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-013760
Date Inspected: 18-Mar-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: Xu Le Feng

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

CWI Present:	☑ Yes	☐ No	
Rod Oven in Use:	☑ Yes	☐ No	☐ N/A
Weld Procedures Followed:	☑ Yes	☐ No	☐ N/A
Verified Joint Fit-up:	☑ 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. 005372

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 CD CORNER SEAM TOWER BOTTOM TO 119M DIAPHRAGM BOTTOM
1. NSTL4 – 3B/L – 1B

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 4 CD CORNER SEAM TOWER BOTTOM TO 119M DIAPHRAGM BOTTOM

1. NSTL4 – 3B/L – 1B

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-3097 located on Stiffener Connection Plate SA4-49. Welder is identified as 040268. ZPMC Quality Control (QC) Inspector is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS – 485 – SMAW – 2G (2F) – Repair.
(See attached photo)

Flux Core Arc Welding (FCAW):
Weld joint # 55 located on North Tower Lift 4 NSTL4 – 3D/L. Welder is identified as 052075. ZPMC Quality Control (QC) Inspector is identified as Wang Hao. 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 # 1-1A located on Strut Connection plate ED1 – SA4– 69 – 119M. Welder is identified as 040656. 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 ED1 – SA4– 69 – 119M. 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.
(See attached photo)

Weld joint # 4-1A located on Strut Connection plate SD1 – 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.

Sub-Merged Arc Welding (SAW):
Weld joint # 1-2B located on Strut Plate WD1 – STSA4 – 5 – 123M. Welder is identified as 044560. ZPMC Quality Control (QC) Inspector is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS – B – T – 4221 – B – U3c – S – 1.

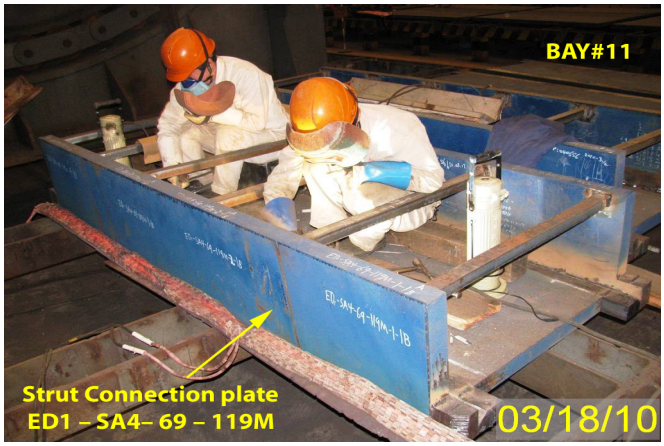
Weld joint # 2-1A located on Strut Plate ED1 – STSA4 – 65 – 127M. Welder is identified as 040699. ZPMC Quality Control (QC) Inspector is identified as Mao Bin Bin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 4221 – B – U3c – S – 1.

Weld joint # 1-2B located on Strut Plate SD1 – STSA4 – 5 – 119M. Welder is identified as 044560. ZPMC Quality Control (QC) Inspector is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS – B – T – 4221 – B – U3c – S – 1.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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