

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017199**Date Inspected:** 12-Sep-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. Qiu wen/Xu Le Feng**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.

In process Inspection

Bay #10

This QA Inspector observed the following work in progress:

FCAW in the 2F position for the OBG Segment Bottom Plate, weld No: BP3088-001-004/005. The welders are identified as #052075/044473. ZPMC QC is identified as Mr. Sun Tian Liang. 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:

FCAW in the 4F position for the Tower Façade, weld No: ND1-SFSA4-326A/B-06. The welder is identified as #040581. ZPMC QC is identified as Mr. Yin Chun Fang. The welding variables recorded by QC appear to comply with WPS-B-P-2114.

This QA Inspector observed the following work in progress:

SAW in the 1G position for the OBG Segment 14 Bottom Plate, weld No: SEG3007AC-001-002. The welder is identified as #058100. ZPMC QC is identified as Mr. Zhang Lin. The welding variables recorded by QC appear to comply with WPS-B-T-2221-B-U3C-S-2. Please see the attached picture.

WELDING INSPECTION REPORT

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Bay #11

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: WSD1-TL5-4E/F-32A/B located on Tower Lift 5 Grillage. Welder is identified as #068924. ZPMC CWI is identified as Mr.Xu Le Feng. Welding was performed according to the weld repair report T-WR3582 and UT report number: T787-UT-3178.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 welding of weld joint no: ESD1-TL5-2B/F-6A/B located on Tower Lift 5 Grillage. Welder is identified as #040723. ZPMC CWI is identified as Mr. Xu Le Feng. Welding was performed according to the weld repair report T-WR3590 and UT report number: T787-UT-3182.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:

FCAW in the 2F position for the OBG Segment Bottom Plate, weld No: BP3092-001-029. The welder is identified as #046706. ZPMC CWI is identified as Mrs.Yu Dong Ping. The welding variables recorded by QC appear to comply with WPS-B-T-2132.

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 Lift 5 South Tower Grillage. The weld designation reviewed is as follows:

SSD1-TL5-1B-F-1A/B,4A/B,7A/B,8A/B.

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



WELDING INSPECTION REPORT

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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
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Reviewed By:	McClendon,Timothy	QA Reviewer
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