

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-015726**Date Inspected:** 16-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Gao Zhi Chun**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 10

This QA Inspector performed randomly Visual Inspection and 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 Lift 5 Skin A Interior splice plate. The weld designations reviewed are as follows.

SND1-SPSA5-6-1, 2, 3, 4A/B

NDT Notification No-06208

BAY 11

This QA Inspector performed randomly Visual Inspection and 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 Tower Strut. The weld designations reviewed are as follows.

ED1-STSA4-6-135M-1-5, 6, 73, 74, 9A, 10A,

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

NDT Notification No-06210

This QA Inspector observed the following work in progress:

BAY 11: SMAW Process.

This QA Inspector observed ZPMC qualified welding personnel identified as 040667, Perform Shielded Metal Arc Welding (SMAW) on Interior splice plate. Joint identified as WSD1-SPSA5-20-2A. 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-3211-Tc-U5b-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 040614, Perform Shielded Metal Arc Welding (SMAW) on Interior splice plate. Joint identified as ESD1-SPSA5-12-3B. 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-3211-Tc-U5b-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 040656, Perform Shielded Metal Arc Welding (SMAW) on Interior splice plate. Joint identified as WSD1-SPSA5-7-4B. 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-3211-Tc-U5b-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 046704, Perform Shielded Metal Arc Welding (SMAW) on Interior splice plate. Joint identified as WSD1-SPSA5-12-2B. 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-3211-Tc-U5b-1.

SMAW Process Repair Welding:

This QA Inspector observed ZPMC qualified welding personnel identified as 040610, Perform Shielded Metal Arc Welding (SMAW) on Tower Strut, Joint identified as WD1-STSA4-5-127M-1-7A. 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-345-SMAW-2G (2F) FCM-Repair-1.

SMAW Process Repair Welding:

This QA Inspector observed ZPMC qualified welding personnel identified as 040610, Perform Shielded Metal Arc Welding (SMAW) on Tower Strut, Joint identified as WD1-STSA4-5-127M-1-6A. 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-2G (2F) FCM-Repair-1. For more information see below attached picture number 1.

SMAW Process Repair Welding:

This QA Inspector observed ZPMC qualified welding personnel identified as 044541, Perform Shielded Metal Arc Welding (SMAW) on Tower Strut, Joint identified as WD1-STSA4-5-119M-1-48A/B. ZPMC CWI Identified as Yu Dong Ping with temporary welding repair report WRR-T-WR3380. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-485-SMAW-2G (2F) FCM-Repair-1.

WELDING INSPECTION REPORT

(Continued Page 3 of 4)

BAY 11 OBG Lift 13 Side plate:

This QA Inspector observed ZPMC qualified welding personnel identified as 049220, 205649 Perform Flux Core Arc Welding (FCAW) on Side plate of OBG lift 13. Joint identified as SP3067-001- 077, 079, 078, ZPMC QC Identified as Ma Qianli Ma. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2232-B-U2-F.

This QA Inspector observed ZPMC qualified welding personnel identified as 046706 Perform Flux Core Arc Welding (FCAW) on Side plate of OBG lift 13. Joint identified as SP3107-001- 106, ZPMC QC Identified as Ma Qianli Ma. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2232-U2-F. For more information see below attached picture number 2.

This QA Inspector observed ZPMC qualified welding personnel identified as 205649 Perform Flux Core Arc Welding (FCAW) on Side plate of OBG lift 13. Joint identified as SP3104-001- 031, ZPMC QC Identified as Ma Qianli Ma. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2232-U2-F.

BAY 11 Heat Straightening:

This QA Inspector observed ZPMC personnel perform Heat Straightening on Side plate of OBG lift 13. Plate identified as SP3069-001 maximum deformation observed 3~5mm. ZPMC QC Identified as Liu Dao Feng with Heat straightening report HSR1 (B)-8828.

BAY 10, SMAW Process:

This QA Inspector observed ZPMC qualified welding personnel identified as 050289, 040581, Perform Shielded Metal Arc Welding (SMAW) on inside the South tower lift 5 Stiffener, Joint identified as SSD1-TL5-1F-F-1A/B, 4A/B. ZPMC QC Identified as Yu Zhi Lai. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-3213-Tc-U5b.

BAY 10 OBG Lift 13:

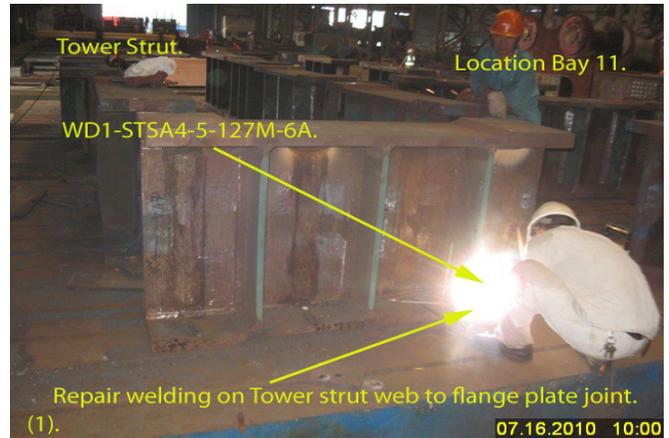
This QA Inspector observed ZPMC qualified welding personnel identified as 040533, 053870, Perform Flux Core Arc Welding (FCAW) on Side plate of OBG lift 13. Joint identified as SP3083-001- 95, 96, ZPMC QC Identified as Yuan Hai Gang. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2132.

This QA Inspector observed ZPMC qualified welding personnel identified as 052075, 053869, Perform Flux Core Arc Welding (FCAW) on Side plate of OBG lift 13. Joint identified as SP3083-001- 107, 108, 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-T-2132.

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

WELDING INSPECTION REPORT

(Continued Page 4 of 4)



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 Michael Ng Phone: 15921845703, who represents the Office of Structural Materials for your project.

Inspected By: Gaikwad,Shailesh

Quality Assurance Inspector

Reviewed By: Clifford,William

QA Reviewer