

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-014156**Date Inspected:** 10-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: An Xiang Qin
Inspected CWI report: Yes No N/A
Electrode to specification: Yes No N/A
Qualified Welders: Yes No N/A
Approved Drawings: Yes No N/A

CWI Present: Yes No
Rod Oven in Use: Yes No N/A
Weld Procedures Followed: Yes No N/A
Verified Joint Fit-up: 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 A22 West tower shearing Plate with base plate. The weld designations reviewed are as follows.

WD1-A22A/B-39, 40, 42, 43, 67

NDT Notification No-005700

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 Shearing Plate. The weld designations reviewed are as follows.

SD1-A23A/B-25, 26, 27, 28

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NDT Notification No-005702

This QA Inspector observed the following work in progress:

BAY 11:

SMAW Process:

This QA Inspector observed ZPMC qualified welding personnel identified as 044541, 044551. Perform Shielded Metal Arc Welding (SMAW) on Tower Strut. Joint identified as ED1-STSA4-10-119M-2-36B, 8A. ZPMC QC Identified as Mao Bin Bin, 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 046709, 041271. Perform Shielded Metal Arc Welding (SMAW) on Tower Strut. Joint identified as ND1-STSA4-6-119M-1-36A, 8B. ZPMC QC Identified as Mao Bin Bin, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-3212-Tc-U5b-1.

SMAW Process: Repair Welding:

This QA Inspector observed ZPMC qualified welding personnel identified as 040655. Perform Shielded Metal Arc Welding (SMAW) on Tower Strut. Joint identified as ED1-STSA4-6-127M-2-73A, ZPMC QC Identified as Liu Dao Feng, 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.

This QA Inspector observed ZPMC qualified welding personnel identified as 040655. Perform Shielded Metal Arc Welding (SMAW) on Tower Strut. Joint identified as ED1-STSA4-6-131M-2-73A, ZPMC QC Identified as Liu Dao Feng, 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.

This QA Inspector observed ZPMC qualified welding personnel identified as 040655. Perform Shielded Metal Arc Welding (SMAW) on Tower Strut. Joint identified as ED1-STSA4-6-131M-2-6A, ZPMC QC Identified as Liu Dao Feng, 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.

BAY 10

This QA Inspector observed ZPMC qualified welding personnel identified as 500363, 500373. Perform Shielded Metal Arc Welding (SMAW) on South Tower lift 5 Grillage plate. Joint identified as SSD1-TL5-1B/F- 35B, 2B, ZPMC QC Identified as Deng Zhi Beng, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-3213-B-U3b.

Magnetic Particle Testing:

This QA Inspector observed ZPMC Magnetic Particle Testing Inspector, performing MT on Shearing Plate bearing stiffener weld at location Bay 10. Item identified as ND1-A24A/B-23, 24.

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FCAW Process: Repair Welding,

This QA Inspector observed ZPMC qualified welding personnel identified as 053869. Perform Flux Core Arc Welding (FCAW) on 13M External diaphragm connection plate Buttering up to 3~10mm. Joint identified as ND1-A10, ZPMC QC Identified as Yu Zhi Lai with temporary welding repair report, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-FCAW-2G(2F)Repair.

FCAW Process:

This QA Inspector observed ZPMC qualified welding personnel identified as 204868, 255455, 053869. Perform Flux Core Arc Welding (FCAW) on bearing plate. Joint identified as ED1-A27B/E-21, 23, 37. ZPMC CWI Identified as You Qi Guo. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2331-Tc-P4-F.

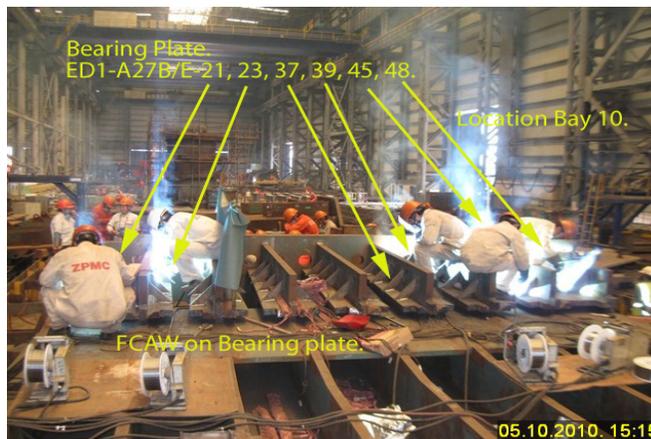
This QA Inspector observed ZPMC qualified welding personnel identified as 057266, 203460, 040465, Perform Flux Core Arc Welding (FCAW) on bearing plate. Joint identified as ED1-A27B/E-39, 45, 48. ZPMC CWI Identified as You Qi Guo. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2331-Tc-P4-F. For more information see below attach photo.

This QA Inspector observed ZPMC qualified welding personnel identified as 044511. Perform Shielded Metal Arc Welding (SMAW) on Skirt plate pad eye. Joint identified as SSD1-A434A/D-16~26, ZPMC QC Identified as Jiang Xiang Bo, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2114 and WPS-B-P-2111.

Ultrasonic Testing:

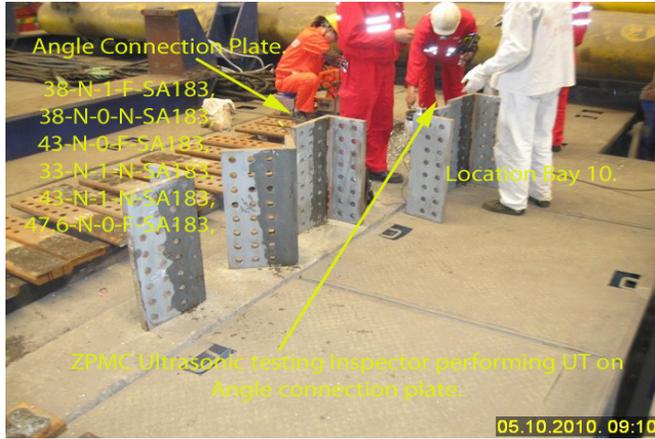
This QA Inspector observed ZPMC Ultrasonic Testing Inspector, performing UT on Angle connection Plate Item identified as 38-N-1-F-SA138, 38-N-0-N-SA13, 43-N-0-F-SA138, 33-N-1-N-SA138, 43-N-1-N-SA138, 47. 6-N-0-F-SA138, at location Bay 10. For more information see below attach photo.

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
