

**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-009640**Date Inspected:** 14-Oct-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:** Chen Ying Xin, Feng Guo.**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:**

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 11 West Tower Lift 3 D/E corner seam

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% and random 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.

WSTL3-4B/K-82A (MT Linear Indication observed, Incident Report)

Bay 10 North Tower Lift 4 skin C to stiffener

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% and random 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.

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NSD1-FCSA4-1B/C-1A/B, 14A/B

NSD1-FCSA4-1C/C-1A/B, 14A/B, 15A/B, 28A/B Green Tag No. 10646

NSD1-FCSA4-1C/C-2, 3, 5, 6, 10, 11, 12, 13, 16, 17, 19, 20, 24, 25, 26, 27

NSD1-FCSA4-1B/C-2, 3, 5, 6, 10, 11, 12, 13

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

Bay 11

FCAW welding of weld joint 7 located on ESD1-A63C/D-1.

Welder is identified as 059525. ZPMC CWI is identified as Mr. Peng Guo.

The welding variables recorded by QC appeared to comply with WPS-B-T-2332-Tc-P4-F.

Bay 10

SMAW welding of weld joint 9B located on ND1-A6002-7.

Welder is identified as 052493. ZPMC CWI is identified as Mr. Chen Ying Xin.

The welding variables recorded by QC appeared to comply with WPS-B-T-3212-Tc-U5b-1.

SMAW welding of weld joint 41 located on ED1-A6003-7.

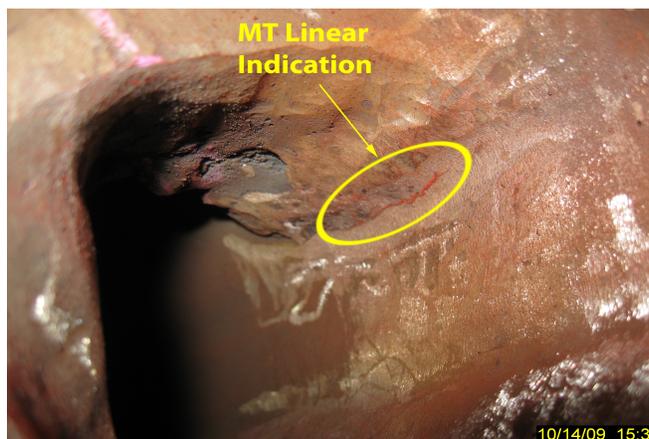
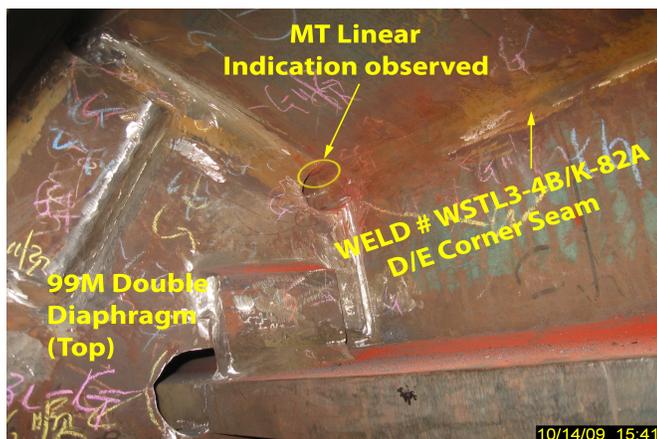
Welder is identified as 068250. ZPMC CWI is identified as Mr. Chen Ying Xin.

The welding variables recorded by QC appeared to comply with WPS-B-T-2113.

During random verification Magnetic Particle Testing (MT) of D/E corner seam of West tower lift 3, weld WSTL3-4B/K-82A located in the Tower Bay No. 11, Caltrans Quality Assurance (QA) Inspector discovered a linear indication of approximately 30mm in length at 99M (Top) double diaphragm. This area had been previously tested and accepted by ZPMC NDT personnel. (NDT Inspection Notification sheet # 004401). This issue has an incident report.

The attached photographs provide additional detail.

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



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

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<b>Inspected By:</b>	Gaikwad,Umesh	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

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