

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-015317**Date Inspected:** 26-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: Gao Zhi Chun
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.

TOWER JETTY

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Repair welding of Weld joint # 11 as per the critical weld repair report T-CWR#642 located on South tower Lift-2 cross bracing gusset plate to small doubler strut plate SSD1 – SA164B/F. Welder is identified as 040582. ZPMC Quality Control (QC) Inspector is identified Sun Zhi Wang. The welding variables recorded by QC appeared to comply with the WPS – 345+485 – SMAW – 2G (2F) – FCM – Repair.

Repair welding of Weld joint # 12 as per the critical weld repair report T-CWR#642 located on North tower Lift-2 Doubler plate to Small doubler strut plate NSD1 – SA166B/F. Welder is identified as 040365. ZPMC Quality Control (QC) Inspector is identified Zhu Feng. The welding variables recorded by QC appeared to comply with the WPS – 485 – SMAW – 2G (2F) – Repair.

BAY#10

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

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006060

Magnetic Particle Testing (MT)

This QA inspector performed MT 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 Tower Component. The weld designation reviewed as follows:

NORTH TOWER LIFT-4, A/E CORNER FITLUGS – GREEN TAG # 12741

NSTL4 – 3 I/L – 29; 30; 32; 95; 97; 98

NSTL4 – 3 J/L – 31; 30; 33; 95; 96; 98

NSTL4 – 3 K/L – 32; 30; 33; 95; 96; 99

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint # 1B located on Lift-5 Splice Plate Stiffener SSD1 – SPSA5 – 13. Welder is identified as 052493. ZPMC Quality Control (QC) Inspector is identified as Yuan Hui Gang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3211 – Tc – U5b – 1.

Weld joint # 2A located on Lift-5 Splice Plate Stiffener NSD1 – SPSA5 – 6. Welder is identified as 044511. ZPMC Quality Control (QC) Inspector is identified as Yuan Hui Gang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3211 – Tc – U5b – 1.

Weld joint # 4A located on Lift-5 Splice Plate Stiffener NSD1 – SPSA5 – 13. Welder is identified as 050289. ZPMC Quality Control (QC) Inspector is identified as Yuan Hui Gang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3211 – Tc – U5b – 1.

BAY#11

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint # 4B located on Lift-5 Splice Plate Stiffener ESD1 – SPSA5 – 7. Welder is identified as 046709. ZPMC Quality Control (QC) Inspector is identified as Xu Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3211 – Tc – U5b – 1. (See attached photo)

Weld joint # 2B located on Lift-5 Splice Plate Stiffener ESD1 – SPSA5 – 20. Welder is identified as 046704. ZPMC Quality Control (QC) Inspector is identified as Xu Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3211 – Tc – U5b – 1.

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

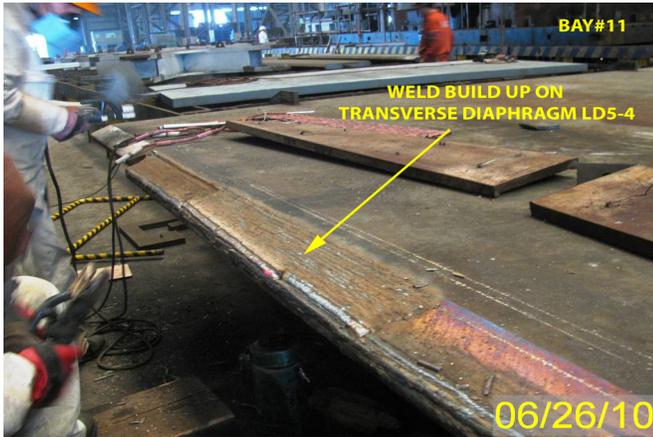
Weld build up being performed according to the weld repair report #T-CWR649 located on East West Lift-5 lifting Transverse Diaphragm # LD5-4. Welder is identified as 044551. ZPMC Quality Control (QC) Inspector is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS – 485 – SMAW – 2G (2F) – Repair – 1. (See attached photo)

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

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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 Michael Ng - 15921845703, who represents the Office of Structural Materials for your project.

Inspected By: Kumar,Sandeep

Quality Assurance Inspector

Reviewed By: Clifford,William

QA Reviewer