

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-013749**Date Inspected:** 10-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.

BAY 10

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 005307

Ultrasonic Testing (UT)

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member is identified as Tower Component. The weld designations reviewed are as follows:

NORTH TOWER LIFT 4 CD CORNER SEAM DOUBLE DIAPHRAGM POSITION

1. NSTL4 – 3B/L – 1B

NORTH TOWER LIFT 4 BC CORNER SEAM SINGLE & DOUBLE DIAPHRAGM POSITION

1. NSTL4 – 3B/L – 5B

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW):

Repair welding of base material according to the weld repair report #T-WR-3033 located on North Tower Lift-4 Skin'E'. Welder is identified as 040582. ZPMC Quality Control (QC) Inspector is identified as Wang Hao. The

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welding variables recorded by QC appeared to comply with the WPS – 345 – SMAW – 2G (2F) – Repair.
(See attached photo)

Due to the reduction in length after Heat Straightening. Surface welding / weld build up being performed according to the weld repair report #T-WR3074 located on East Tower Shearing Plate # ED1 – A27. Welder is identified as 500363. ZPMC Quality Control (QC) Inspector is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS – 345 – SMAW – 3G (3F) – Repair. (See attached Photo)

BAY 11

This QA Inspector observed the following work in progress:

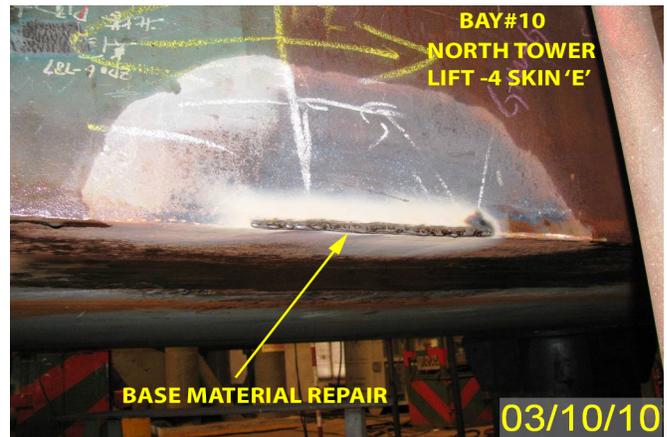
Shielded Metal Arc Welding (SMAW):

Weld joint # 2-1A located on Strut Connection Plate SD1 – SA4– 56 – 123M. 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.

Sub-Merged Arc Welding (SAW):

Weld joint # 4-1B located on Strut Connection Plate SD1 – STSA4 – 6 – 135. Welder is identified as 040699. 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 – 3221 – Tc – U5 – S – 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.

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