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-012921
Date Inspected: 13-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.Ye Yong Jun			**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 Shaft Lift 1 Bearing Stiffeners on Skin C . The weld designations reviewed are as follows:-

WSD1-SA294F/G-50,53,56,59

NORTH 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 North Shaft Lift 1 Bearing Stiffeners on Skin B. The weld designations reviewed are as follows:-

NSD1-SA11-19,22,25,28,31,34

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-SA233-26 located on Skin B Bearing Stiffener. Welder is identified as 066683.ZPMC QC is identified as Mr. Xing shi shun. 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-SA233-32 located on Skin B Bearing Stiffener. Welder is identified as 067947.ZPMC QC is identified as Mr. Xing shi shun. 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-SA227F/H-19 located on Skin E Bearing Stiffener. Welder is identified as 040723.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-SA227F/H-9 located on Skin E 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.

WEST SHAFT LIFT 1:-

This QA inspector observed the following work in progress:
FCAW welding of weld joint no: WSD1-SA279-22 located on Skin B Bearing Stiffener. Welder is identified as 040704.ZPMC QC is identified as Mr. Fu Wei min. 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: WSD1-SA279-28 located on Skin B Bearing Stiffener. Welder is identified as 040609.ZPMC QC is identified as Mr. Fu Wei min. 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: WSD1-SA653D/F-10 located on Skin A Bearing Stiffener. Welder is identified as 049541.ZPMC QC is identified as Mr. Fu Wei min. 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: WSD1-SA225F/H-34 located on Skin E Bearing Stiffener. Welder is identified as 042218.ZPMC QC is identified as Mr. Fu Wei min. 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: WSD1-SA225F/H-49 located on Skin E Bearing Stiffener. Welder is identified as 046706.ZPMC QC is identified as Mr. Fu Wei min. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

SOUTH SHAFT LIFT 1:-

This QA inspector observed the following work in progress:
FCAW welding of weld joint no: SSD1-SA40B/E-51 located on Skin D Bearing Stiffener. Welder is identified as 040261.ZPMC QC is identified as Mr. Liu wei zhao. 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: SSD1-SA40B/E-45 located on Skin D Bearing Stiffener. Welder is identified as 057266.ZPMC QC is identified as Mr. Liu wei zhao. 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: SSD1-SA18-22 located on Skin B Bearing Stiffener. Welder is identified as 052075.ZPMC QC is identified as Mr. Liu wei zhao. 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: SSD1-SA18-29 located on Skin B Bearing Stiffener. Welder is identified as 057180.ZPMC QC is identified as Mr. Liu wei zhao. 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.

WELDING INSPECTION REPORT

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