

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-010199**Date Inspected:** 14-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 ED1-A6001-6-10B 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 .

SMAW welding in the 2G position at excavation area on weld joint ND1-A6002-4-9A/B located on Tower Strut assembly . Welder is identified as #056200.ZPMC QC is identified as Mr. Yu Zhi Lai.The welding variables recorded by QC appeared to comply with WPS-485-SMAW-2G (2F)-FCM-Repair-1 and repair procedure T-CWR324.

SMAW welding in the 2G position at excavation area on weld joint ND1-A6002-5-9A/B located on Tower Strut assembly . Welder is identified as #052493.ZPMC QC is identified as Mr. Yu Zhi Lai.The welding variables recorded by QC appeared to comply with WPS-485-SMAW-2G (2F)-FCM-Repair-1 and repair procedure T-WR2342.

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SMAW welding in the 2G position at excavation area on weld joint ND1-A6002-4-7A/B located on Tower Strut assembly . Welder is identified as #052493.ZPMC QC is identified as Mr.Yu Zhi Lai.The welding variables recorded by QC appeared to comply with WPS-485-SMAW-2G (2F)-FCM-Repair-1 and repair procedure T-WR2319.

SMAW welding in the 2G position at excavation area on weld joint ND1-A6002-16-9A/B located on Tower Strut assembly . Welder is identified as #040333.ZPMC QC is identified as Mr.Yu Zhi Lai.The welding variables recorded by QC appeared to comply with WPS-485-SMAW-2G (2F)-FCM-Repair-1 and repair procedure T-WR2354.

Ultrasonic Testing (UT)

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as West Tower Strut Plate welds .

The Weld Designations are as follow

WD1-STSA3-2-99MM-2-8,9A/B
WD1-STSA3-2-99MM-1-8,9A/B
WD1-STSA3-2-109MM-2-8,9A/B
WD1-STSA3-2-109MM-1-8,9A/B
WD1-STSA3-2-89MM-2-8,9A/B
WD1-STSA3-2-89MM-1-8,9A/B
WD1-STSA3-2-89MM-1-1,2,4,6A/B
WD1-STSA3-2-89MM-2-1,2,4,6A/B

Trial Assembly Yard

Splice joint between 1AE & 1BE

This QA inspector was instructed by task leaders to carry out Ultrasonic testing (UT) with ABF QC utilizing scanning pattern 'D' for detecting transverse Indications on the transverse segment splice for OBG Segment 1AE to 1BE. The indications found on this date were recorded onto a data sheet that Caltrans QA and ABF QA have jointly filled out.

The Weld Designations are as follows

OBE1-006
OBE1-005

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

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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.

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