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

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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-012071
Date Inspected: 07-Feb-2010

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:	Yu Dong Ping, 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 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 10 TOWER STRUT

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 report for this date. The members are identified as Tower Components. The weld designations reviewed are as follows.

ED1-A6001-3-73, 81, 77, 49, 53, 57, 25, 33, 29, 10, 9, 38, 42, 46, 16, 20, 24, 64, 68, 72, 88, 92, 96

TOWER ANGLE CONNECTION PLATE (GREEN TAG NO. 11716)

This QA inspector performed green tagging for the following components. The components are identified as Tower components and the weld designition are as follows.

ED1-A5007-2, 4, 6, 8, 9, 10, 11, 12, 13, 15, 16, 17, 19, 20, 22, 23, 24, 25, 29, 18-1A/B
ND1-A5012-4, 8, 11, 12, 13, 16, 26, 31-1A/B

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

BAY 10

SOUTH TOWER LIFT 4 A/E CORNER BACKFILL PLATE REPAIR (127M TOP)
SMAW welding of weld joint 98 (Repair) located on SSTL4-1G/L.
Welder is identified as 057258. ZPMC CWI is identified as Mr. Du Zhi Qun.
The welding variables recorded by QC appeared to comply with WPS-485-SMAW-3G(3F)-REPAIR.

SOUTH TOWER LIFT 4 A/E CORNER BACKFILL PLATE REPAIR (131M BOTTOM)
SMAW welding of weld joint 30 (Repair) located on SSTL4-1H/L.
Welder is identified as 052930. ZPMC CWI is identified as Mr. Du Zhi Qun.
The welding variables recorded by QC appeared to comply with WPS-485-SMAW-3G(3F)-REPAIR.

SOUTH TOWER LIFT 4 FIT LUG ON SKIN A
FCAW welding of weld joint 98 located on SSTL4-2I/L.
Welder is identified as 066477. ZPMC CWI is identified as Mr. Li Lin.
The welding variables recorded by QC appeared to comply with WPS-B-T-4333-Tc-P4-F.

FCAW welding of weld joint 98 located on SSTL4-2J/L.
Welder is identified as 040434. ZPMC CWI is identified as Mr. Li Lin.
The welding variables recorded by QC appeared to comply with WPS-B-T-4333-Tc-P4-F.

FCAW welding of weld joint 45 located on SSTL4-2C/L.
Welder is identified as 066236. ZPMC CWI is identified as Mr. Liu Zhong An.
The welding variables recorded by QC appeared to comply with WPS-B-T-2333-Tc-P4-F.

TOWER STRUT ANGLE CONNECTION PLATE
This QA inspector witnessed Magnetic Particle Tesing (MT) performed by ZPMC NDT personnel on the weld joints of Strut angle connection plates. On one of the angle connection plate idntified as ND1-A5012-33-1A/B, ZPMC NDT personnel found linear indication. The components are identified as Tower components. The weld designitions are as follows. Attached photographs provide additional detail.

ED1-A5007-2, 4, 6, 8, 9, 10, 11, 12, 13, 15, 16, 17, 19, 20, 22, 23, 24, 25, 29, 18-1A/B
ND1-A5012-4, 8, 11, 12, 13, 16, 26, 31-1A/B
ND1-A5012-33-1A/B (ZPMC NDT personnel found MT linear indication)

BAY 11

TOWER STRUT ANGLE CONNECTION PLATE
SAW welding of weld joint 1B located on ED1-SA4-68-131M-8.
Welder is identified as 041716. ZPMC CWI is identified as Yu Dong Ping.
The welding variables recorded by QC appeared to comply with WPS-B-T-3221-Tc-U5-S-1.

SAW welding of weld joint 1B located on ND1-SA4-68-131M-1.
Welder is identified as 041716. ZPMC CWI is identified as Yu Dong Ping.
The welding variables recorded by QC appeared to comply with WPS-B-T-3221-Tc-U5-S-1.

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 Skyler Guest : 15000422360, who represents the Office of Structural Materials for your project.

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