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-012913
Date Inspected: 04-Mar-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: 700
OSM Departure Time: 1900
Location: Shanghai,China

CWI Name:	Mr.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

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.

IN PROCESS INSPECTION:-
TOWER TRAIL ASSEMBLY AREA:-

EAST SHAFT LIFT 1:-

This QA inspector observed the following work in progress:
FCAW welding of weld joint no: ESD1-SA237D/F-1 located on Skin A Interior Bearing Stiffener. Welder is identified as 059525.ZPMC QC is identified as Mr. Yang Ming Ming. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

This QA inspector observed the following work in progress:
FCAW welding of weld joint no: ESD1-SA296B/E-13 located on Skin D Exterior Bearing Stiffener. Welder is identified as 040703.ZPMC QC is identified as Mr. Yang Ming Ming. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

WEST SHAFT LIFT 1:-

This QA inspector observed the following work in progress:

FCAW welding of weld joint no: ESD1-SA294F/G-56 located on Skin C Exterior Bearing Stiffener. Welder is identified as 040736.ZPMC QC is identified as Mr. Sun Zi wang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

This QA inspector observed the following work in progress:
FCAW welding of weld joint no: ESD1-SA295B/E-22 located on Skin C Exterior Bearing Stiffener. Welder is identified as 040723.ZPMC QC is identified as Mr. Sun Zi wang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

WEST SHAFT LIFTS 1&2:-

This QA inspector carried out the dimension measurements of Gap and misalignment of Interior splice plates between West tower Lift 1 and Lift 2 from inside. The same was measured from Top and bottom side of interior splice plates over the Longitudinal stiffeners of Skin A, B, C, D and E. The maximum Gap between stiffener to Interior splice plate on both top and bottom found to be 9.8mm and the minimum found to be 0mm. The maximum misalignment between stiffener to Interior splice plate on both top and bottom found to be 12 mm and the minimum found to be 0.5 mm. The readings are recorded on the data sheet and submitted to the Lead Inspector.

NORTH SHAFT LIFT 1:-

This QA inspector observed the following work in progress:
FCAW welding of weld joint no: NSD1-SA22B/E-12 located on Skin D Exterior Bearing Stiffener. Welder is identified as 040533.ZPMC QC is identified as Mr. Qiu Wen. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

This QA inspector observed the following work in progress:
FCAW welding of weld joint no: NSD1-SA11-28 located on Skin B Exterior Bearing Stiffener. Welder is identified as 053869.ZPMC QC is identified as Mr. Qiu Wen. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

This QA inspector observed the following work in progress:
ZPMC performed Base metal repair of Interior Bearing Stiffener located on Skin C (NSD1-SA17 F/G-24, 26). The weld metal repair areas were approximately 3mm depth and app.120mm length at 2 random locations. The material is A 709M Grade 345 Non-SPCM. Welder is identified as 050038.ZPMC CWI is identified as Mr. Zhao Chen Sun. SMAW welding was been performed against Critical Weld repair report T-CWR594. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-3G(3F)-Repair.

SOUTH SHAFT LIFT 1:-

This QA inspector observed the following work in progress:
FCAW welding of weld joint no: SSD1-SA17F/G-67 located on Skin C Exterior Bearing Stiffener. Welder is identified as 053116.ZPMC QC is identified as Mr. Liu Zhi. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

WELDING INSPECTION REPORT

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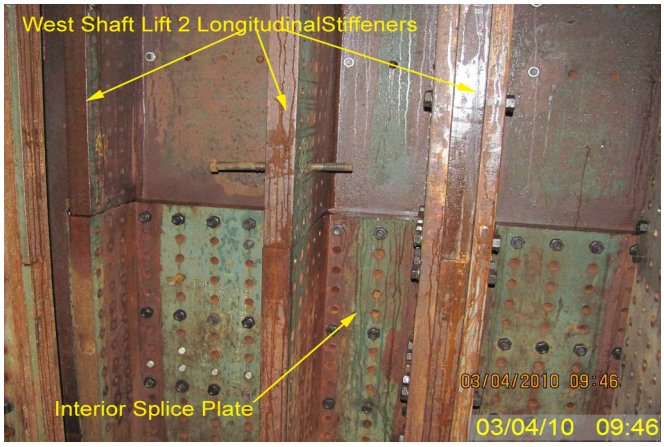
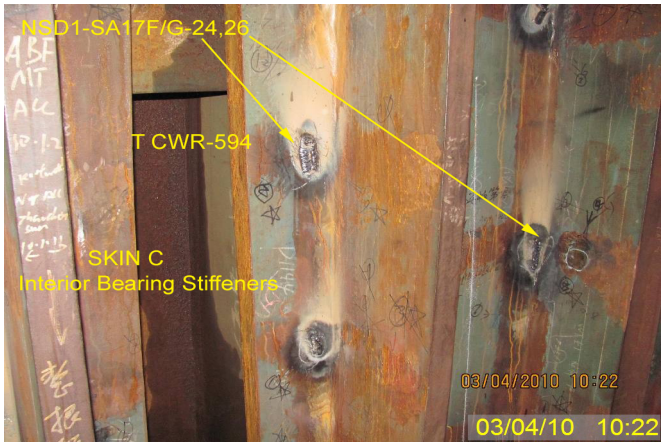
This QA inspector observed the following work in progress:
FCAW welding of weld joint no: SSD1-SA18-9 located on Skin B Exterior Bearing Stiffener. Welder is identified as 057180.ZPMC QC is identified as Mr. Liu Zhi. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

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
Reviewed By:	Clifford,William	QA Reviewer