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-014577
Date Inspected: 28-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
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

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#10
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 North Tower Lift 4 Fit Lug of Skin A, B, C, D, E and back fill Plates at 116M,119M and 123M elevation. The weld designations reviewed are as follows:-

NSTL4-3B/L-34,35,36,42,43,12,19,58,59,45,46,15,25,26,27,30.
NSTL4-3C/L-49,50,32,33,34,92,54,42,49,10,11,107,108,120,25,26,27,80,83,88,149,152.
NSTL4-3F/L-42,43,51,19,24,39,65,66,141,12,16,68,53.

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 Shear Plate Bearing stiffeners. The weld designations reviewed are as follows:-

SD1-A20B/B-35, 38

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 Strut Plate. The weld designations reviewed are as follows:-

ED1-STSA4-6-127M-1-6A/B,9A/B,73A/B,13,19,26,30,33,37,39,42,61,63,70,93,96.

IN PROCESS INSPECTION:-
Bay#11

This QA inspector observed the following work in progress:
SMAW welding of weld joint no: WD1-STSA4-5-131M-1-48A/B located on Strut Plate. Welder is identified as 044541. ZPMC QC is identified as Mr.Liu Dao feng. Welding was been performed against Weld Repair Report T-WR3281 and UT report number-T787-UT-2913.The welding variables recorded by QC appeared to comply with the WPS-485-SMAW-2G(2F)-FCM-Repair-1.Please see the attached picture.

This QA inspector observed the following work in progress:
SMAW welding of weld joint no: WD1- STSA4-5-139M-1-7A located on Strut Plate. Welder is identified as 040619.ZPMC QC is identified as Mr. Liu Dao feng. 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: WD1- STSA4-5-139M-1-5B located on Strut Plate. Welder is identified as 046704.ZPMC QC is identified as Mr. Liu dao feng. 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:
SAW welding of weld joint no: GTSA5-B/G-3A located on Grillage Top Erection Plate. Welder is identified as 042195.ZPMC QC is identified as Mr.Shao Hai Long. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-B-U3C-S-2.

This QA inspector observed the following work in progress:
SAW welding of weld joint no: GTSA5-B/G-6A located on Grillage Top Erection Plate. Welder is identified as 044550.ZPMC QC is identified as Mr.Shao Hai Long. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-B-U3C-S-2.

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