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-013045
Date Inspected: 20-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.Tu Jun/Li Lin

CWI Present: ☑ Yes ☐ No

	Yes	No	N/A
Inspected CWI report:	☐	☑	☐
Electrode to specification:	☑	☐	☐
Qualified Welders:	☑	☐	☐
Approved Drawings:	☑	☐	☐

	Yes	No	N/A
Rod Oven in Use:	☑	☐	☐
Weld Procedures Followed:	☑	☐	☐
Verified Joint Fit-up:	☑	☐	☐
Approved WPS:	☑	☐	☐
Delayed / Cancelled:	☐	☑	☐

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.

Ultrasonic Testing:-

BAY # 10:-

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an UT report for this date. The member is identified as Tower Lift 5 Grillage Plate. The weld designations reviewed are as follows:

NSD1-TL5-3B-F-19A/B
NSD1-TL5-3B-F-6A/B

BAY # 11:-

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an UT report for this date. The member is identified as East Shaft Lift 4”AE” Corner Seam. The weld designations reviewed are as follows:

ESTL4-2B/L-60A/B
ESTL4-2L/L-5A/B

Magnetic Particle Testing:-

BAY #11:-

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 Connecting Angle Plate. The weld designations reviewed are as follows:-

WD1-SA3-18-89M-1,3,4,5,6,7,8-1A/B
SD1-SA3-16-99M-1,2,3,4-1A/B
SD1-SA3-16-109M-1,2,3,4-1A/B

IN PROCESS INSPECTION:-
BAY #10:-

This QA inspector observed the following work in progress:
FCAW welding of weld joint no: NSTL4-3D/L-38 located on Diagonal Splice Plate of “CD” Corner. Welder is identified as 053870.ZPMC CWI is identified as Mr.Tu Jun. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U2a-F-1.

This QA inspector observed the following work in progress:
FCAW welding of weld joint no: NSTL4-3D/L-2 located on Diagonal Splice Plate of “CD” Corner. Welder is identified as 066763.ZPMC QC is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U2a-F-1.

This QA inspector observed the following work in progress:
SAW welding of weld joint no: SD1-A112A/H-1A located on Shear Plate. Welder is identified as 040414.ZPMC QC is identified as Mr. Yu zhi lai. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-B-U3c-S-2.

BAY #11:-
This QA inspector observed the following work in progress:
FCAW welding of weld joint no: WSTL4-2D/L-18 located on Diagonal Splice Plate of “BC” Corner. Welder is identified as 040759.ZPMC CWI is identified as Mr.Li Lin. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U2a-F-1.

This QA inspector observed the following work in progress:
FCAW welding of weld joint no: WSTL4-2D/L-46 located on Diagonal Splice Plate to Skin “BC”. Welder is identified as 046706.ZPMC QC is identified as Mr. Xu Jin Xiang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U2a-F-1.

This QA inspector observed the following work in progress:
SMAW welding of weld joint no: SD1-SA4-56-131M-4-1A located on Connecting Angle Plate. Welder is identified as 040667.ZPMC CWI is identified as Mrs.Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS-B-T-3211-TC-U5b-1.

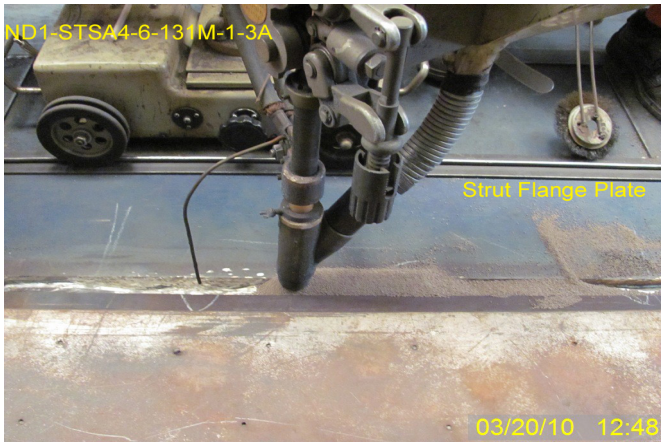
This QA inspector observed the following work in progress:

SAW welding of weld joint no: SD1-STSA4-5-119M-1-2B located on Strut Flange Plate. Welder is identified as 044560.ZPMC CWI is identified as Mr. An Qing Xiang. The welding variables recorded by QC appeared to comply with the WPS-B-T-4221-B-U3c-S-1.

This QA inspector observed the following work in progress:
SMAW welding of weld joint no: SD1-SA4-56-131M-1-1A located on Connecting Angle Plate. Welder is identified as 040614.ZPMC QC is identified as Mr. Mao Bin Bin. The welding variables recorded by QC appeared to comply with the WPS-B-T-3211-TC-U2b-1.

This QA inspector observed the following work in progress:
SAW welding of weld joint no: ND1-STSA4-6-131M-1-3A located on Strut Flange Plate. Welder is identified as 040699.ZPMC CWI is identified as Mr. An Qing Xiang. The welding variables recorded by QC appeared to comply with the WPS-B-T-4221-B-U3c-S-1.

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