

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-014935**Date Inspected:** 11-Jun-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:	Mr. An Qing Xiang/Qiu wen	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	

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:-**Trail Assembly Area:-**

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 Cross bracing gusset plate at 65M elevation. The weld designations reviewed are as follows:-

WD1-GUSA3-3-65M-E-4A/B

WD1-GUSA3-3-65M-W-3,4A/B

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

ED1-STSA4-6-131M-2-5A,6A,9A,10A,16,17,37,42,51,53,58,63,73A/B,74A/B,75.

Ultrasonic Testing:-

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Trail Assembly Area:-

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an UT report for this date. The member is identified as Cross bracing gusset plate at 65M elevation. The weld designations reviewed are as follows:-

WD1-GUSA3-3-65M-E-4A/B

WD1-GUSA3-3-65M-W-3,4A/B

IN PROCESS INSPECTION:-

Trail Assembly Area:-

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: SSD1-SA164B/F-14 located on Doubler strut plate at 53M elevation. Welder is identified as 050038. ZPMC CWI is identified as Mr. Zhao Chen Sun. The welding variables recorded by QC appeared to comply with the WPS-B-T-4313-TC-P4.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: WSD1-SA340B/F-12 located on Doubler strut plate at 53M elevation. Welder is identified as 202323. ZPMC CWI is identified as Mr. Zhao Chen Sun. The welding variables recorded by QC appeared to comply with the WPS-B-T-4313-TC-P4.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: ESD1-SA300B/F-22 located on Doubler strut plate at 53M elevation. Welder is identified as 040610. ZPMC CWI is identified as Mr. Zhao Chen Sun. The welding variables recorded by QC appeared to comply with the WPS-B-T-3212-B-U2a-2.

Bay#11:-

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: WSD1-TL5-4B/F-34B located on Lift 5 Grillage Plate. Welder is identified as 049704. ZPMC QC is identified as Mr. Xu jin long. The welding variables recorded by QC appeared to comply with the WPS-B-T-3213-B-U3b.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: WSD1-TL5-4B/F-34A located on Lift 5 Grillage Plate. Welder is identified as 040619. ZPMC QC is identified as Mr. Xu jin long. The welding variables recorded by QC appeared to comply with the WPS-B-T-3213-B-U3b.

Bay#10:-

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: SSD1-SPSA5-6-1A located on Lift 5 Interior Splice Plate. Welder is identified as 050266. ZPMC QC is identified as Mr. Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS-B-T-3211-TC-U5b-1.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: NSD1-SPSA5-6-1A located on Lift 5 Interior Splice Plate. Welder is identified as 044511.ZPMC QC is identified as Mr. Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS-B-T-3211-TC-U5b-1.

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



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 Micheal Ng- 159-2184-5703 , who represents the Office of Structural Materials for your project.

Inspected By: Pillai,Pandaram

Quality Assurance Inspector

Reviewed By: Clifford,William

QA Reviewer