

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-013667**Date Inspected:** 15-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:** Mr. Tu Jun/Li Lin**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:-**BAY #10:-**

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 Skirt Plate. The weld designations reviewed are as follows:-

SSD1-A434D/D-33,46,47,48,49,50,51,56,70

NSD1-A802D/D-33,46,47,48,49,50,51,56,80

SSD1-A434A/D-14

NSD1-A802A/D-14

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 Strut Plate. The weld designations reviewed are as follows:-

WD1-STSA4-5-139M-1-21,22A/B

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SD1-STSA4-5-139M-1-21,22A/B
WD1-STSA4-5-135M-1-21,22A/B
SD1-STSA4-5-139M-1-1,3A/B
WD1-STSA4-5-139M-1-21,22A/B
SD1-STSA4-5-143M-1-1,3A/B
WD1-STSA4-5-143M-1-1,3A/B
WD1-STSA4-5-143M-1-2,4A/B
WD1-STSA4-5-127M-1-2,4A/B
SD1-STSA4-5-131M-1-2,4A/B
WD1-STSA4-5-131M-1-2,4A/B
SD1-STSA4-5-135M-1-2,4A/B
WD1-STSA4-5-135M-2,4A/B

IN PROCESS INSPECTION:-

BAY #10:-

This QA inspector observed the following work in progress:

FCAW welding of weld joint no: WD1-SSA3-30-4 located on Façade Buildup Channel. Welder is identified as 040349.ZPMC QC is identified as Mr.Zhu Zhung jie. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132.

This QA inspector observed the following work in progress:

ZPMC performed Buttering on South Tower 146m Connect Stiffener (SSD1-SPSA5-16-LS5-9).The Buttering area is 6 to 8mm thick. The material is A 709M Grade 485 Non-SPCM. Welder is identified a 056200.ZPMC CWI is identified as Mr. Du Zhiqun. SMAW welding was been performed against Critical Weld repair report T-CWR612. The welding variables recorded by QC appeared to comply with the WPS-485-SMAW-2G(2F)-Repair-1.Please see the attached picture.

BAY #11:-

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: WD1-SA4-56-139M-1-1B located on Connecting Angle Plate. Welder is identified as 046704.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:

SMAW welding of weld joint no: ND1-STSA4-6-123M-2-10A located on Strut Plate. Welder is identified as 040667.ZPMC CWI is identified as Mr.Mao Bin Bin. The welding variables recorded by QC appeared to comply with the WPS-B-T-2212-TC-U5b-1.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: ED1-STSA4-6-127M-2-5A located on Strut Plate. Welder is identified as 044541.ZPMC QC is identified as Mr.Mao Bin Bin. The welding variables recorded by QC appeared to comply

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with the WPS-B-T-3212-TC-U5b.

This QA inspector observed the following work in progress:

SAW welding of weld joint no: WSD1-TL5-4B/F-10A located on Lift 5 Grillage Plate. Welder is identified as 044560.ZPMC QC is identified as Mr.Xu Jie. The welding variables recorded by QC appeared to comply with the WPS-B-T-3221-U3c-S-1.Please see the attached picture.

This QA inspector observed the following work in progress:

SAW welding of weld joint no: WSD1-TL5-4B/F-9B located on Lift 5 Grillage Plate. Welder is identified as 047304.ZPMC QC is identified as Mr.Xu Jie. The welding variables recorded by QC appeared to comply with the WPS-B-T-3221-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
