

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-014150**Date Inspected:** 13-May-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. An Qing Xiang/Gao Shi Shun			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:-

OUTSIDE YARD:-

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 Tower Handrails. The weld designations reviewed are as follows:-

SSD1-RA4-6
SSD1-RA4-40
SSD1-RA4-3
SSD1-RA4-27
SSD1-RA4-30
SSD1-RA4-43
SSD1-RA4-22
ESD1-RA4-17
ESD1-RA4-44

IN PROCESS INSPECTION:-

BAY #11:-

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: ND1-STSA4-6-143M-2-74A located on Strut Plate. Welder is identified as 040724.ZPMC QC is identified as Mr.Mao Bin Bin. The welding variables recorded by QC appeared to comply with the WPS-B-T-3212-TC-U5b-1.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: ED1-STSA4-6-143M-1-10B located on Strut Plate. Welder is identified as 044551.ZPMC QC is identified as Mr.Mao Bin Bin. The welding variables recorded by QC appeared to comply with the WPS-B-T-2212-TC-U5b.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: ED1-STSA4-6-143M-1-5B located on Strut Plate. Welder is identified as 044551.ZPMC QC is identified as Mr.Mao Bin Bin. The welding variables recorded by QC appeared to comply with the WPS-B-T-3212-TC-U5b-1.

This QA inspector observed the following work in progress:

FCAW welding of weld joint no: SD1-A23A/B-31 located on Bearing stiffener Plate. Welder is identified as 040649.ZPMC QC is identified as Mr.Shao Hai Lang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2331-TC-P4-F.Please see the attached picture.

This QA inspector observed the following work in progress:

FCAW welding of weld joint no: WD1-A25B/E-10 located on Bearing stiffener Plate. Welder is identified as 040723.ZPMC QC is identified as Mr.Shao Hai Lang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2331-TC-P4-F.

This QA inspector observed the following work in progress:

FCAW welding of weld joint no: ED1-A29A/B-33 located on Bearing stiffener Plate. Welder is identified as 040725.ZPMC QC is identified as Mr.Shao Hai Lang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2331-TC-P4-F.

This QA inspector observed the following work in progress:

ZPMC performed Buttering on Outside Diaphragm at 13M elevation (WD1-A21).The Buttering area is 11mm thick. The material is A 709M Grade 345 Non-SPCM. Welder is identified a 053870.ZPMC QC is identified as Mr. Deng Zhi Bing. FCAW welding was been performed against Weld repair report T-WR3226. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-2G (2F)-Repair.

BAY #10:-

SMAW welding of weld joint no: SSD1-TL5-1B-F-35B located on Lift 5 Grillage Plate. Welder is identified as 500363.ZPMC CWI is identified as Mr.Gao Shi Shun. The welding variables recorded by QC appeared to comply with the WPS-B-T-3213-B-U3b.Please see the attached picture.

SMAW welding of weld joint no: SSD1-TL5-1B-F-2B located on Lift 5 Grillage Plate. Welder is identified as

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

500373.ZPMC CWI is identified as Mr.Gao Shi Shun. The welding variables recorded by QC appeared to comply with the WPS-B-T-3213-B-U3b.

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
