

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-008126**Date Inspected:** 06-Aug-2009**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:	Sun Wei, Liu Fa Wen, Zhao Chen			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 and Tower		

Summary of Items Observed:

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

Bay 5 OBG Box Bracket of Bike Way

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 reports for this date. The members are identified as OBG Components. The weld designations reviewed are as follows.

BK001-030-040, 044, 037, 033, 042, 035, 064, 065
 BK001-029-040, 044, 037, 033, 042, 035, 064, 065
 BK001-028-040, 044, 037, 033, 042, 035, 064, 065
 BK001-027-040, 044, 037, 033, 042, 035, 064, 065
 BK001-026-040, 044, 037, 033, 042, 035, 064, 065
 BK001-025-040, 044, 037, 033, 042, 035, 064, 065

Bay 3 OBG Floor Beam Lifting 11

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested

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and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT reports for this date. The members are identified as OBG Components. The weld designations reviewed are as follows.

FB020-009-086, 087, 120, 121, 136, 137, 130, 131, 022, 023, 088, 093, 107

Bay 6 Tower Gusset Plate of Cross Bracing

This QA inspector performed Magnetic Particle Testing (MT) of approximately more than 15% lot testing and Visual Testing (VT) of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT reports for this date. The members are identified as Tower Components. The weld designations reviewed are as follows.

WSD1-GUSA3-3-77M-4-1, 2
WSD1-GUSA3-3-89M-1-1, 2
WSD1-GUSA3-3-89M-2-1, 2
WSD1-GUSA3-3-89M-3-1, 2
WSD1-GUSA3-3-89M-4-1, 2
WSD1-GUSA3-3-99M-1-1, 2

This Quality Assurance (QA) Inspector observed the following work in progress:

Bay 6 Tower Strut Plate

SMAW welding of weld joint 13 located on WD1-A305-65M-4.
Welder is identified as 066456. ZPMC QC is identified as Mr. Zhang Bao Bo.
The welding variables recorded by QC appeared to comply with WPS-B-T-2113.

SMAW welding of weld joint 48 located on WD1-A305-77M-1.
Welder is identified as 037780. ZPMC QC is identified as Mr. Zhang Bao Bo.
The welding variables recorded by QC appeared to comply with WPS-B-T-2112.

Bay 7

FCAW welding of weld joint 007 located on BP3025-001.
Welder is identified as 019006. ZPMC QC is identified as Mr. Zhou Jie.
The welding variables recorded by QC appeared to comply with WPS-B-T-2233-B-U2-F.

SAW welding of weld joint 002 located on DP3001-001.
Welder is identified as 054458. ZPMC QC is identified as Mr. Zhong Chong Biao.
The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-L2c-S-2.

Bay 8

FCAW welding of weld joint 002 located on CB202F-013.

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Welder is identified as 069118. ZPMC QC is identified as Mr. Zhang Jing Xin.

The welding variables recorded by QC appeared to comply with WPS-B-T-2231-B-U2-F.

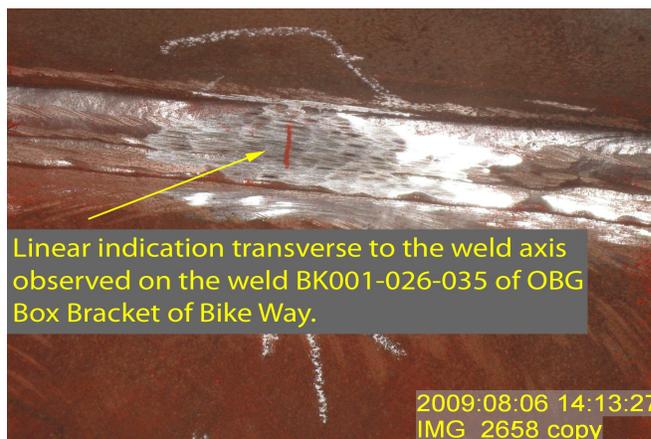
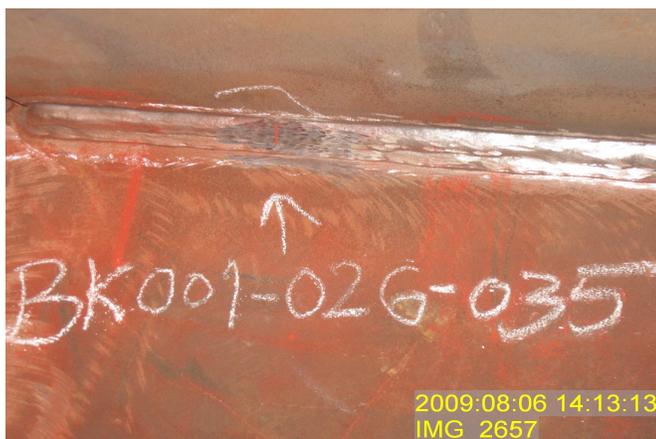
SAW welding of weld joint 001 located on CB202C-013.

Welder is identified as 207463. ZPMC QC is identified as Mr. Zhang Jing Xin.

The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-L2c-S-2.

During random verification Magnetic Particle Testing (MT) of OBG Box Bracket of Bike Way, weld BK001-026-035 located in the OBG Bay no.5, Caltrans Quality Assurance (QA) Inspector discovered a linear indication of 10~12mm in length transverse to the weld axis. This area had been previously tested and accepted by ZPMC NDT personnel. This QA inspector prepared an incident report of this issue for this date. The attached photographs provide additional detail.

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



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

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 Jim Simonis - 134-7246-3441, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Umesh	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
