

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-013756**Date Inspected:** 19-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. 005381

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 designation reviewed as follows:

NORTH TOWER LIFT 4 TRIANGULAR PLATE AT 116.33M DIAPHRAGM ON CD CORNER

1. NSTL4 – 3B/L – 21; 23

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 005377

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 designation reviewed as follows:

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INTERNAL SIDE WELDS OF TOWER SKIRT PLATE

1. SD1 – A440E/E – 37; 38
2. ND1 – A501E/E – 36; 37
3. SD1 – A712A/F – 6; 20

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:

INTERNAL SIDE WELDS OF TOWER SKIRT PLATE

1. SD1 – A440E/E – 37; 38
2. ND1 – A501E/E – 36; 37
3. SD1 – A712A/F – 6; 20

Flux Core Arc Welding (FCAW):

Weld joint # 12 located on North Tower Lift 4 Diagonal Plate at CD corner NSTL4 – 3D/L. Welder is identified as 057180. ZPMC Quality Control (QC) Inspector is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2233 – B – U2a – F – 1.

Weld joint # 45 located on North Tower Lift 4 Diagonal Plate at CD corner NSTL4 – 3D/L. Welder is identified as 040432. ZPMC Quality Control (QC) Inspector is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2233 – B – U2a – F – 1.

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 WD1 – SA4– 56 – 131M. Welder is identified as 040667. ZPMC Quality Control (QC) Inspector is identified as Liu Dao Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3211 – Tc – U5b – 1.

Weld joint # 3-1A located on Strut Connection plate SD1 – SA4– 56 – 139M. Welder is identified as 046704. ZPMC Quality Control (QC) Inspector is identified as Liu Dao Feng. 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 # 6B located on West Tower Lift 5 D/E Corner WSD1 – TL5 – 4B/F. Welder is identified as 040699. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3221 – C – U2b – S. (See attached photo)

Flux Core Arc Welding (FCAW):

Weld joint # 7 located on West Tower Lift 4 Diagonal Plate at CD corner WSTL4 – 2B/L. Welder is identified as 053316. ZPMC Quality Control (QC) Inspector is identified as Xu Jin Long. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – P4 – F.

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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
