

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020695**Date Inspected:** 13-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhu Jun**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:** OBG, Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Dennis Combs, was present during the times noted above for the observations relative to the work being performed.

Bay 14

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Li Ping

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector

Component: Floor Beam

PCMK: SEG3007P

Weld Number: 041

Welder: 044774

WPS-B-T-2233-ESAB

Bay 16

This Caltrans QA inspector received ZPMC non-destructive test (NDT) notification number 07765 from ZPMC for Bay 16. This QA inspector performed magnetic particle testing (MT) verification of welds after ZPMC had

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performed their MT inspection. The segment is identified as Tower Facade. The weld designations reviewed are as follows.

WD1-SFSA4-333A/B-8-003, 019

Bay 19

This QA Inspector observed the following work in progress for Bay 19.

ZPMC was using the Flux Cored Arc Welding (FCAW) process.

ZPMC QC is identified as Xu Tao

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector

Component: Suspender Bracket

PCMK: SB021-102

Weld Number: 026, 032

Welder: 062762

WPS-B-T-2132-ESAB

Blast Bay 1

This Caltrans QA inspector received ZPMC non-destructive test (NDT) notification number 07762 from ZPMC for Blast Bay 1. This QA inspector performed magnetic particle testing (MT) verification of welds after ZPMC had performed their MT inspection. The segment is identified as South Tower Lift 4. The weld designations reviewed are as follows.

ESD1-FASA4-2C/E-70

ESD1-FASA4-2C/E-15

This Caltrans QA Inspector and Mr. Bret Rice, Mr. Kelly Leavitt, and Mr. Mike Hasler performed a pre-blast visual inspection of the interior surface and internal components, South Tower Lift 4 subassembly, 116~131 meter mark to the bottom surface of the double diaphragm. Surface defects and base metal surface irregularities that required grinding were marked up with colored chalk, and weld defects that require welding were taped with gray masking tape for repair after the coating has been applied. ZPMC QC and ABF inspection personnel were present during the inspection and informed of QA findings.

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

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remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Combs,Dennis	Quality Assurance Inspector
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Reviewed By:	Riley,Ken	QA Reviewer
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