

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-013676**Date Inspected:** 04-May-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:** Yu Dong Ping**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:

This QA Inspector observed the following work in progress:

BAY 11:

SMAW Process:

This QA Inspector observed ZPMC qualified welding personnel identified as 040667, 040614. Perform Shielded Metal Arc Welding (SMAW) on Tower Strut. Joint identified as WD1-STSA4-5-127M-1-47A, 5B. 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-3212-Tc-U5b-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 251194. Perform Shielded Metal Arc Welding (SMAW) on Tower Strut. Joint identified as ED1-STSA4-6-131M-2-93, 94, 13,14, 33,34, ZPMC QC Identified as Liu Dao Feng, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2112.

This QA Inspector observed ZPMC qualified welding personnel identified as 202100. Perform Shielded Metal Arc Welding (SMAW) on Tower Strut. Joint identified as ND1-STSA4-6-131M-1-61, 62, 75, 76, 23, 24, 27, ZPMC

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QC Identified as Liu Dao Feng, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2112.

This QA Inspector observed ZPMC qualified welding personnel identified as 040724, 046769. Perform Shielded Metal Arc Welding (SMAW) on Tower Strut. Joint identified as ED1-STSA4-6-139M-1-29, 30, 19, 20, 31, 32, 17, 18, ZPMC QC Identified as Liu Dao Feng, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2113.

This QA Inspector observed ZPMC qualified welding personnel identified as 046704. Perform Shielded Metal Arc Welding (SMAW) on Tower Strut. Joint identified as WD1-STSA4-5-143M-1-7A, 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-2212-Tc-U5b.

Repair welding: FCAW Process,

This QA Inspector observed ZPMC qualified welding personnel identified as 042218. Perform Flux Core Arc Welding (FCAW) on Skirt connection beam. Item identified as WSD1-SA38, Buttering up to 18mm. ZPMC QC Identified as Shao Hao Long, with temporary welding repair report WRR-T-WR3219. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-FCAW-1G (1F) Repair.

This QA Inspector observed ZPMC qualified welding personnel identified as 040619. Perform Shielded Metal Arc Welding (SMAW) on East Tower lift 5 Grillage plate. Joint identified as ESD1-TL5-2B/F-35A, 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-3213-B-U3b.

BAY 10

SMAW Process,

This QA Inspector observed ZPMC qualified welding personnel identified as 052930. Perform Shielded Metal Arc Welding (SMAW) on South Tower lift 3 Skin B small doublers plate. Joint identified as CAMPSA-3-91, 92, 93. ZPMC QC Identified as Yuan Hai Gang, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2112, 2113, 2114. For more information see attach below photo number 2.

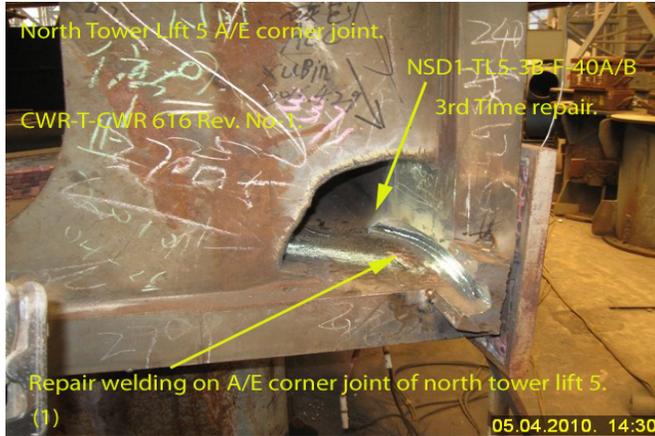
Repair welding:

This QA Inspector observed ZPMC qualified welding personnel identified as 052693. Perform Shielded Metal Arc Welding (SMAW) on North Tower lift 5 A/E corner joint as 3rd time repair. Joint identified as NSD1-TL5-3B/F-40A/B. ZPMC QC Identified as Li Peng Fei with critical welding repair report CWR-T-CWR616, Rev No-1. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-485-SMAW-2G (2F)-Repair. For more information see attach below photo number 1.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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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