

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-014589**Date Inspected:** 24-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:** Zhu Feng**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 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.

TOWER JETTY

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 005810

Ultrasonic Testing (UT)

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member is identified as Tower Component. The weld designations reviewed are as follows:

EAST TOWER LIFT – 1 CORNER WELD ON TOP

A/E corner – 600mm; B/C corner – 600mm & C/D corner – 600mm in length

EAST TOWER LIFT – 1 CORNER WELD ON BOTTOM

B/C corner – 600mm & C/D corner – 600mm in length

This QA Inspector observed the following work in progress:

Flux cored Arc Welding (FCAW):

Weld joint # 22 located on East Tower Lift-1 Skin'E' Façade Plate ESD1 – SA216. Welder is identified as

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040759. ZPMC Quality Control (QC) Inspector is identified as Zhao Chen Sun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2131.

Weld joint # 24 located on South Tower Lift-1 Façade Plate ESD1 – SA216. Welder is identified as 040302. ZPMC Quality Control (QC) Inspector is identified as Zhao Chen Sun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2131.

BAY#10

This QA Inspector observed the following work in progress:

Flux cored Arc Welding (FCAW):

Weld joint # 81 located on Bearing Stiffener of Shear plate ED1 – A27B/E. Welder is identified as 057266. ZPMC Quality Control (QC) Inspector is identified as Lu Wei Chao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2331 – Tc – P4 – F.

Weld joint # 86 located on Bearing Stiffener of Shear plate ED1 – A27B/E. Welder is identified as 040533. ZPMC Quality Control (QC) Inspector is identified as Lu Wei Chao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2331 – Tc – P4 – F.

(See attached photo)

Weld joint # 88 located on Bearing Stiffener of Shear plate ED1 – A27B/E. Welder is identified as 053869. ZPMC Quality Control (QC) Inspector is identified as Lu Wei Chao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2331 – Tc – P4 – F.

BAY#11

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint # 48B located on Tower Strut SD1 – STSA4 – 5 – 139M – 1. Welder is identified as 040619. 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 – 2212 – Tc – U5b.

Weld joint # 73B located on Tower Strut ND1 – STSA4 – 5– 139M – 1. Welder is identified as 040614. 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 – 3212 – Tc – U5b – 1.

Submerged Arc Welding (SAW):

Weld joint # 6A located on Grillage Top Plate GTSA5 – B/G. Welder is identified as 044550. ZPMC Quality Control (QC) Inspector is identified as Shang Hai Long. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2221 – B – U3c – S – 2.

Weld joint # 3A located on Grillage Top Plate GTSA5 – B/G. Welder is identified as 042195. ZPMC Quality Control (QC) Inspector is identified as Shang Hai Long. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2221 – B – U3c – S – 2.

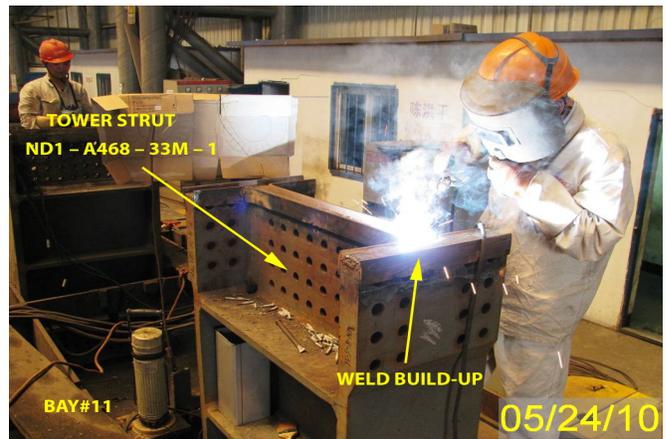
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Weld build-up by Shielded Metal Arc Welding (SMAW):

According to the Critical Weld Repair report T-CWR 628 weld build-up being performed on Tower Strut Plate ND1 – A468 – 33M – 1. Welder is identified as 202100. ZPMC Quality Control (QC) Inspector is identified as Shang Hai Long. The welding variables recorded by QC appeared to comply with the WPS – 485 – SMAW – 1G (1F) – Repair – 1. (See attached photo)

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