

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-010263**Date Inspected:** 04-Nov-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, 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		

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 Tower Spare Strut Plate

This QA inspector performed Ultrasonic Testing (UT) of approximately 10%, 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 UT and MT reports for this date. The members are identified as Tower Components. The weld designations reviewed are as follows.

WD1-A6003-2

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

Outside Yard

FCAW welding of weld joint 84A (Repair) located on NSTL3-3B/K.

Welder is identified as 040261. ZPMC CWI is identified as Mr. Du Zhi Qun.

The welding variables recorded by QC appeared to comply with WPS-345-FCAW-2G (2F)-REPAIR.

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South Tower Lift 2

This QA inspector observed ZPMC personnel was working on the weld surface repair on Grating Bracket of 53M diaphragm of South Tower lift 2. The welder is identified as 067904. ZPMC QC is identified as Mr. Yang Ming Ming.

West Tower Lift 3

This QA inspector witnessed Magnetic Particle Testing (MT) of fit lugs on skin C and skin C with diaphragm at 109M (Top) diaphragm performed by ZPMC NDT technician.

South Tower Lift 1

During random in process Visual Testing (VT) of South Tower Lift 1, backing bar of C/D corner diagonal stiffener located in the Tower assembly yard (Jetty Area), Caltrans Quality Assurance (QA) Inspector observed “crack like” linear indications on the backing bar of C/D corner diagonal stiffener fit for plate splice. This QA Inspector performed follow up Magnetic Particle Testing (MT) to confirm these linear indications. This issue has an incident report. The attached photographs provide additional detail.

East Tower Lift 2

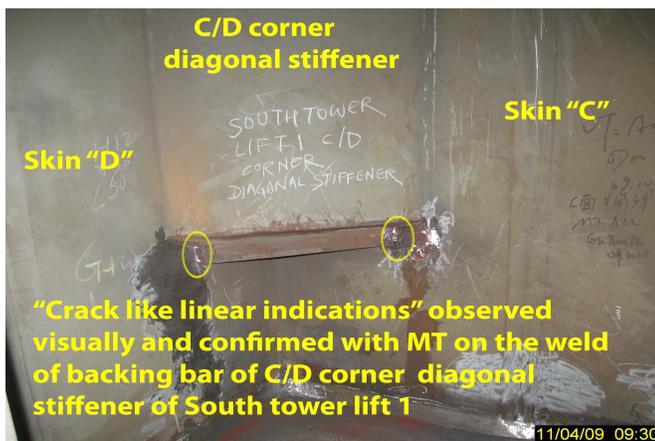
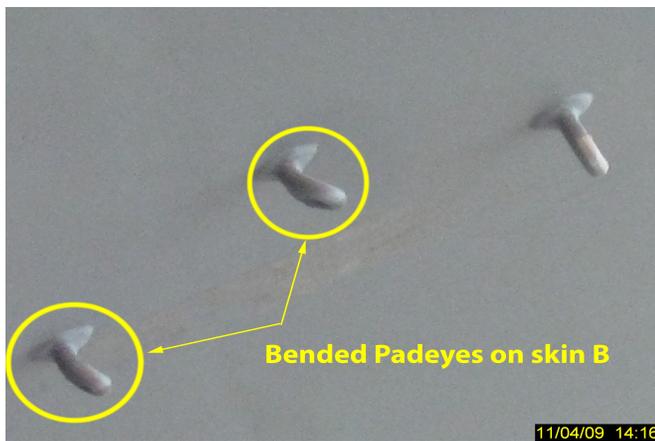
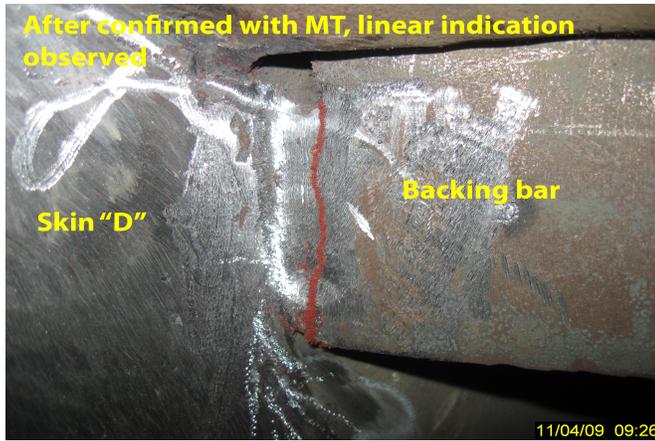
During random in process Visual Testing (VT) of East Tower Lift 2 located in the Milling section, Caltrans Quality Assurance (QA) Inspector observed two padeyes on skin B near B/C corner bended at 53M diaphragm. The attached photographs provide additional detail.

During random 10% verification Ultrasonic Testing (UT) on weld joint WD1-A6003-2-11, Caltrans Quality Assurance (QA) Inspector discovered a class “A” non conforming indication measuring approximately 21mm in length. This weld was previously tested and accepted by ZPMC Quality Control (QC) UT technician (NDT Inspection Notification Sheet # 004549). This issue has an incident report.

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