

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-011969**Date Inspected:** 07-Feb-2010**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:** Xu Le Feng**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:

BAY 10:

This QA Inspector performed Magnetic Particle Testing (MT) of approximately 15% and randomly Visual Testing of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL- 6028 (MT) report for this date. The member is identified as Tower right angle connected plate. The weld designations reviewed are as follows.

ED1-A5007-2,4,6,8,9,10,11,12,13,15,16,17,18,19, 20,22,23,24,25,29,30-1A/B

ND1-A5012-4,8,11,12,13,16,26,31-1A/B.

NDT Notification No-005191

This QA Inspector observed the following work in progress:

BAY 10

This QA Inspector observed ZPMC qualified welding personnel identified as 040434, Perform Flux Core Arc Welding (FCAW) on South tower lift 4 Fit lug. The weld identified as SSTL4-1K/L-100, near double diaphragm 143M top. ZPMC CWI Identified as Lilin, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2333-Tc-P4-F.

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This QA Inspector observed ZPMC qualified welding personnel identified as 040434, Perform Flux Core Arc Welding (FCAW) on South tower lift 4 Fit lug. The weld identified as SSSL4-1K/L-35, near double diaphragm 143M bottom. ZPMC CWI Identified as Lilin, 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 066477, Perform Flux Core Arc Welding (FCAW) on South tower lift 4 Fit lug. The weld identified as SSSL4-1J/L-100, near double diaphragm 139M top. ZPMC CWI Identified as Lilin, 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 066477, Perform Flux Core Arc Welding (FCAW) on South tower lift 4 Fit lug. The weld identified as SSSL4-1K/L-34, near double diaphragm 139M bottom. ZPMC CWI Identified as Lilin, 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 066477, Perform Flux Core Arc Welding (FCAW) on South tower lift 4 Fit lug. The weld identified as SSSL4-1I/L-100, near double diaphragm 135M top. ZPMC CWI Identified as Lilin, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2333-Tc-P4-F. For more information see attached photos.

Repair Welding:

This QA Inspector observed ZPMC qualified welding personnel identified as 052930, Perform Shielded Metal Arc Welding (SMAW) on South tower lift 4, Back fill plate repair welding. The weld identified as SSSL4-1H/L-30, near double diaphragm 131M bottom. ZPMC CWI Identified as Du Zhiqun, with Temporary welding repair report, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with, WPS-485-SMAW-3G (3F)- Repair.

Repair Welding:

This QA Inspector observed ZPMC qualified welding personnel identified as 057258, Perform Shielded Metal Arc Welding (SMAW) on South tower lift 4, Back fill plate repair welding. The weld identified as SSSL4-1G/L-29, near double diaphragm 127M bottom. ZPMC CWI Identified as Du Zhiqun, with Temporary welding repair report, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with, WPS-485-SMAW-3G (3F)- Repair.

This QA Inspector observed during random Visual inspection, ZPMC Magnetic Particle Testing (MT) Inspector perform MT on Tower Strut Plate, The Item identified as ED1-A6001-1 For more information see attached photos.

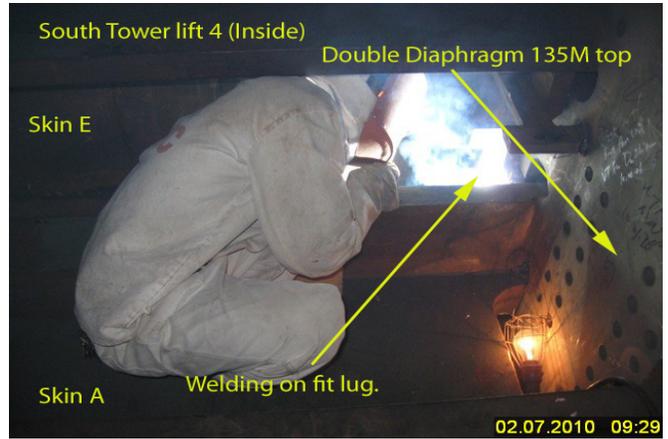
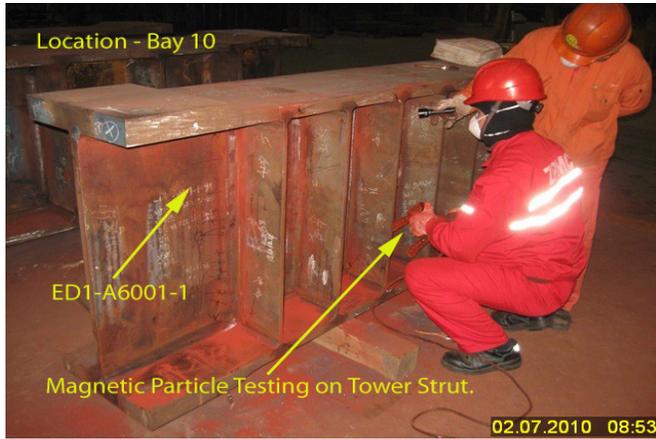
BAY 11:

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This QA Inspector observed ZPMC qualified welding personnel identified as 041716. Perform Submerged Arc Welding (SAW) on Tower Flange Plate. Joint identified ED1-SA4-68-131M-8-1B, ND1-SA4-68-131M-1-1B, ND1-SA4-68-131M-2-1B, ZPMC CWI Identified as Yu Dong Ping. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-3221-Tc-U5-S-1.

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
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Reviewed By:	Clifford,William	QA Reviewer
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