

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-009074**Date Inspected:** 03-Sep-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:	An Qin Xiang, Xu Le Feng, Peng			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, West Tower.

SAW welding of weld joint WD1-A6003-7-6B; located on Bay11, West Tower. Welder is identified as 044550; 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-4221-B-U3C-S-1.

Bay11, West Tower, STRUTS.

SMAW welding of weld joint WD1-A6001-8-41, 42, 31, 32, 19, 20, 55, 56, 67, 68, 79, 80, 91, 90; located on Bay11, West Tower. Welder is identified as 066480; ZPMC Quality Control Inspector (QC) is identified as Xu Le Feng. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2112.

Bay11, Lift 3, East Tower(Inside), CD Corner 111.89M.

FCAW welding of weld joint WSTL3-4J/K-1,2; located on Bay11, Lift 3, East Tower(Inside), CD Corner 111.89M. Welder is identified as 069043 Zhu Tangquan; ZPMC Quality Control Inspector (QC) is identified as Peng Guo. The welding variables recorded by Quality Control Inspector(QC) appeared to comply with the Applicable WPS: 1)WPS-B-T-2132, 2)WPS-B-T-2133.

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This QA Inspector carried out NDE on following:

Bay 11, West Tower, Lift 3.

This QA inspector performs Random Visual Testing (VT) of area previously tested and accepted by ZPMC Quality Control personnel, FOR GREEN TAG. The members are identified as

- 1) WSTL3-4C/K-87, 88. 89M Diaphragm Web to Skin D Connection Plate.
- 2) WSTL3-4G/K-29, 30. 99M Diaphragm Web to Skin D Connection Plate.
- 3) WSTL3-4I/K-23, 24. 109M Diaphragm Web to Skin D Connection Plate.

Bay 11, East Tower, Lift 3.

This QA inspector performs Random Visual Testing (VT) of area previously tested and accepted by ZPMC Quality Control personnel, FOR GREEN TAG. The members are identified as

- 1) ESTL3-4B/K-62/63. B/C Corner Stiffener Triangle Plate, 85.25M
- 2) ESTL3-4C/K-99/100. B/C Corner Stiffener Triangle Plate, 89M
- 3) ESTL3-4C/K-70/71. B/C Corner Stiffener Triangle Plate, 89M
- 4) ESTL3-4F/K-57/58. B/C Corner Stiffener Triangle Plate, 92.5M
- 5) ESTL3-4F/K-133/134. B/C Corner Stiffener Triangle Plate, 95.5M
- 6) ESTL3-4G/K-69, 70. B/C Corner Stiffener Triangle Plate, 99M
- 7) ESTL3-4G/K-158/160. B/C Corner Stiffener Triangle Plate, 99M
- 8) ESTL3-4H/K-57/58. B/C Corner Stiffener Triangle Plate, 102.5M
- 9) ESTL3-4H/K-131/132. B/C Corner Stiffener Triangle Plate, 105.5M
- 10) ESTL3-4I/K-66/67. B/C Corner Stiffener Triangle Plate, 109M
- 11) ESTL3-4I/K-156/158. B/C Corner Stiffener Triangle Plate, 109M
- 12) ESTL3-4J/K-60/61. B/C Corner Stiffener Triangle Plate, 111.89M

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
