

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-009808**Date Inspected:** 20-Oct-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:** Yu dong ping**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, D.Sukanthan was present during the time noted above for observations relative to the work being performed.

TOWER # BAY 11

This QA inspector performed Ultrasonic Test of approximately 10% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an Ultrasonic Test report for this date. The member is identified as Tower Strut Plate. Inspection Notification number - 004435. The weld designations reviewed are as follows:

(WD1-A6001-8-007A/B, 008A/B, 009A/B, 010A/B, 011A/B, 012A/B)

This QA inspector performed Magnetic Particle Test of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an Magnetic Particle Test report for this date. The member is identified as Tower Strut Plate. Inspection Notification number- 004435. The weld designations reviewed are as follows:

(WD1-A6001-8-089,090,085,086,093,094,053,054,054,049,050,039,040,043,044,095,096,087,088,091, 092,059, 060,055,056,051,052,045,046,037,038,041,042)

This QA inspector performed Magnetic Particle Test of approximately 15% of the area previously tested and

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accepted by ZPMC Quality Control Personnel. This QA Inspector generated an Magnetic Particle Test report for this date. The member is identified as Tower Skirt Plate. Inspection Notification number- 004439. The weld designations reviewed are as follows:

(ESD1-A61-2-021,022,029,028,033,034,009,010,039,040,012,013,007,008,001,002)

(ESD1-A61-1-028,029,009,010,033,034,017,018,039,038,011,012,007,008,001,002)

(ESD1-A61-2-041,049,050,079,080,069,070,057,058,063,064,065,066,048,041,042,047)

(ESD1-A61-1-041,049,050,079,080,069,070,057,058,063,064,065,066,048,041,042,047)

TOWER # BAY 10

This QA inspector performed Ultrasonic Test of approximately 10% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an Ultrasonic Test report for this date. The member is identified as Tower Lift 3 West Tower Skin A& E. Inspection Notification number - 004442. The weld designations reviewed are as follows:

(WSTL3-4B/K-81B)

This QA Inspector randomly observed the following work in progress:

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Submerged Arc Welding Process:

Welding of weld joint –004B located on PCMK SD1-STSA3-1-109M-1. Welder is identified as 040772. ZPMC QC 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.

Welding of weld joint –006A located on PCMK SD1-STSA3-1-099M-1. Welder is identified as 040772. ZPMC QC 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.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No Relevant Conversation

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 Eric Tsang 150-00422372, who represents the Office of Structural Materials for your project.

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Inspected By: Sukanthan,Dhanasingh

Quality Assurance Inspector

Reviewed By: Hall,Steven

QA Reviewer