

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:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006788**Date Inspected:** 17-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Tu 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:	Tower		

Summary of Items Observed:

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector Larry Viars was present during the times noted above for observations relative to the work being performed.

Blast Shop 2-

Caltrans Quality Assurance (QA) Inspectors Viars, Alaniz and Gaikwad performed random internal visual inspection of East Tower Lift 1 from 43 Top Diaphragm to 47.6 Meter bottom diaphragm after grit blasting. During Caltrans visual inspection, Caltrans QA inspectors observed that steel backing tack welds were cracked for 47.6 Meter Diaphragm to Diaphragm insert Plate CJP welds at Skin "A" to "E" and "E" to "D" corners. ZPMC personnel did not weld a continuous fillet the full length of the steel backing. ZPMC weld backing for Weld ESD1-A165 H/J-016 did not run the full length of the weld. It was also noted that gouges up to 4 mm were found at steel backing tack weld locations. An Incident report for steel backing was issued on this date. Please see the attached photographs of above mentioned anomalies.

Various discontinuities were found to include but not limited to, Slag, porosity, crater cracks, weld spatter, base metal gouges and arc strikes. This QA Inspector did not observe ZPMC personnel perform MT of Arc Strike areas after grinding.

Bay 10-

QA Inspector observed the following work in progress: SAW welding of weld joint SSD1-FCSA4- 1 A/C- 050,

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

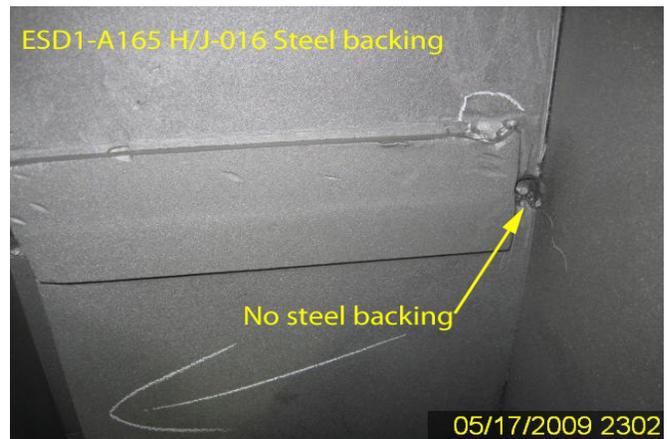
located on East tower Lift 2 Skin "C" . ZPMC welder was identified as 207746. ZPMC QC is identified as Tu Jun. The repair welding appeared to be in conformance with welding procedure specification, WPS-345-. SAW-1G-Repair.

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 members are identified as South Tower Lift 4 Skin Plate C. The weld identification number is SSD1-FCSA4-1 A/C 062B.

Bay 11-

QA Inspector observed the following work in progress: FCAW welding of weld joints WSD1-FDSA3-2 B/C- 022 and 023, located on West Tower Lift 2 Skin plate"D". ZPMC welders were identified as 069469 and 066398. ZPMC QC is identified as Zhang Zhi Neng. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2332-TC-P5-F.

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



Summary of Conversations:

As identified within the contents of this report.

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 Serge Sinevod, +86 134 8257 0045, who represents the Office of Structural Materials for your project.

Inspected By: Viars,Larry

Quality Assurance Inspector

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Reviewed By: Carreon,Albert

QA Reviewer