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-013536
Date Inspected: 19-Apr-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: Zhao Chen Sun

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

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

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. 005548
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 BEARING PLATE
NSD1 – SA33D/F – 01; 03; 05
NSD1 – SA11 – 01; 03; 13; 15
NSD1 – SA17F/G – 09; 11; 19; 21; 31; 33
NSD1 – SA22B/E – 28; 29
NSD1 – SA76F/H – 03; 05; 11; 13; 19; 21

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 BEARING PLATE

NSD1 – SA33D/F – 01; 03; 05

NSD1 – SA11 – 01; 03; 13; 15

NSD1 – SA17F/G – 09; 11; 19; 21; 31; 33

NSD1 – SA22B/E – 28; 29

NSD1 – SA76F/H – 03; 05; 11; 13; 19; 21

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW):

Weld joint # 031 located on East Tower Lift-1 Bearing stiffener ESD1 – SA227F/H. Welder is identified as 053316. 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.

Weld joint # 043 located on South Tower Lift-1 Bearing stiffener SSD1 – SA16F/G. Welder is identified as 040533. 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.

Weld joint # 052 located on East Tower Lift-1 Bearing stiffener ESD1 – SA227F/H. Welder is identified as 042218. 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.

Weld joint # 049 located on South Tower Lift-1 Bearing stiffener SSD1 – SA16F/G. Welder is identified as 053869. 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)

SHEAR PLATE INSTALLATION:

Shear plate # WD1-A25A/E installing on vertical trial assembly between West and South Tower Lift-1 at B/C corners.
(See attached photo)

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

WELDING INSPECTION REPORT

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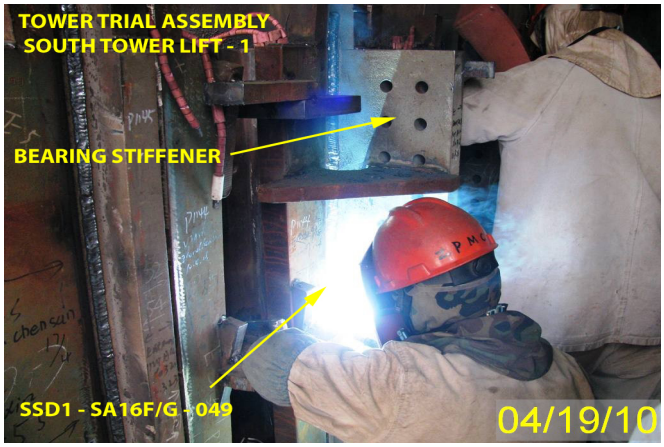

Summary of Conversations:

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