

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-010197**Date Inspected:** 12-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:** Chan Ying Xin**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 COMPONENT**Summary of Items Observed:**

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

In process Inspection

Bay #10

This QA Inspector observed the following work in progress:

SMAW welding in the 2G position at weld joint ND1-A6002-7-7B located on North Tower Strut assembly .
Welder is identified as #052493.ZPMC QC is identified as Mr. Chan Ying Xin.The welding variables recorded by QC appeared to comply with WPS-B-T-3212-Tc-U5b-1 .

SMAW welding in the 2G position at weld joint ND1-A6002-7-9A located on North Tower Strut assembly .
Welder is identified as #056364.ZPMC QC is identified as Mr. Chan Ying Xin.The welding variables recorded by QC appeared to comply with WPS-B-T-3212-Tc-U5b-1 .

SMAW welding in the 2G position at weld joint ND1-A6002-9-7B located on North Tower Strut assembly .
Welder is identified as #040333.ZPMC QC is identified as Mr. Chan Ying Xin.The welding variables recorded by QC appeared to comply with WPS-B-T-3212-Tc-U5b-1 .

SMAW welding in the 2G position at weld joint ND1-A6002-7-9A located on North Tower Strut assembly .
Welder is identified as #056200.ZPMC QC is identified as Mr. Chan Ying Xin.The welding variables recorded by

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QC appeared to comply with WPS-B-T-3212-Tc-U5b-1 .

SMAW welding in the 2G position at weld joint ED1-A6001-4-8B located on East Tower Strut assembly . Welder is identified as #053049.ZPMC QC is identified as Mr. Chan Ying Xin.The welding variables recorded by QC appeared to comply with WPS-B-T-3212-Tc-U5b-1 .

FCAW in the 3F position of the South Tower Diaphragm to Skin connecting Plate 'C' weld No. SSSL4-1K/L-69. The welder is identified as #066064. ZPMC QC is identified as Mr. Gong Liang Zhu .The welding variables recorded by QC appear to comply with WPS-B-T-2133.

FCAW in the 3F position of the South Tower Diaphragm to Skin connecting Plate 'C' weld No. SSSL4-1J/L-130. The welder is identified as #068753. ZPMC QC is identified as Mr. Gong Liang Zhu.The welding variables recorded by QC appear to comply with WPS-B-T-2133.

During random in-process visual inspection the QA inspector observed ZPMC welding personal was doing base metal repair welding without any NDE and Weld repair Report at North Tower Lift-IV, Skin 'D' .The QA Inspector found six Crack like Linear Indication length approx.10 to 130mm at the temporary attachment area after grinding .And the QA Inspector confirmed the Linear Indication by MT .This area were previously inspected and accepted by ZPMC QC.

This QA Inspector generated an incident report for this date.

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:	Bera,Subhasis	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
