

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-013522**Date Inspected:** 01-Apr-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:** 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 Components**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

Tower Trial Assembly

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 005452

Visual Inspection Testing (VT)

This QA inspector performed VT of the area previously tested and accepted by ZPMC Quality Control personnel. The member is identified as Tower Component. The identified component and weld designations reviewed are as follows:

NORTH TOWER LIFT-1 HAND RAIL WELDS

1. E74-18M-17~19-N
2. E74-23M-14~19-N
3. E74-28M-17~19-N
4. E74-33M-17~19-N
5. E74-38M-17~19-N
6. E74-43M-17~19-N

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WEST TOWER LIFT-1 HAND RAIL WELDS

1. E74-18M-14~16-W
2. E74-23M-14~16-W
3. E74-28M-14~16-W
4. E74-33M-14~16-W
5. E74-38M-14~16-W
6. E74-43M-14~16-W

EAST TOWER LIFT-1 HAND RAIL WELDS

1. E74-23M-8~13-E
2. E74-28M-8~13-E
3. E74-33M-8~13-E
4. E74-38M-8~13-E
5. E74-43M-8~13-E

Magnetic Particle Testig (MT)

This QA inspector performed 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 Tower Component. The weld designation reviewed as follows:

NORTH TOWER LIFT-1 HAND RAIL WELDS

1. E74-18M-17-N
2. E74-18M-18-N

WEST TOWER LIFT-1 HAND RAIL WELDS

1. E74-23M-15-W
2. E74-23M-16-W

EAST TOWER LIFT-1 HAND RAIL WELDS

1. E74-23M-8-E
2. E74-23M-9-E
3. E74-23M-11-E
4. E74-23M-12-E

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW):

Weld joint # 042 located on North Tower Lift-1 Bearing stiffener Plate NSD1 – SA17F/G. Welder is identified as 052075. ZPMC Quality Control (QC) Inspector is identified as You Qi Guo. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2333 – Tc – P4 – F.

Weld joint # 005 located on North Tower Lift-1 Bearing stiffener Plate WSD1 – SA279. Welder is identified as 049220. ZPMC Quality Control (QC) Inspector is identified as Fu Wei Min. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2333 – Tc – P4 – F.

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Weld joint # 074 located on North Tower Lift-1 Bearing stiffener Plate NSD1 – SA17F/G. Welder is identified as 053116. ZPMC Quality Control (QC) Inspector is identified as You Qi Guo. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2333 – Tc – P4 – F.

Weld joint # 015 located on North Tower Lift-1 Bearing stiffener Plate WSD1 – SA225F/H. Welder is identified as 040706. ZPMC Quality Control (QC) Inspector is identified as Fu Wei Min. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2333 – Tc – P4 – F.
(See attached photo)

MEASUREMENTS ON VERTICAL TRIAL ASSEMBLY EAST TOWER LIFT-1

This QA Inspector carried out the measurements on East Tower Lift-1 Inside to check the gap from the edge of the base plate anchor bolt holes to the side of the bearing, type-1&2 stiffeners for skin ‘A’, ‘B’, ‘C’, ‘D’ & ‘E’. Measurements were recorded on the data sheet and submitted to the assigned task leader.

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



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

Inspected By:	Kumar,Sandeep	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
