

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-006160**Date Inspected:** 06-Apr-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 630**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Hong Fei**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 Inspector (QA) Joe Alaniz 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.

This QA inspector performed VT of the area previously tested and accepted by ZPMC Quality Control personnel. The weld designations reviewed are as follows:

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1. Welds between the 80.75m diaphragm and skin A and E fit lugs.
2. Welds between the 77m diaphragm and skin A/D/E fit lugs.
3. Welds between the 74m diaphragm and skin A/D/E fit lugs.
4. Welds between the 71m diaphragm and skin A/D/E fit lugs.

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) is/are identified as Skin C stiffeners. The weld designations reviewed are as follows:

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1. ESD1-SA77A/E-1B (1A) 2. ESD1-SA77A/E-2B (2A) 3. ESD1-SA77A/E-3B (3A)

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4. ESD1-SA77A/E-4B (4A) 5. ESD1-SA77A/E-5B (5A)
6. ESD1-SA77A/E-13B (13A) ~17A (17B) 7. ESD1-SA77A/E-22A (22B) ~26A (26B)

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This QA inspector performed UT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member(s) is/are identified as Skin C stiffeners. The weld designations reviewed are as follows:

1. ESD1-SA77A/E-1B (1A)
2. ESD1-SA77A/E-2B (2A)
3. ESD1-SA77A/E-3B (3A)
4. ESD1-SA77A/E-4B (4A)
5. ESD1-SA77A/E-5B (5A)

This QA Inspector observed the following work in progress:

SMAW welding of weld joint 7, 8, 65 and 64 located on PCMK WD1-A467-28M

Welder is identified as Mr. Zhang Youzhi (040675). ZPMC QC is identified as Li Hong Fei

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

This QA Inspector observed the following work in progress:

SMAW welding of weld joint 5A and 2B located on PCMK WD1-A467-47.6M

Welder is identified as Mr. Cui Guozhong (040656). ZPMC QC is identified as Li Hong Fei

The welding variables recorded by QC appeared to comply with WPS-B-T-2212-Tc-U5b-1 and WPS-B-T-3212-Tc-U5b.

This QA Inspector observed the following work in progress:

SMAW welding of weld joint 62 located on PCMK WD1-A21A/B

Welder is identified as Mr. Zhu Tangquan (069043). ZPMC QC is identified as Li Hong Fei

The welding variables recorded by QC appeared to comply with WPS-B-T-2332-Tc-U5b-1.

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

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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 Eric Tsang (134-8257-0045), who represents the Office of Structural Materials for your project.

Inspected By:	Alaniz,Joe	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
