

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-013527**Date Inspected:** 07-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:** Gong Liang Zhu**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. 005481

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:

SOUTH TOWER SKIN 'D' EXTERNAL BEARING STIFFENER

SSD1 – SA40B/E – 32; 36; 39; 42; 45; 51

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:

SOUTH TOWER SKIN 'D' EXTERNAL BEARING STIFFENER

SSD1 – SA40B/E – 32; 36; 39; 42; 45; 51

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This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW):

Weld joint # 030 located on East Tower Lift-1 outside bearing stiffener Plate ESD1 – SA227F/H. Welder is identified as 049541. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2333 – Tc – P4 – F.

Weld joint # 006 located on West Tower Lift-1 Bearing stiffener WSD1 – SA295B/E. Welder is identified as 205649. ZPMC Quality Control (QC) Inspector is identified as Wang Chuang Xin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2233 – Tc – U5 – F.

(See attached photo)

Weld joint # 029 located on North Tower Lift-1 inside bearing stiffener Plate NSD1 – SA22B/E. Welder is identified as 040533. ZPMC Quality Control (QC) Inspector is identified as Yang Min Min. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2333 – Tc – P4 – F.

(See attached photo)

Weld joint # 001 located on West Tower Lift-1 Bearing stiffener WSD1 – SA279. Welder is identified as 040736. ZPMC Quality Control (QC) Inspector is identified as Wang Chuang Xin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2233 – Tc – U5 – F.

Weld joint # 045 located on East Tower Lift-1 outside bearing stiffener Plate ESD1 – SA227F/H. Welder is identified as 040704. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2333 – Tc – P4 – F.

MEASUREMENTS ON VERTICAL TRIAL ASSEMBLY TOWER LIFT-1&2

This QA Inspector carried out the measurements along with the ABF QA Inspector Bi Duwei on South, East, West and North Tower locations exterior side of Lift – 1&2 to check faying surface between splice plate and the 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.



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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
