

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-014093**Date Inspected:** 08-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:** Gao Zhi Chun, Tu Jun**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 11, East Tower lift 4, Step Plate (GREEN TAG NO. 12518)

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

ESD1-FASA4-2A/E-70

ESD1-FASA4-2C/E-15

North Tower Lift 1, Skin D External Elevator Brackets (GREEN TAG NO. 11662)

This QA inspector performed green tagging for the skin D elevator brackets supports of North Tower lift 1.

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

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BAY11

TOWER GRILLAGE PLATE

SMAW welding of weld joint 1B located on ESD1-TL5-2B/F.

Welder is identified as 040619. ZPMC QC is identified as Mr. Li Bin.

The welding variables recorded by QC appeared to comply with WPS-B-T-3213-B-U3b.

SMAW welding of weld joint 1A located on ESD1-TL5-2B/F.

Welder is identified as 040690. ZPMC QC is identified as Mr. Li Bin.

The welding variables recorded by QC appeared to comply with WPS-B-T-3213-B-U3b.

LIFT 4 STRUT PLATE

SMAW welding of weld joint 33 located on ND1-STSA4-6-131M-1.

Welder is identified as 206189. ZPMC QC is identified as Mr. Liu Dao Feng.

The welding variables recorded by QC appeared to comply with WPS-B-T-2112.

SMAW welding of weld joint 8B located on WD1-STSA4-5-127M-1.

Welders are identified as 040614. ZPMC CWI is identified as Yu Dong Ping.

The welding variables recorded by QC appeared to comply with WPS-B-T-2212-Tc-U5b-1.

BAY 10

FACADE PLATE

FCAW welding of weld joint 22 located on WD1-SFSA3-28.

Welder is identified as 044480. ZPMC QC is identified as Mr. Zhu Zhong Jie.

The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

TOWER GRILLAGE PLATE

SMAW welding of weld joint 35A located on SSD1-TL5-1B-F.

Welder is identified as 500363. ZPMC QC is identified as Mr. Yu Zhi Lai.

The welding variables recorded by QC appeared to comply with WPS-B-T-3213-B-U3b.

SMAW welding of weld joint 2A located on SSD1-TL5-1B-F.

Welder is identified as 500363. ZPMC QC is identified as Mr. Yu Zhi Lai.

The welding variables recorded by QC appeared to comply with WPS-B-T-3213-B-U3b.

BEARING STIFFENER ON ND1-A24

FCAW welding of weld joint 24 located on ND1-A24A/B.

Welder is identified as 040533. ZPMC QC is identified as Mr. Li Peng Fei.

The welding variables recorded by QC appeared to comply with WPS-B-T-2331-Tc-P4-F.

FCAW welding of weld joint 23 located on ND1-A24A/B.

Welder is identified as 053869. ZPMC QC is identified as Mr. Li Peng Fei.

The welding variables recorded by QC appeared to comply with WPS-B-T-2331-Tc-P4-F.

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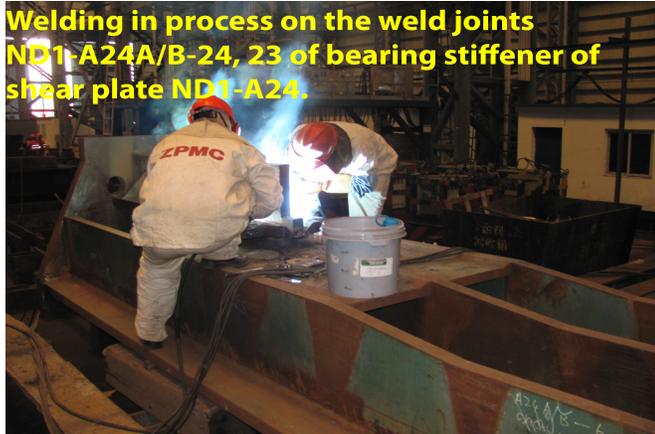
SOUTH TOWER LIFT 3, MANHOLE OPENING COWLING PLATE

SMAW welding of weld joints 21 & 17 located on SSD1-FASA3-1C/E.

Welder is identified as 052930. ZPMC CWI is identified as Mr. Gao Zhi Chun.

The welding variables recorded by QC appeared to comply with WPS-B-T-2112/2113/2114.

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