DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Vallejo, CA 94592-1133
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-017185
Date Inspected: 08-Sep-2010

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 700
OSM Departure Time: 1900
Location: Shanghai,China

CWI Name: Mr.Xu le feng/Qiu wen

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

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.

In process Inspection

Bay #10

This QA inspector observed the following work in progress:
SMAW welding of weld joint No: SSD1-TL5-1B/F-7A located on Lift 5 Grillage Plate. Welder is identified as #500363. ZPMC QC is identified as Mr. Yuan hui gang. Welding was performed with temporary weld repair report. The welding variables recorded by QC appeared to comply with the WPS-485-SMAW-3G(3F)-Repair.

This QA Inspector observed the following work in progress:
SMAW in the 3G position for the Lift 5 Tower Grillage, weld No: NSD1-TL5-3B-F-7. The welder is identified as #066179. ZPMC QC is identified as Mr. Yuan hui gang. The welding variables recorded by QC appear to comply with WPS-B-T-3213-TC-U4C.

This QA Inspector observed the following work in progress:
SAW in the 1G position for the OBG Segment14 Bottom Plate, weld No: BP3094-001-292. The welder is identified as #050295. ZPMC QC is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appear to comply with WPS-B-T-2221-B-L2C-S-2. Please see the attached picture.

Bay #11

This QA Inspector observed the following work in progress:
FCAW in the 2F position for the OBG Segment Bottom Plate, weld No: BP3093-001-017/018. The welders are identified as #049220/046706. ZPMC QC is identified as Mr. Liu Dao Feng. The welding variables recorded by QC appear to comply with WPS-B-T-2132. Please see the attached picture.

This QA Inspector observed the following work in progress:
SMAW in the 3G position for the Lift 5 Tower Grillage, weld No: WSD1-TL5-4B/F-3. The welder is identified as #066763. ZPMC QC is identified as Mr. Xu Jie. The welding variables recorded by QC appear to comply with WPS-B-T-3213-TC-U4C.

This QA Inspector observed the following work in progress:
SMAW in the 3G position for the Lift 5 Tower Grillage, weld No: ESD1-TL5-2B/F-14. The welder is identified as #040723. ZPMC QC is identified as Mr. Xu Jie. The welding variables recorded by QC appear to comply with WPS-B-T-3213-TC-U4C

Magnetic Particle Testing:-

Bay #10

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 Bike Path. The weld designation reviewed is as follows:

8A-BK004A3-030-12,13,14
8A-BK004A6-030-68,69
8A-BK004A7-030-3,4,63,65,66,125,126

8C-BK004A3-030-38,47,48
8C-BK004A6-030-74,75
8C- BK004A7-030-21,81,15,75,146,76

9A-BK004A4-030-53,55,68,69
9A- BK004A6-030-112,113
9A-BK004A7-030-51,52,111,113,117,118

9C-BK004A4-030-29,44,42,43
9C-BK004A6-030-94,95
9C-BK004A7-030-39,99,101,45,107,105,46

10A-BK004A4-030-1,2,3
10A-BK004A6-030-84,85

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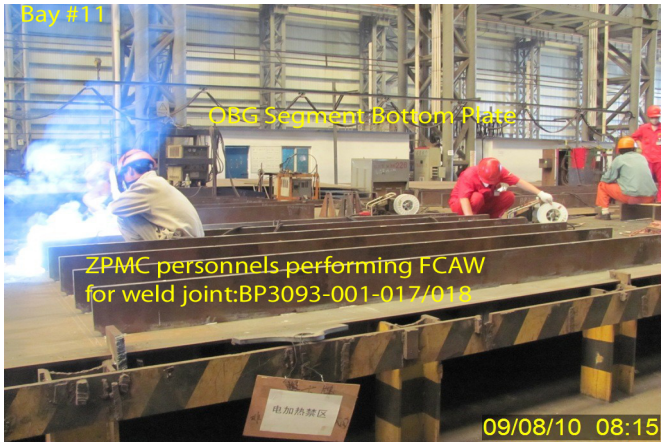
10A-BK004A7-030-27,28,30,87,88,163,164

Unless otherwise noted, all work observed on this date appeared to generally comply with 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 Michel Ng 159-2184-5703, who represents the Office of Structural Materials for your project.

Inspected By:	Pillai,Pandaram	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer