

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-009135**Date Inspected:** 14-Sep-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, Shen Fu You			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		

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector, Utekar Shrikant was present during the times noted above for observations relative to the work being performed.

BAY#11

Visual Inspection

This QA inspector performed Visual Testing (VT) of the area previously tested and accepted by ZPMC Quality Control personnel. The members are identified as doubler plates of skin 'E' for the West tower lift four. The weld identification numbers are as follows:

WSD1-FESA4-4B/F-1, 4, 5, 14, 15, 16

WSD1-FESA4-4C/F-3, 4, 5, 10, 11, 12

WSD1-FESA4-4D/F-3, 4, 5, 12, 13, 14

WSD1-FESA4-4E/F-3, 4, 5

Magnetic Particle Inspection

This QA inspector performed Magnetic Particle Testing (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 members are identified as doubler plate of skin plate 'E' for West tower lift four. The weld identification numbers

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are as follows:

WSD1-FESA4-4B/F-1, 4, 5, 14, 15, 16

WSD1-FESA4-4C/F-3, 4, 5, 10, 11, 12

WSD1-FESA4-4D/F-3, 4, 5, 12, 13, 14

WSD1-FESA4-4E/F-3, 4, 5

Green Tag

The following green tags issued for Tower components after completing the NDT requirements are.

West tower skin e doubler plates - Green tag# 10424

BAY#10

This QA Inspector randomly observed the following work in progress.

FCAW welding process of weld joint 1A located on PCMK NSD1-SPSA3-56. Welder is identified as 040533 ZPMC QC is identified as Ma Yun. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-TC-U5-F.

Unless otherwise noted, all work observed on this dated 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:	Utekar,Shrikant	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
