

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-008067**Date Inspected:** 30-Jul-2009**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:** Ma Yun, Chen Ying Xin.**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 10 North Tower Lift 2 Butt of BC Corner Diagonal Stiffener

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT reports for this date. The members are identified as Tower Components. The weld designations reviewed are as follows.

NSD1-TL8K/L-1~14 (45mm Thickness Butt Joint with backing strip)

NSD1-TL8K/L-33~45 (45mm Thickness Butt Joint with backing strip)

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

Bay 10

North Tower Lift 3 Corner Seam Skin D/E

FCAW welding of weld joint 85A located on NSTL3-3B/K.

Welder is identified as 040338. ZPMC QC is identified as Mr. Zong Yi.

The welding variables recorded by QC appeared to comply with WPS-B-T-2231-Tc-U4b-F.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

North Tower Lift 3 Corner Seam Skin B/C

SAW welding of weld joint 82B located on NSTL3-3B/K.

Welder is identified as 050295. ZPMC QC is identified as Mr. Wan Wen Zhong.

The welding variables recorded by QC appeared to comply with WPS-B-T-2221-C-U2b-S-2.

North Tower Lift 3 Corner Seam Skin A/B

SAW welding of weld joint 83B located on NSTL3-3B/K.

Welder is identified as 207745. ZPMC QC is identified as Mr. Wan Wen Zhong.

The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-L2c-S-2.

South Tower Lift 4 Skin E Doubler Plate

FCAW welding of weld joint 3 located on SSD1-FESA4-1C/F.

Welder is identified as 066164. ZPMC QC is identified as Mr. Ma Yun.

The welding variables recorded by QC appeared to comply with WPS-B-T-4332-Tc-P4-F.

FCAW welding of weld joint 16 located on SSD1-FESA4-1B/F.

Welder is identified as 066673. ZPMC QC is identified as Mr. Ma Yun.

The welding variables recorded by QC appeared to comply with WPS-B-T-4332-Tc-P4-F.

North Tower Lift 1 Corner Seam Skin A/E (WRR No. T-WR1668)

FCAW welding of weld joint 4A/B (Repair) located on NSD1-A112B/H.

Welder is identified as 053870. ZPMC QC is identified as Mr. Sun Tian Liang.

The welding variables recorded by QC appeared to comply with WPS-345-FCAW-2G-REPAIR.

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 Serge Sinevod : 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Umesh	Quality Assurance Inspector
----------------------	---------------	-----------------------------

Reviewed By:	Clifford,William	QA Reviewer
---------------------	------------------	-------------