

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-012530**Date Inspected:** 13-Feb-2010**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:** Mr. You Qi Guo**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 date Caltrans OSM Quality Assurance (QA) Inspector, Nagalingam Pandaram Pillai was present during the times noted above for observations relative to the work being performed.

Magnetic Particle Testing:-

TOWER TRAIL ASSEMBLY AREA:-

WEST SHAFT LIFT 1:-

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an MT report for this date. The member is identified as West Tower Lift 1 Interior Bearing Plate. The weld designations reviewed are as follows:-

WSD1-SA225-F/H-2,8,10,12,14,16,18,20,22,24.

IN PROCESS INSPECTION:-

TOWER TRAIL ASSEMBLY AREA:-

NORTH SHAFT LIFT 1:-

This QA inspector observed the following work in progress:

ZPMC performed Weld metal repair of Interior Bearing Plate located on Skin E (NSD1-SA76F/F-04). The weld

WELDING INSPECTION REPORT

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metal repair areas were approximately 2mm depth and 50mm length at 2 random locations. The material is A709M Grade 345 Non-SPCM. Welder is identified as 053829.ZPMC CWI is identified as Mr. You Qi Guo. SMAW welding was been performed. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-3G (3F)-Repair. Please see the attached pictures below.

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



Summary of Conversations:

No Relevant Conversation.

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 Skyler Guest - 15000422360, who represents the Office of Structural Materials for your project.

Inspected By:	Pillai,Pandaram	Quality Assurance Inspector
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Reviewed By:	Clifford,William	QA Reviewer
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