

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-010936**Date Inspected:** 11-Dec-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Du Zhi Qun, Liu Zhong An	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 day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This Quality Assurance (QA) Inspector observed the following work in progress:

Bay 10

SPARE STRUT

SMAW welding of weld joint 10B located on ED1-STSA3-2-109M-1.

Welder is identified as 040333. ZPMC QC is identified as Mr. Du Zhi Qun.

The welding variables recorded by QC appeared to comply with WPS-B-T-3212-Tc-U5b-1.

SMAW welding of weld joint 55 located on ED1-STSA3-2-99M-1.

Welder is identified as 057259. ZPMC QC is identified as Mr. Yu Zhi Lai.

The welding variables recorded by QC appeared to comply with WPS-B-T-2113.

SMAW welding of weld joint 15 located on ED1-STSA3-2-99M-2.

Welder is identified as 040267. ZPMC CWI is identified as Mr. Du Zhi Qun.

The welding variables recorded by QC appeared to comply with WPS-B-T-2113.

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SMAW welding of weld joint 54 located on ED1-STSA3-2-99M-1.

Welder is identified as 050038. ZPMC QC is identified as Mr. Yu Zhi Lai.

The welding variables recorded by QC appeared to comply with WPS-B-T-4113-1.

NORTH TOWER LIFT 5 BEARING PLATE

SMAW welding of weld joint 5B located on ND1-BPSA5-1-2.

Welder is identified as 040269. ZPMC QC is identified as Mr. Du Zhi Qun.

The welding variables recorded by QC appeared to comply with WPS-B-T-3212-Tc-U5b-1.

NORTH TOWER LIFT 4 C/D CORNER SEAM

FCAW welding of weld joint 2B located on NSTL4-3L/L.

Welder is identified as 050289. ZPMC QC is identified as Mr. Deng Zhi Bing.

The welding variables recorded by QC appeared to comply with WPS-B-T-3212-Tc-U4b-1.

NORTH TOWER LIFT 4 D/E CORNER SEAM

FCAW welding of weld joint 1B located on NSTL4-3L/L.

Welder is identified as 052930. ZPMC QC is identified as Mr. Deng Zhi Bing.

The welding variables recorded by QC appeared to comply with WPS-B-T-3211-Tc-U4b-1.

SOUTH TOWER LIFT 4 A/B CORNER SEAM REPAIR

FCAW welding of weld joint 4B(Repair) located on SSSL4-1B/L.

Welder is identified as 048627. ZPMC QC is identified as Mr. Jiang Xiao Bo.

The welding variables recorded by QC appeared to comply with WPS-345-FCAW-1G(1F)-REPAIR.

BAY 11

INTERIOR SPLICE PLATE

FCAW welding of weld joint 2B located on WSD1-SPSA4-5.

Welder is identified as 040755. ZPMC QC is identified as Mr. Xu Jin Long.

The welding variables recorded by QC appeared to comply with WPS-B-T-2231-Tc-U5-F.

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

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

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 134-8257-0045, who represents the Office of Structural Materials for your project.

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Inspected By:	Gaikwad,Umesh	Quality Assurance Inspector
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Reviewed By:	Clifford,William	QA Reviewer
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