

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-008824**Date Inspected:** 01-Sep-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:	Yu Dong Ping, Xu Le Feng.	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 3 Gusset Plate between skin D stiffeners

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% and Visual Testing (VT) of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT reports for this date. The members are identified as Tower Components. The weld designations reviewed are as follows.

NSD1-FDSA3-1C/C-4, 37

West Tower Lift 1 Diagonal Stiffener Plate to corner BC at Outside Milling Position

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.

WSD1-A423H/H-15

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Bay 10 North Tower Lift 3 Corner Seam D/E internal (Double Diaphragms 1200mm length)

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% and Visual Testing (VT) of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT reports for this date. The members are identified as Tower Components. The weld designations reviewed are as follows.

NSTL3-3B/K-85A

Bay 11 East Tower Lift 3 Skin B/C (Outside)

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% and Visual Testing (VT) of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT reports for this date. The members are identified as Tower Components. The weld designations reviewed are as follows.

ESTL3-4B/K-84B

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

Bay 11

SMAW welding of weld joint 1A/B (Repair) located on SD1-A5002-16.
Welder is identified as 046704. ZPMC QC is identified as Mr. Liu Ying.
The welding variables recorded by QC appeared to comply with WPS-485-SMAW-1G-REPAIR.

FCAW welding of weld joint 1 located on WSD1-FDSA4-4C/D.
Welder is identified as 066251. ZPMC QC is identified as Mr. Li Lin.
The welding variables recorded by QC appeared to comply with WPS-B-T-4332-Tc-P5-F.

SAW welding of weld joint 6A located on WD1-A6003-7.
Welder is identified as 044550. ZPMC QC is identified as Xu Chen Xia.
The welding variables recorded by QC appeared to comply with WPS-B-T-4221-B-U3c-S-1.

Strut Plate

SMAW welding of weld joint 7A located on SD1-A6002-4.
Welder is identified as 066028. ZPMC QC is identified as Mr. Mao Bin Bin.
The welding variables recorded by QC appeared to comply with WPS-B-T-3212-Tc-U5b-1.

SMAW welding of weld joint 11B located on WD1-A6001-7.
Welder is identified as 040656. ZPMC QC is identified as Mr. Liu Ying.
The welding variables recorded by QC appeared to comply with WPS-B-T-2212-Tc-U5b.

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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 Jim Simonis - 134-7246-3441, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Umesh	Quality Assurance Inspector
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Reviewed By:	Clifford,William	QA Reviewer
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