS-B-T-4333-TC-P4-F.

3)FCAW welding of weld joint SSD1-FDSA4-1C/C-20/21 located on South Tower; Lift-4; Skin-D. Welder is identified as 201825/050041. ZPMC QCI-CWI is identified as Wan Wen Zhong. The welding variables recorded by QC appeared to comply with the WPS- B-T-2332-TC-P5-F.

Bay 11

SAW

SAW welding of weld joint WSD1-FCSA4-2C/C-4B located on West Tower; Lift-4; Skin-C. Welder is identified as 042195. ZPMC QCI is identified as Lui Xiao Zhang. The welding variables recorded by QC appeared to comply with the WPS- B-T-2221-B-U3C-S-2.

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FCAW –West Tower Lift-2

1)FCAW welding of weld joint WSD1-TL6-J/C -55/56 located on West Shaft; Lift-2. Welding of Diagonal plate to Skin-B is in progress. Welder is identified as 066479. ZPMC QCI-CWI is identified as Zhan Zhi neng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P4-F.

2)FCAW welding of weld joint WSD1-TL6-J/L -57/58 located on West Shaft; Lift-2. Welding of Diagonal plate to Skin-D is in progress. Welder is identified as 068493. ZPMC QCI-CWI is identified as Zhan Zhi neng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P4-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
Reviewed By:	Clifford,William	QA Reviewer
