

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-013680**Date Inspected:** 08-Mar-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:** Xu Le Feng**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. 005280

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 reviewed as follows:

WEST TOWER LIFT 1 SKIN 'A' EXTERNAL BEARING PLATE

1. WSD1 – SA653D/F – 11; 42

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 designations reviewed are as follows:

WEST TOWER LIFT 1 SKIN 'A' EXTERNAL BEARING PLATE

1. WSD1 – SA653D/F – 11; 42

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

BAY 10

This QA Inspector observed the following work in progress:

Sub-Merged Arc Welding (SAW):

Weld joint # 21A located on Grillage Plate SSD1 – TL5 – 1B – F. Welder is identified as 040252. ZPMC Quality Control (QC) Inspector is identified as Yu Zhi Zai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3221 – B – U3c – S – 1.

Flux Core Arc Welding (FCAW):

Weld joint # 025 located on North Tower Lift-1 Skirt Extension Block NSD1 – A802D/D. Welder is identified as 050275. ZPMC Quality Control (QC) Inspector is identified as Jiang Xiao Bo. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2332 – Tc – P4 – F.

Surface welding / weld build up being performed according to the weld repair report #T-WR3083 located on Grilled Plate Stiffener # SSD1 – TL5 – 1A – F – TD5 - 9. Welder is identified as 500363. ZPMC Quality Control (QC) Inspector is identified as Deng Zhi Bing. The welding variables recorded by QC appeared to comply with the WPS – 485 – SMAW – 2G (2F) – Repair – 1.

Weld joint # 032 located on North Tower Lift-1 Skirt Extension Block SSD1 – A434D/D. Welder is identified as 050275. ZPMC Quality Control (QC) Inspector is identified as Jiang Xiao Bo. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2332 – Tc – P4 – F.

(See attached Photo)

BAY 11

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW):

Weld joint # 32B located on West Tower Lift-5 A/B corner WSD1 – TL5 – 4B – F. Welder is identified as 046704. ZPMC Quality Control (QC) Inspector is identified as Shao Hai Lang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3212 – Tc – U4b – 1.

Repair welding of a weld joint # 60A according to the weld repair report #T-WR-2971 located on West Tower Lift-4 A/E corner. Welder is identified as 040733. ZPMC Quality Control (QC) Inspector is identified as Mao Mao Zhao. The welding variables recorded by QC appeared to comply with the WPS – 345 – SMAW – 1G (1F) – Repair.

Weld joint # 5-1A located on Strut Connection Plate WSD1 – TL5 – 4B – F. Welder is identified as 040667. ZPMC Quality Control (QC) Inspector is identified as Mao Bin Bin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3211 – Tc – U5b – 1.

(See attached Photo)

Weld joint # 21B located on West Tower Lift-5 A/B corner WSD1 – TL5 – 4B – F. Welder is identified as 049099. ZPMC Quality Control (QC) Inspector is identified as Shao Hai Lang. The welding variables recorded by

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

QC appeared to comply with the WPS – B – T – 3212 – Tc – U4b – 1.

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
