

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-014602**Date Inspected:** 26-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: Yu Dong Ping
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 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.

BAY#11

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint # 48A located on Tower Strut SD1 – STSA4 – 5 – 139M – 1. Welder is identified as 040619. ZPMC Quality Control (QC) Inspector is identified as Liu Dao Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3212 – Tc – U5b – 1.

Weld joint # 6B located on Tower Strut ND1 – STSA4 – 5 – 139M – 1. Welder is identified as 040614. ZPMC Quality Control (QC) Inspector is identified as Liu Dao Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3212 – Tc – U5b – 1. (See attached photo)

Flux cored Arc Welding (FCAW):

Weld joint # 89 located on Shear Plate WD1 – A25B/B. Welder is identified as 040704. ZPMC Quality Control (QC) Inspector is identified as Xu Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2331 – Tc – P4 – F.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Weld joint # 77 located on Shear Plate WD1 – A25B/B. Welder is identified as 202384. ZPMC Quality Control (QC) Inspector is identified as Xu Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2331 – Tc – P4 – F.

Weld joint # 68 located on Shear Plate WD1 – A25B/B. Welder is identified as 049451. ZPMC Quality Control (QC) Inspector is identified as Xu Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2331 – Tc – P4 – F.

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.

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

According to the Critical Weld Repair report T-CWR 627 weld build-up being performed on Tower Strut Plate ND1 – A468 – 28M – 1. Welder is identified as 040724. 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.

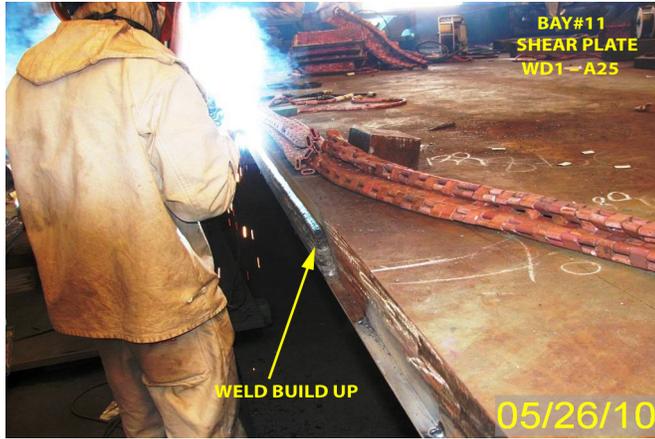
Weld build-up by Flux Cored Arc Welding (FCAW):

According to the Critical Weld Repair report T-WR 3295 weld build-up being performed on Shear Plate WD1 – A25. Welder is identified as 040759. ZPMC Quality Control (QC) Inspector is identified as Xu Jie. The welding variables recorded by QC appeared to comply with the WPS – 345 – FCAW – 2G (2F) – Repair. (See attached photo)

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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



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