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-014411
Date Inspected: 25-May-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: Mr.An Qing Xiang

Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**CWI Present:**	☑ Yes	☐ No	
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ 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

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:-
Bay#11
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 West Tower Lift 4 Fit Lug of Skin A,B,C,D,E and back fill Plate. The weld designations reviewed are as follows:-

WSTL4-F/L-60,119
WSTL4-G/L-57,121,8,9,10,11,19,20,33,34,38,56,60,61,63,84,85,91,92,100,101,102,105,106,126,128,130.

IN PROCESS INSPECTION:-
Bay#11
This QA inspector observed the following work in progress:
FCAW welding of weld joint no: WD1-A25B/B-84 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.Please see the attached picture.

This QA inspector observed the following work in progress:

FCAW welding of weld joint no: WD1-A25B/B-81 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: WD1-A25B/B-73 located on Shear Plate Bearing Stiffener. Welder is identified as 040723.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: WD1-A25B/B-76 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.Please see the attached picture.

This QA inspector observed the following work in progress:
SMAW welding of weld joint no: ND1-STSA4-6-127M-1-83 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-2113.

This QA inspector observed the following work in progress:
SMAW welding of weld joint no: ND1- STSA4-6-127M-2-90 located on Strut Plate. Welder is identified as 040611.ZPMC QC is identified as Mr. Mao Bin Bin. The welding variables recorded by QC appeared to comply with the WPS-B-T-4113-1.

This QA inspector observed the following work in progress:
SMAW welding of weld joint no: ED1- STSA4-6-131M-1-93 located on Strut Plate. Welder is identified as 206189.ZPMC QC is identified as Mr. Mao Bin Bin. The welding variables recorded by QC appeared to comply with the WPS-B-T-2112.

BAY#10
This QA inspector observed the following work in progress:
FCAW welding of weld joint no: ED1-A27B/E-84 located on Shear Plate Bearing Stiffener. Welder is identified as 053869.ZPMC CWI is identified as Mr. You Qi Guo .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: ED1-A27B/E-80 located on Shear Plate Bearing Stiffener. Welder is identified as 040533.ZPMC CWI is identified as Mr.You Qi Guo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2331-TC-P4-F.Please see the attached picture.

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

WELDING INSPECTION REPORT

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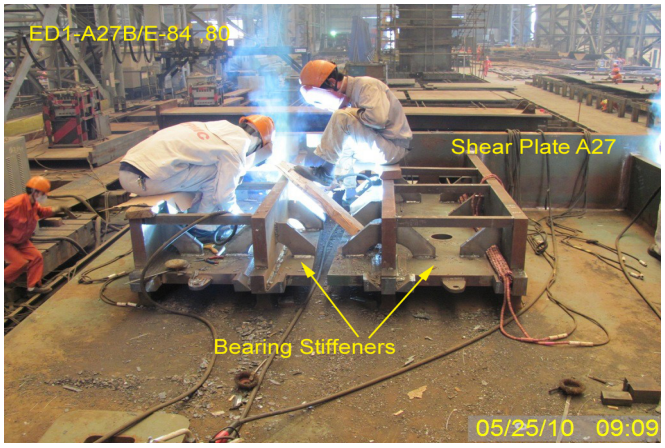

Summary of Conversations:

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