

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-013265**Date Inspected:** 12-Apr-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:** 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:

BAY 11

This QA Inspector performed randomly Visual Inspection Magnetic Particle Testing (MT) of approximately 15% 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 Skirt Plate. The weld designations reviewed are as follows.

SD1-A440E/E-37, 38

ND1-A501E/E-36, 37

NDT Notification No-005506

This QA Inspector observed the following work in progress:

BAY 10

This QA Inspector observed ZPMC qualified welding personnel identified as 209051. Perform Submerged Arc Welding (SAW) on North Tower lift 5 C/D corner joint. Joint identified as NSD1-TL5-3B-F-8A, ZPMC QC Identified as Yuan Hui Gang, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-3221-Tc-U2b-S.

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BAY 11:

This QA Inspector observed ZPMC qualified welding personnel identified as 040614, 040667. Perform Shielded Metal Arc Welding (SMAW) on Angle connection plate. Joint identified as SD1-SA4-56-143M-1, 2, 3, 4-1A, 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-3211-Tc-U5B-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 040656, 046704. Perform Shielded Metal Arc Welding (SMAW) on Angle connection plate. Joint identified as WD1-SA4-56-139M-1, 2, 3, 4-1A, 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-3211-Tc-U5B-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 047304. Perform Submerged Arc Welding (SAW) on Grillage Beam plate. Joint identified as WSD1-TL5-4B/F-9A, ZPMC QC Identified as Libin. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-3221 -U3c-S-1.

Repair Welding:

This QA Inspector observed ZPMC qualified welding personnel identified as 040655. Perform Shielded Metal Arc Welding (SMAW) on East Tower lift 3 skin E stiffener. Build up 3mm. Item identified as LS3-37, ZPMC CWI Identified as An Qing Xiang, with temporary welding repair report, WRR-T-WR3165. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-2G (2F) Repair. For more information see below attach photo No-1.

Repair Welding:

This QA Inspector observed ZPMC qualified welding personnel identified as 040541. Perform Shielded Metal Arc Welding (SMAW) on West Tower lift 5 A/E corner joint. Joint identified as WSD1-TL5-4B/F-33A, ZPMC CWI Identified as An Qing Xiang, 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-2G (2F) Repair-1. For more information see below attach photo No-2.

This QA Inspector observed ZPMC qualified welding personnel identified as 046704. Perform Flux Core Arc Welding (FCAW) on West tower lift 4 A/E corner Back fill plate welding at Double diaphragm. Joint identified as WSTL4-2G/L-112. 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-4333-TC-P4-F.

This QA Inspector observed ZPMC qualified welding personnel identified as 203269. Perform Flux Core Arc Welding (FCAW) on West tower lift 4 A/E corner Back fill plate welding. Joint identified as WSTL4-2J/L- 44. ZPMC QC Identified as Shao Hao Long, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-4333-Tc-P4-F.

This QA Inspector observed ZPMC qualified welding personnel identified as 053316, 040736. Perform Flux Core Arc Welding (FCAW) on West tower lift 4 A/E corner Back fill plate welding. Joint identified as WSTL4-2I/L- 110, 43. ZPMC QC Identified as Shao Hao Long, The welding parameters as measured using QC's calibrated

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instrument appeared to be in general compliance with WPS-B-T-4333-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