DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-011903
Date Inspected: 30-Jan-2010

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 645
OSM Departure Time: 1845
Location: Shanghai, China

CWI Name:	Zhao Chen Sun.			**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:

Heavy Dock(Tower Assembly), South Tower, Lift 1, Skin C, Bearing Stiffener(Inside Tower).

FCAW welding of Partial Penetration weld joint (PJP) SSD1-SA17F/G-23, 33; located on Heavy Dock(Tower Assembly), South Tower, Lift 1, Skin C. Welders are identified as 052075, 054069; ZPMC Quality Control Inspector (QC) is identified as Zhao Chen Sun. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2333-TC-P4-F.

Heavy Dock(Tower Assembly), South Tower, Lift 1, Skin B, Bearing Stiffener(Inside Tower).

FCAW welding of Partial Penetration weld joint (PJP) SSD1-SA18-13; located on Heavy Dock(Tower Assembly), South Tower, Lift 1, Skin B. Welders are identified as 057244; ZPMC Quality Control Inspector (QC) is identified as Zhao Chen Sun. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2333-TC-P4-F.

Heavy Dock(Tower Assembly), South Tower, Lift 1, Skin E, Bearing Stiffener(Inside Tower).

FCAW welding of Partial Penetration weld joint (PJP) SSD1-SA16F/G-84, 19, 20; located on Heavy Dock(Tower Assembly), South Tower, Lift 1, Skin E. Welders are identified as 201825, 040343, 040291; ZPMC Quality Control Inspector (QC) is identified as Zhao Chen Sun. The welding variables recorded by Quality Control

Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2333-TC-P4-F.

Heavy Dock(Tower Assembly), West Tower, Lift 1, Skin C & D, Bearing Stiffener(Inside Tower).

During the Quality Assurance (QA) random in-process visual inspection of West Tower Lift 1 Bearing Plate groove weld, this QA inspector observed ZPMC NDT Personnel performing Magnetic Particle Testing(MT) for Criticle weld Repair locations(CWR). This is Partial joint Penetration Joint(PJP). Weld Identified as

1) WSD1-SA295B/E-5. Skin D (CWR # T-CWR554).
2) WSD1-SA294F/G-12. Skin C (CWR # T-CWR557).

ZPMC NDT Personnel found Linear Indication Transverse to the weld axis on the welds.The attached photographs provide additional detail.

Heavy Dock(Tower Assembly), Tower, 47.6M Elevation, Strut connection angles.

During the Quality Assurance (QA) random in-process visual inspection this QA inspector observed ZPMC Heat straightened the Strut connection angle on 47.6M Elevation. the Strut connection angle is identified as ED1-SA183-47.6M-2.

The attached photographs provide additional detail.

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

WELDING INSPECTION REPORT

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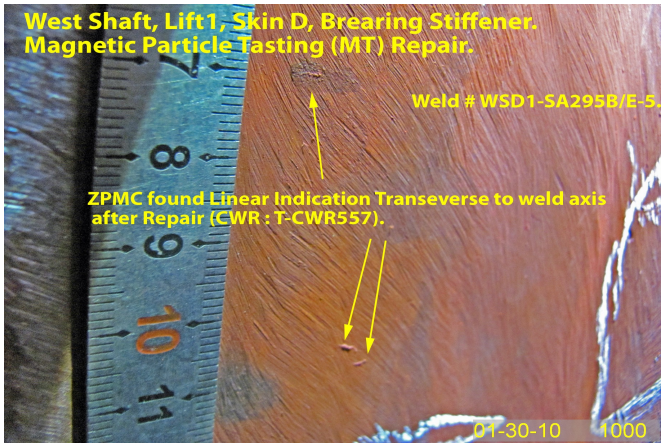

Summary of Conversations:

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.

Inspected By:	Juvekar,Amit	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer