

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-008089**Date Inspected:** 11-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.
Pin Hole at location A29, A30As per Notification 003659)	OBG 1AAE	Bay-2

Bay 01

FCAW

FCAW welding of weld joint FB201-14-037/038. Welding of Floor Beam Stiffener is in progress. Welder is identified as 054460. ZPMC QCI-CWI is identified as Chen Xi and QCI as Tian Lei. The welding variables

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recorded by QC appeared to comply with the WPS-B-T-2232-TC-U4b-F.

Bay 06

SMAW-Strut Connection Plates.

SMAW welding of weld joint WD1-A305-65M-2-41. Welder is identified as 068091. ZPMC QCI-CWI is identified as Shi Yu. The welding variables recorded by QC appeared to comply with the WPS- B-T-2113.

Bay 10

FCAW-South Shaft Lift-3

1)FCAW welding of weld joint SSSL3-1B/K- 82B located on South Tower Shaft; Lift-3.Welding of Corner weld (out side) in progress. Welder is identified as 050295/207745. ZPMC QCI-CWI is identified as Wan Wen Zhong. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-C-U2b-S-2.

2)FCAW welding of weld joint NSTL3-3I/K-118, 119, 120, 121, 122, 123 located on North Tower; Lift-3. Welding of Stiffener to Diaphragm and Fit-lug to Diaphragm is in progress at 109M & 99M elevations respectively. Welder is identified as 053116/057244. ZPMC QCI-CWI is identified as Li Ming. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133 & B-T-4133.

SMAW-Repair-North Shaft Lift-1

SMAW welding of weld joint NSD1-A166J/J-219 located on North Tower;Lift-1.Welder is identified as 052930. ZPMC QCI - CWI is identified as Wan Wen Zhong. The welding variables recorded by QC appeared to comply with the WPS-SMAW-3G (3F)-Repair.

Bay 11

SAW

1)SAW welding of weld joint WSD1-FDSA4-4A/D-14B, 15B located on West Tower; Lift-4; Skin-D. Welder is identified as 047304. ZPMC QCI-CWI is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS- B-T-4221-B-U3C-S-3.

2)SAW welding of weld joint WD1-A6003-8-2B located on West Tower. Welder is identified as 046975. ZPMC QCI-CWI is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS- B-T-4221-B-U3C-S-1.

FCAW

1)FCAW welding of weld joint WSD1-FASA4-2E/E-48, 49 located on West Tower; Lift-4; Skin-A. Welding of Skin plate to Stiffener is in progress. Welder is identified as 068923/070140. ZPMC QCI is identified as Cao Cheng . The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P5-F.

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Doubler Plate welding:

2)FCAW welding of weld joint ESD1-FASA4-2A/E-27 located on East Tower; Lift-4; Skin-4. Welding of Skin plate to Doubler plate is in progress. Welder is identified as 070212. ZPMC QCI-CWI is identified as Liu Xiao Zhong. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-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
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Reviewed By:	Clifford,William	QA Reviewer
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