

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-010658**Date Inspected:** 28-Nov-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, An Qin Xiang.	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:

Bay 10, North Tower, Lift 4, Skin E, Near 143M Double Diaphragm, E/D Corner, Temporary Attachment Area.

During random in Process visual inspection at North Shaft, Lift 4, Skin E (Temporary Attachment Area near Corner Seam E/D) this Caltrans Quality Assurance (QA) Inspector observed "Excavation in Base Metal over 6mm" at the removed Temporary attachment Weld area. The Excavation was shown to ZPMC and ABF QC Inspectors. No Incident Report has been written on this issue. The attached photographs provide additional detail.

Bay 11, East Tower, Interior Corner Splice Sub Assembly.

FCAW welding of weld joint ESD1-SPSA4-1-2B; located on Bay 11, East Tower. Welders are identified as 040759; 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: 1) WPS-B-T-2232-B-U5-F.

Bay 11, South Tower, Strut.

SMAW welding of weld joint SD1-STSA3-1-99M-1-11B; located on Bay 11, South Tower. Welders are identified as 088009, 040669; ZPMC Quality Control Inspector (QC) is identified as Yu Dong Ping. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2212-TC-U5B.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Bay 11, East Tower, Lift 4, DE Corner Inside.

SMAW welding of weld joint ESTL4-2L/L-1B; located on Bay 11, East tower. Welders are identified as 049099, 040733; ZPMC Quality Control Inspector (QC) is identified as Zhan Bo. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-485-SMAW-1G(1F)-REPAIR-1.

Bay 10, North Tower, Lift 1.

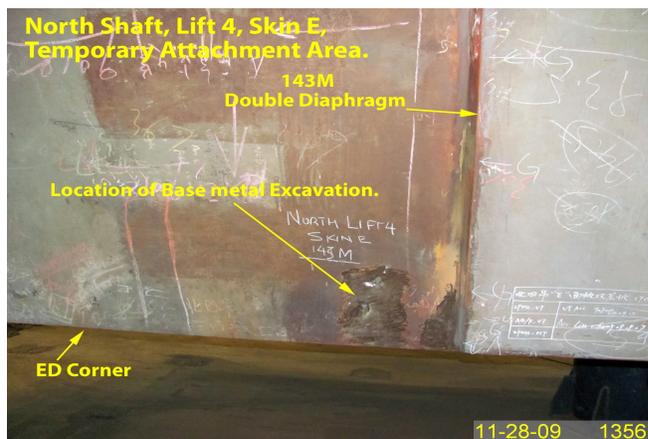
Installing Supports for Grating Brackets Inside.

This QA Inspector carried out NDE on following
Bay 11, Tower Strut Angle Plates.

This QA inspector performs Random Ultrasonic Testing (UT) of approximately 10% area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report(TL-6027) for this date. The members are identified as

- 1) WD1-SA3-18-99M-LOT-1A (LOT : 1 TO 8). QA UT 10% : WD1-SA3-18-99M-8-1A.
- 2) SD1-SA3-16-109M-LOT-1A (LOT : 1 TO 4). QA UT 10% : SD1-SA3-16-109M-3-1A.

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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Reviewed By: Clifford, William

QA Reviewer