DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
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-010617
Date Inspected: 29-Nov-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: 700
OSM Departure Time: 1900
Location: Shanghai, China

CWI Name:	Chen Ying Xin, Gong Liang Zhu	**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 East Tower Lift 4 D/E corner seam

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT reports for this date. The members are identified as Tower Components. The weld designations reviewed are as follows.

ESTL4-2B/L-61A/B (D/E CORNER SEAM @ 143M, 139M, 135M, 123M & 119M DOUBLE DIAPHRAGM AREA)

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

Bay 10

SMAW welding of weld joint 29 located on ND1-A6002-1.
Welder is identified as 040268. ZPMC CWI is identified as Mr. Chen Ying Xin.
The welding variables recorded by QC appeared to comply with WPS-B-T-2113.

SMAW welding of weld joint 56 located on ED1-STSA3-2-89M-1.
Welder is identified as 057266. ZPMC CWI is identified as Mr. Chen Ying Xin.
The welding variables recorded by QC appeared to comply with WPS-B-T-4113-1.

FCAW welding of weld joint 3B located on NSD1-SPSA4-24.
Welder is identified as 040261. ZPMC CWI is identified as Mr. Gong Linag Zhu.
The welding variables recorded by QC appeared to comply with WPS-B-T-2231-Tc-U5-F.

FCAW welding of weld joint 2A located on SSD1-SPSA4-18.
Welder is identified as 040533. ZPMC CWI is identified as Mr. Gong Liang Zhu.
The welding variables recorded by QC appeared to comply with WPS-B-T-2231-Tc-U5-F.

SAW welding of weld joint 13B located on SSD1-TL5-1E-F.
Welder is identified as 050295. ZPMC QC is identified as Mr. Deng Zhi Bing.
The welding variables recorded by QC appeared to comply with WPS-B-T-3221-B-U3c-S-1.

SMAW welding of weld joint 26B located on ND1-STSA3-1-109M-1.
Welder is identified as 053050. ZPMC QC is identified as Mr. Yu Zhi Lai.
The welding variables recorded by QC appeared to comply with WPS-B-T-3212-Tc-U5b-1.

BAY 11

SMAW welding of weld joint 11B located on SD1-STSA3-1-109M-1.
Welder is identified as 040656. ZPMC QC is identified as Mr. Mao Bin Bin.
The welding variables recorded by QC appeared to comply with WPS-B-T-3212-Tc-U5b-1.

West Tower Lift 4
FCAW welding of weld joint 122 located on WSTL4-2K/L.
Welder is identified as 053486. ZPMC CWI is identified as Mr. Zhan Bo.
The welding variables recorded by QC appeared to comply with WPS-B-T-4332-Tc-P4-F.

During random in process Visual Testing (VT) of Strut Connection Angle plate, located in the Tower bay no. 10, Caltrans Quality Assurance (QA) Inspector observed that ZPMC personnel performing heat straightening on weld # ND1-A5012-18-1A/B after NDT completion of ZPMC and Caltran's QA inspector.
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 Serge Sinevod 134-8257-0045, who represents the Office of Structural Materials for your project.

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