

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-014415**Date Inspected:** 22-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:** You Qi Guo.**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 and 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 west Tower lift 4, diaphragm to skin and fit lug weld. The weld designations reviewed are as follows.

WSTL4-2B/L-9, 11, 14, 25, 28, 32, 35, 42, 45, 51

WSTL4-2C/L-56, 125

NDT Notification No-005796

BAY 11

This QA Inspector performed randomly Visual Inspection and 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 West Tower lift 4 D/E corner joint. The weld designations reviewed are as follows.

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WSTL4-2L/L-1B,
WSTL4-2B/L-61B
NDT Notification No-005798

BAY 11

This QA Inspector performed randomly Visual Inspection Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL- 6027 (UT) report for this date. The member is identified as West Tower Lift 4 119M Diaphragm backfill plate. The weld designations reviewed are as follows.

WSTL4-2C/L-56, 125
NDT Notification No-005796

This QA Inspector observed the following work in progress:

BAY 11:

SMAW Process:

This QA Inspector observed ZPMC qualified welding personnel identified as 040614, 040611. Perform Shielded Metal Arc Welding (SMAW) on Tower Strut. Joint identified as ND1-STSA4-6-139M-2-9A, 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-2212Tc-U5b.

This QA Inspector observed ZPMC qualified welding personnel identified as 040614, 040611. Perform Shielded Metal Arc Welding (SMAW) on Tower Strut. Joint identified as ND1-STSA4-6-139M-2-73B, 6A, 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-3212Tc-U5b-1.

FCAW Process:

This QA Inspector observed ZPMC qualified welding personnel identified as 040609, 042218, Perform Flux Core Arc Welding (FCAW) on Shear plate bearing stiffener weld. Joint identified as WD1-A21A/B-22, 23. ZPMC QC Identified as Xu Jie. 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 040759, 053316, Perform Flux Core Arc Welding (FCAW) on Shear plate bearing stiffener weld. Joint identified as ED1-A29A/B-56, 58, 74, 72, 60, 63. ZPMC QC Identified as Xu Jie. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2331-Tc-P4-F.

SMAW Process:

This QA Inspector observed ZPMC qualified welding personnel identified as 040655, Perform Shielded Metal Arc Welding (SMAW) on East tower lift 3 Skin A, Facade plate. Joint identified as ESD1-FASA3-2-B/E-20, 14 and ESD1-FASA3-2-C/E-10, ZPMC QC Identified as Xi Jun Long. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-4314-Tc-P4-2.

This QA Inspector observed ZPMC qualified welding personnel identified as 040704, Perform Shielded Metal Arc

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Welding (SMAW) on East tower lift 3 Skin A, Facade plate. Joint identified as ESD1-FCSA3-2-B/E-19, 13 and ESD1-FCSA3-2-C/E-9, ZPMC QC Identified as Xi Jun Long. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-4132.

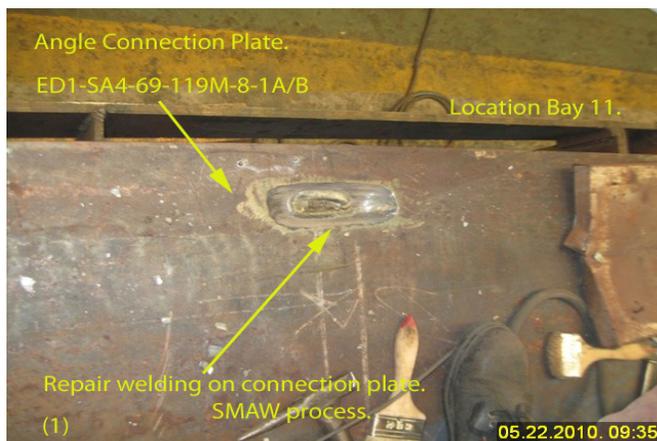
SAW Process:

This QA Inspector observed ZPMC qualified welding personnel identified as 042195, 044550. Perform Submerged Arc Welding (SAW) on Saddle grillage plate. Joint identified as GTSA5-B/G-3B, 6B, 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-2221-B-U3c-S-2.

Repair Welding, SMAW Process:

This QA Inspector observed ZPMC qualified welding personnel identified as 044541, Perform Shielded Metal Arc Welding (SMAW) on Angle connection plate. Joint identified as ED1-SA4-69-119M-8-1A/B, ZPMC CWI Identified as Yu Dong Ping 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-1G (1F) Repair. For more information see below attach photo number 1.

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

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Reviewed By: Clifford, William

QA Reviewer