

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-009310**Date Inspected:** 12-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:	Chen Ying Xin, Ma Yun, Du Zhi			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 South Tower skin D Interior Splice Area

This QA inspector performed Ultrasonic Testing (UT), Magnetic Particle Testing (MT) and Visual Testing (VT) of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT and MT reports for this date. The members are identified as Tower Components. The weld designations reviewed are as buttering area of skin D interior splice plate.

This QA inspector issued Green Tag for the above part. The Green Tag no. is 5618R1.

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

Bay 10

North Tower Lift 4 skin E Doubler Plate

FCAW welding of weld joint 3 located on NSD1-FESA4-3E/F.

Welder is identified as 037907. ZPMC QC is identified as Mr. Chen Ying Xin.

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The welding variables recorded by QC appeared to comply with WPS-B-T-4332-Tc-P4-F-1.

FCAW welding of weld joint 12 located on NSD1-FESA4-3C/F.

Welder is identified as 068918. ZPMC QC is identified as Mr. Chen Ying Xin.

The welding variables recorded by QC appeared to comply with WPS-B-T-4332-Tc-P4-F-1.

South Tower Interior Splice Plate

FCAW welding of weld joint 3B located on SSD1-SPSA3-70.

Welder is identified as 053870. ZPMC QC is identified as Mr. Du Zhi Qun.

The welding variables recorded by QC appeared to comply with WPS-B-T-2231-Tc-U5-F-1.

North Tower Lift 3 Skin E Padeye

SMAW welding of weld joint 35 located on NSD1-FESA3-1A/D.

Welder is identified as 057220. ZPMC QC is identified as Mr. Gao Zhi Chun.

The welding variables recorded by QC appeared to comply with WPS-B-P-2114-Padeye.

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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