

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-008526**Date Inspected:** 13-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wang Chuan Qing**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 components**Summary of Items Observed:**

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

Bay# 10- Tower Assembly:

This QA Inspector randomly observed the following work in progress:

FCAW Process:

Welding of weld joint# 60A located on PCMK NSD1 FESA4-3 F/F. Welder is identified as 040343. ZPMC QC is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2231-TC-U5b-F.

Welding of weld joint# 42A located on PCMK NSD1 FESA4-3 F/F. Welder is identified as 053869. ZPMC QC is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2231-TC-U5b-F.

Welding of weld joint# 1A located on PCMK NSD1 FESA4-3 F/F. Welder is identified as 040261. ZPMC QC is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2231-TC-U5b-F.

Welding of weld joint# 45, 46 located on PCMK SSD1 FDSA4-1 B/C. Welder is identified as 201825. ZPMC QC is identified as Wang Chuan Qing. The welding variables recorded by QC appeared to comply with the specified

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WPS no. B-T-4332-TC-P5-F.

Welding of weld joint# 5, 6 located on PCMK SSD1 FDSA4-1 B/C. Welder is identified as 057266. ZPMC QC is identified as Wang Chuan Qing. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-4332-TC-P5-F.

Welding of weld joint# 1,2 located on PCMK SSD1 FDSA4-1 B/C. Welder is identified as 057244. ZPMC QC is identified as Wang Chuan Qing. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-4332-TC-P5-F.

SMAW Process:

Welding of weld joint# 14A located on PCMK NSD1 FDSA4-3 D/D. Welder is identified as 052930. ZPMC QC is identified as Yuan Hui Gang. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3212-TC-U5b-1.

Welding of weld joint# 12 located on PCMK NSD1 FDSA4-3 D/D. Welder is identified as 052930. ZPMC QC is identified as Yuan Hui Gang. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3312-TC-P5.

Welding of weld joint# 66A located on PCMK NSD1 FDSA4-3 F/F. Welder is identified as 050289. ZPMC QC is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3212-TC-U5b-1.

Bay# 11- Tower Assembly:

This QA Inspector randomly observed the following work in progress:

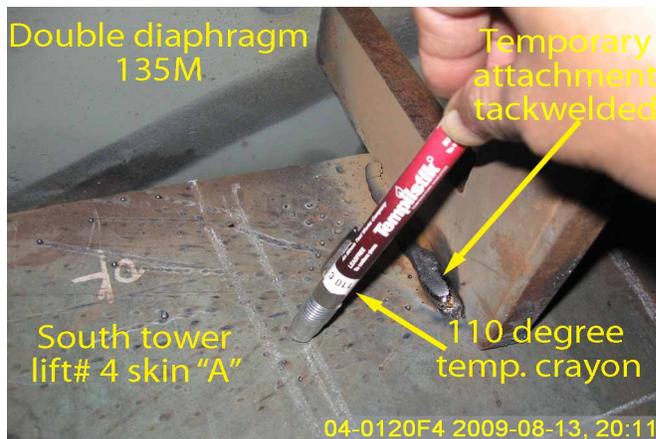
SMAW Process:

Welding of weld joint# 28A located on PCMK WSD1 FDSA4-4 D/D. Welder is identified as 040690. ZPMC QC is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3212-TC-U5b-1.

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

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Summary of Conversations:

ZPMC has temporarily tack welded fit up lugs on South tower lift# 4, skin "A" that are not specified in the shop drawings and without sufficient preheat temperature. Required preheat temperature is 110C, specified in the WPS# WPS-B-P-2112 for base material thickness 60mm. The lugs appear to be for the purpose of aiding in the positioning of the double diaphragm (135M) on the skin plate. See attached photos.

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 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By: Chakrabarti, Dilip Kumar

Quality Assurance Inspector

Reviewed By: Clifford, William

QA Reviewer