

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 #: 04-0120F4Cty: 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-014120**Date Inspected:** 28-Dec-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:** Du Zhi Qun.**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 Shailesh 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:

Outside Yard (8CE)

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 a TL- 6027 (UT) report for this date. The member is identified as Segment (8CE). The weld designations reviewed are as follows.

Weld nos. are

SEG 048 B - 004,003,002,001,032.

SEG 048 F-006,004,026,022.

SSD 17 A - PP69-010,215,013.

SSD 18 A - PP70-130,133,135.

NDT Notification No: 004949

This QA Inspector observed the following work in progress:

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

TOWER TRIAL ASSEMBLY

This QA Inspector observed ZPMC qualified welding personnel identified as 066683, 070046 perform Flux Core Arc Welding (FCAW) on, South Tower, lift 4,(Inside) weld joint identified as SSOL SA40B/E -8, 14 Skin D. ZPMC CWI Identified as You Qi Guo. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2333-TC-P4-F.

This QA Inspector observed ZPMC qualified welding personnel identified as 066733, 040367 perform Flux Core Arc Welding (FCAW) on, South Tower, lift 4,(Outside) Skin B weld joint identified as SSDI-SA1F1 B/H-24. ZPMC CWI Identified as You Qi Guo. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2333-TC-P4-F.

This QA Inspector observed ZPMC qualified welding personnel identified as 202821, 042218 perform Flux Core Arc Welding (FCAW) on, West Tower, lift 1,(Inside) Skin C. weld joint identified as WSD1-SA294 F/G-24, 26. ZPMC CWI Identified as You Qi Guo. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2333-TC-P4-F.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the 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 Skyler Guest phone: 15000422360, who represents the Office of Structural Materials for your project.

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