

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-014401**Date Inspected:** 23-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. Zhao Chen Sun/An Qing Xian			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.

Ultrasonic Testing:-

TRAIL ASSEMBLY AREA:-

SOUTH SHAFT LIFT1

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 South Shaft Lift 1 Corner Seam. The weld designations reviewed are as follows:-

Temporary attachment removal area Top Side(600mm Length)

AE Corner- SSD1-A164E/J-242A/B

BC Corner- SSD1-A164E/J-245A/B

CD Corner- SSD1-A164E/J-244A/B

Temporary attachment removal area Bottom Side (1880mm Length)

BC Corner-SSD1-A111B/H-127A/B

CD Corner-SSD1-A111B/H-126A/B

IN PROCESS INSPECTION:-

TRAIL ASSEMBLY AREA:-

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This QA inspector observed the following work in progress:

SMAW welding of weld joint no: B22-2-EL-80.58M-1-1-N located on North Shaft Lift 2 Cable Tray Support. Welder is identified as 500331.ZPMC QC is identified as Mr.Zhu Feng. The welding variables recorded by QC appeared to comply with the WPS-B-P-2112.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: B22-2-EL-65.731M-2-2-S located on South Shaft Lift 2 Cable Tray Support. Welder is identified as 053049.ZPMC QC is identified as Mr.Zhu Feng. The welding variables recorded by QC appeared to comply with the WPS-B-P-2114.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: SSD1-SA16E/G-8 located on South Shaft Lift 1 Façade Plate. Welder is identified as 053049.ZPMC CWI is identified as Mr.Zhao Chen Sun. The welding variables recorded by QC appeared to comply with the WPS-B-T-2131.

BAY#11:-

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: ND1-STSA4-6-123M-1-71 located on Strut Plate. Welder is identified as 041271.ZPMC QC is identified as Mr.Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with the WPS-B-T-2112.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: ND1-STSA4-6-127M-1-43 located on Strut Plate. Welder is identified as 044551.ZPMC QC is identified as Mr. Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with the WPS-B-T-2113.

This QA inspector observed the following work in progress:

FCAW welding of weld joint no: ED1-A29A/B-72 located on Shear Plate Bearing Stiffener. Welder is identified as 049541.ZPMC QC is identified as Mr.Xu Jie. 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-63 located on Shear Plate Bearing Stiffener. Welder is identified as 053486.ZPMC QC is identified as Mr.Xu Jie. 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-74 located on Shear Plate Bearing Stiffener. Welder is identified as 040704.ZPMC QC is identified as Mr.Xu Jie. 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-60 located on Shear Plate Bearing Stiffener. Welder is identified as 040759.ZPMC QC is identified as Mr.Xu Jie. The welding variables recorded by QC appeared to comply with

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the WPS-B-T-2331-TC-P4-F.

During random visual inspection in Bay 11, this Quality Assurance Inspector (QA) discovered the following issue:

- Two (2) angle plates in the top elevation of Shear Plate were damaged and distorted.
- The welds are identified as WD1-A25B/E-174,187; fillet weld.
- Tower Lift 1 Shear Plate WD1-A25.
- The member is located in Bay#11.
- These angle plates were previously VT and MT tested.
- The Notice of Witness Inspection Number (NWIT) is 005762.

For further information, please see the attached pictures:

Unless otherwise noted, all work observed on this date appeared to generally comply with the applicable contract documents.

Summary of Conversations:

The incident report is issued for the above mentioned discrepancy observed in Bay#11 and prior to issue it was informed to ZPMC QC and ABF QA.



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

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your project.

Inspected By:	Pillai, Pandaram	Quality Assurance Inspector
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Reviewed By:	Clifford, William	QA Reviewer
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