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 #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-008837
Date Inspected: 28-Aug-2009

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 1900
OSM Departure Time: 700
Location: Shanghai, China

CWI Name:	CWI: Liu Yang			**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:

Magnetic Particle Testing (MT):
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 a TL-6028 MT report on this date. The member and the weld designations are as follows:

Sl # Section # Weld # Green Tag # Location
1. SSTL3-1 B/K 82B 9817 NA
2. SSTL3-1 B/K 19 NA NA
3. SSTL3-1 C/K 22 NA NA

Final VT:
This QA inspector performed Final Visual Testing (FVT) of entire welded area, previously tested and accepted by ZPMC Quality Control personnel of the member and weld designated are as follows:

Sl # Section # Weld # Green Tag # Location

1. SSTL3-1 B/K 19 NA NA
2. SSTL3-1 C/K 22 NA NA
3. SSTL3-1 C/K 102 NA NA
4. SSTL3-1 D/K 24 NA NA
5. SSTL3-1 F/K 17 NA NA
6. SSTL3-1 F/K 95 NA NA
7. SSTL3-1 G/K 24 NA NA
8. SSTL3-1 G/K 113 NA NA
9. SSTL3-1 H/K 18 NA NA
10. SSTL3-1 H/K 94 NA NA
11. SSTL3-1 I/K 22 NA NA
12. SSTL3-1 I/K 113 NA NA
13. SSTL3-1 J/K 18 NA NA
14. SSTL3-1 B/K 82B 9817 NA

FCAW Process:
Welding of weld Joint# 2A located on PCMK NSD1 SPSA3-54. Welder is identified as 053896. ZPMC QC is identified as Lu Wei Chao. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2232-B-U5-F.

Welding of weld Joint# 1A located on PCMK NSD1 SPSA3-52. Welder is identified as 040343. ZPMC QC is identified as Lu Wei Chao. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2232-B-U5-F.

Tack welding of weld Joint# 26 located on PCMK NSD1 FASA4-1 B/E-2. Welder is identified as 250253. ZPMC QC is identified as Yuan Hai Gang. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-4312-TC-P4-2.

Tack welding of weld Joint# 5 located on PCMK NSD1 FASA4-1 B/E-1. Welder is identified as 052889. ZPMC QC is identified as Yuan Hai Gang. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-4312-TC-P4-2.

Tack welding of weld Joint# 16 located on PCMK NSD1 FASA4-1 C/E. Welder is identified as 040586. ZPMC QC is identified as Yuan Hai Gang. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-4312-TC-P4-2.

Tack welding of weld Joint# 16 located on PCMK NSD1 FASA4-1 C/E. Welder is identified as 040475. ZPMC QC is identified as Yuan Hai Gang. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-4312-TC-P4-2.

Bay# 11- Tower Assembly:
This QA Inspector randomly observed the following work in progress:

FCAW Process:

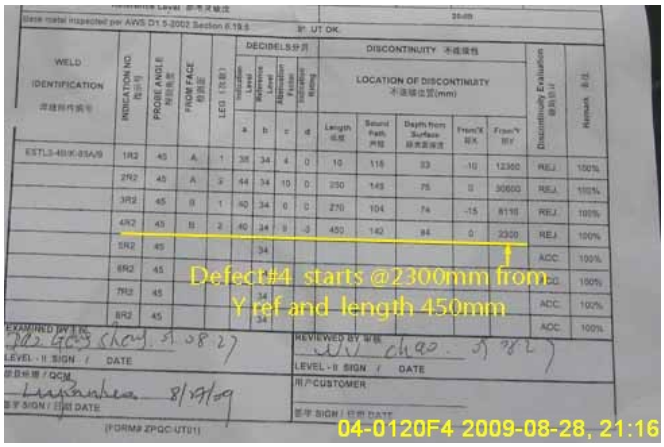
Welding of weld Joint# 84B located on PCMK WSD1 FASA4-2 A/E-21. Welder is identified as 040212. ZPMC QC is identified as Zhan Bo. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-4332-TC-P4-F.

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

Summary of Conversations:

During random Inspection in Bay# 11 this QA Inspector observed that the repair for weld joint# ESTL3-4 B/K-83A/B was being prepared in the presence of ZPMC QC Zhang Bo. After this QA Inspector verified the Critical Welding Report (CWR)# T-CWR-210 and the weld map, it appeared that defect location# 4, as confirmed by the ZPMC QC and the location of the excavation did not match as detailed in the CWR and attached UT report.

This QA Inspector asked ZPMC QC representative Shen Xue Jun why the location of the where the critical weld repair location does not match the location indicated on the ultrasonic inspection report. Shen Xue Jun informed this QA Inspector that he does not know why the locations do not match and that ZPMC will not perform any welding repairs at this location until ZPMC revises the critical weld repair document.



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.

WELDING INSPECTION REPORT

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Inspected By:	Chakrabarti,Dilip Kumar	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer