

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-014605**Date Inspected:** 29-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: An Qing Xing
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 # 64 located on Tower Strut ND1 – STSA4 – 6 – 143M – 2. Welder is identified as 040614. ZPMC Quality Control (QC) Inspector is identified as Mao Bin Bin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2113. (See attached photo)

Weld joint # 96 located on Tower Strut ED1 – STSA4 – 6 – 143M – 1. Welder is identified as 040610. ZPMC Quality Control (QC) Inspector is identified as Mao Bin Bin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 4113 – 1.

Weld joint # 40 located on Tower Strut ED1 – STSA4 – 6 – 135M – 2. Welder is identified as 046769. ZPMC Quality Control (QC) Inspector is identified as Mao Bin Bin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2112.

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Flux cored Arc Welding (FCAW):

Weld joint # 57 located on Shear Plate ED1 – A29A/B. 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 – B – T – 2331 – Tc – P4 – F.

Weld joint # 37 located on Shear Plate SD1 – A20A/B. Welder is identified as 042218. 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. (See attached photo)

Weld joint # 69 located on Shear Plate ED1 – A29A/B. Welder is identified as 053316. 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.

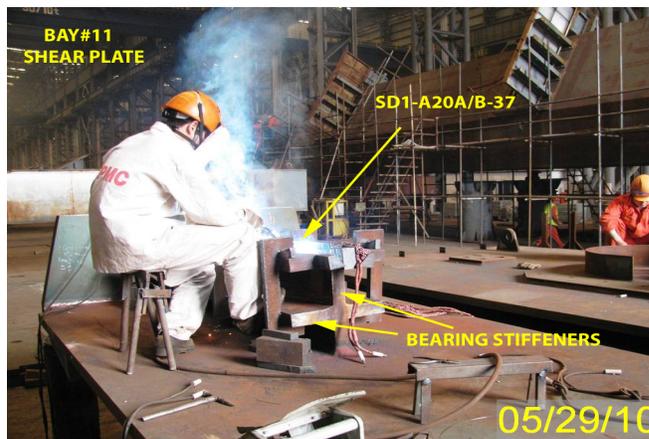
MEASUREMENTS ON VERTICAL TRIAL ASSEMBLY SOUTH TOWER LIFT-1

This QA Inspector carried out the measurements on South Tower Lift-1 Exterior side to check the distance from the edge of the base plate anchor bolt holes to the side of the type-2 bearing stiffeners for skin 'A'; 'B'; 'C'; 'E'. Measurements were recorded on the data sheet and submitted to the assigned task leader.

BLASTING SHOP#2

This QA inspector performed Pre blast visual inspection of external surfaces of South tower, Lift 1 from 0 to 50.3 Elevation. Few areas were identified and marked which requires grinding, Magnetic particle testing (MT) & weld repair wherever applicable in all the Skins.

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.

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Inspected By:	Kumar,Sandeep	Quality Assurance Inspector
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Reviewed By:	Clifford,William	QA Reviewer
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