

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-010729**Date Inspected:** 03-Dec-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:** Wu Zhi Cheg and Du Zhiquu**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:** OBG and 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.

Trial Assembly area In process Inspection

SMAW in the 4G position of the OBG segment 5CE corner joint at side plate to Edge plate , weld No. CA-024-001 at BK side. The welder is identified as #054467. ZPMC QC is identified as Mr. Wang Li Yang. The welding variables recorded by QC appear to comply with WPS- B-P-2214-Tc-U4b-FCM-1.

SMAW in the 4G position of the OBG segment 6AE corner joint at side plate to Edge plate , weld No. CA-026-001 at BK side. The welder is identified as #054467. ZPMC QC is identified as Mr. Wang Li Yang. The welding variables recorded by QC appear to comply with WPS- B-P-2214-Tc-U4b-FCM-1.

Witness of Magnetic Particle Testing

This QA inspector was Witnessing of Magnetic Particle Testing which was carried by ABF QC Technicians at Edge Plate Base Metal repair Area at 6CW at crass beam side. This inspector observed the ABF QC did not find any indication on the inspected area.

The Edge Plate designations reviewed as follows:

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EP24B

Tower In process Inspection

Bay #10

This QA Inspector observed the following work in progress:

SMAW welding in the 2G position on weld joint ED1-STSA3-2-99M-2-11B located on Tower Strut assembly .
Welder is identified as #056364.ZPMC QC is identified as Mr.Du Zhiqun.The welding variables recorded by QC appeared to comply with WPS-B-T-3212-Tc-U5b-1.

SMAW welding in the 2G position on weld joint ED1-STSA3-2-99M-1-61B located on Tower Strut assembly .
Welder is identified as #040582.ZPMC QC is identified as Mr.Du Zhiqun.The welding variables recorded by QC appeared to comply with WPS-B-T-3212-Tc-U5b-1.

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 Corner joint Strut Angle Tower part.

The Weld Designations are as follows

ND1-SA3-16-89M-2-1A/B
ND1-SA3-16-89M-3-1A/B
ND1-SA3-16-99M-1-1A/B
ND1-SA3-16-99M-2-1A/B
ND1-SA3-16-99M-3-1A/B
ND1-SA3-16-109M-2-1A/B
ND1-SA3-16-109M-3-1A/B
ND1-SA3-16-109M-4-1A/B
ND1-SA3-18-99M-2-1A/B
ND1-SA3-18-99M-3-1A/B
ND1-SA3-18-99M-4-1A/B
ND1-SA3-18-99M-5-1A/B
ND1-SA3-18-99M-6-1A/B
ND1-SA3-18-99M-8-1A/B
ND1-SA3-18-109M-3-1A/B

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

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remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

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