

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-012078**Date Inspected:** 10-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

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|------------------------------------|--------------------------|----------------------------------|-------|----|-----|
| 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 NORTH TOWER LIFT 2 ~ 3, SPLICE PLATE

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.

SA-433 QUANTITY: 9PCS

SA-438 QUANTITY: 2PCS

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

BAY 10**NORTH TOWER LIFT 4, C/D CORNER REPAIR (T-CWR533, REV. 2)**

SMAW welding of weld joint 1A/B (Repair) located on NSTL4-3B/L.

Welder is identified as 052930. ZPMC CWI is identified as Mr. Du Zhi Qun.

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The welding variables recorded by QC appeared to comply with WPS-345-SMAW-1G(1F)-REPAIR.

SOUTH TOWER LIFT 4, FIT LUG ON SKIN A

FCAW welding of weld joint 103 located on SSSL4-1F/L.

Welder is identified as 066236. ZPMC CWI is identified as Mr. Li Lin.

The welding variables recorded by QC appeared to comply with WPS-B-T-2333-Tc-P4-F.

FCAW welding of weld joint 30 located on SSSL4-1G/L.

Welder is identified as 066236. 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.

NORTH TOWER LIFT 2

During random in process Visual Inspection this QA inspector observed ZPMC personnel performing grinding on base metal of skin C and skin D of North Tower lift 2 to remove temporary attachments. The components are identified as Tower components. Attached photographs provide additional detail.

BAY 11

TOWER STRUT ANGLE CONNECTION PLATE

SAW welding of weld joint 1B located on ND1-SA4-68-139M-8.

Welder is identified as 040699. ZPMC CWI is identified as Yu Dong Ping.

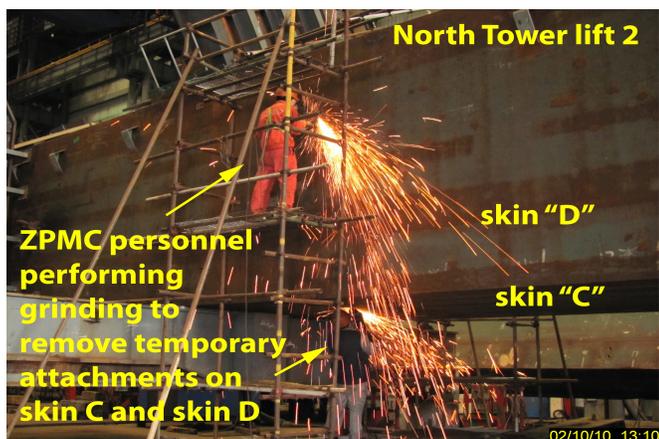
The welding variables recorded by QC appeared to comply with WPS-B-T-3221-Tc-U5-S-1.

SAW welding of weld joint 1B located on ED1-SA4-68-143M-1.

Welder is identified as 040699. 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:

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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.

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