

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-008158**Date Inspected:** 02-Aug-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 Hong Fei, Liu Xiaozhong, Zhang			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, Amit K. Juvekar, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Bay11, East Tower, Interior Corner Splice Sub Assembly.

FCAW welding of weld joint ESD1-SPSA3-35-2A; located on Bay11, East Tower. Welder is identified as 040723, 047701; ZPMC Quality Control Inspector (QC) is identified as Li Hong Fei. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2232-B-U2-F.

Bay11, West Tower, Skirt Plate.

SAW welding of weld joint WD1-A597A/L-27B; located on Bay11, West Tower. Welder is identified as Wu Aixiang 040772; ZPMC Quality Control Inspector (QC) is identified as An Qin Xiang. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2221-B-L2C-S-2.

Bay11, Lift 4, Skin C, West Tower.

FCAW welding of weld joint WSD1-FCSA4-2B/C-14A, 12; located on Bay11, Lift 4, Skin C, West Tower. Welder is identified as 049099; ZPMC Quality Control Inspector (QC) is identified as Liu Xiaozhong. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: 1)WPS-B-T-3212-TC-U5B-1, 2)WPS-B-T-3212-TC-TC-P5.

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Bay11, Lift 4, Skin D, West Tower.

FCAW welding of weld joint WSD1-FDSA4-4D/D-47, 48, 44, 45, 47, 48; located on Bay11, Lift 4, Skin D, West Tower. Welder is identified as 20009, 068919, 068916, 066477, 068753, 066251; ZPMC Quality Control Inspector (QC) is identified as Zhang Bo. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2331-TC-U5-F.

This QA Inspector carried out NDE on following:

Bay 11, West Tower, Lift 1, Skin C, Bearing Plates.

This QA inspector performs Random Visual Testing (VT), Magnetic Particle Testing (MT) of approximately 15% area previously tested and accepted by ZPMC Quality Control personnel, FOR GREEN TAG. This QA Inspector generated an MT report (TL-6028) for this date. The members are identified as WSD1-SA294F/G-27, 28, 29, 34, 39, 40, 45, 46, 51, 52, 57, 58, 61, 66, 67, 72, 74, 76.

GREEN TAG # 8239.

Bay 10, North Tower, Tower Shear Link.

This QA inspector performs Magnetic Particle Testing (MT) of approximately 15% area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report (TL-6028) for this date. The members are identified as

- 1) ND1-A6002-6-3, 4 (A/B)
- 2) ND1-A6002-7-3, 4 (A/B)
- 3) ND1-A6002-8-3, 4 (A/B)
- 4) ND1-A6002-9-3, 4 (A/B)
- 5) ND1-A6002-10-3, 4 (A/B)

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, 13482570045, who represents the Office of Structural Materials for your project.

Inspected By:	Juvekar,Amit	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
