

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-009316**Date Inspected:** 20-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:	Du Zhi Qun, Li Ming, Chen Ying			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:

Milling Position West Tower Lift 1

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% and random 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.

WSD1-SA294F/G-100, 102

WSD1-SA295C/E-27, 26, 75, 64

WSD1-A423D/H-8, 10

WSD1-SA51-3

WSD1-SA81-5

WSD1-SA84-5, 7

WSD1-SA82-4

WSD1-SA85-2

WSD1-SA140-4, 6

WSD1-SA141-5

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

WSD1-SA142-2, 4
WSD1-SA143-3
WSD1-SA144-6
WSD1-SA225A/H-68, 70
WSD1-SA225F/H-77, 78

Milling Position West Tower Lift 1 the splice weld between the C/D diagonal plate

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% and random Visual Testing (VT) 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-A115J/J-26, 27, 28, 51, 52
WSD1-A423H/H-6~10, 16~20

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

Bay 10

SOUTH TOWER LIFT 3 CORNER SEAM A/E

FCAW welding of weld joint 84A/B(Repair) located on SSSL3-1B/K.
Welder is identified as 050289. ZPMC QC is identified as Mr. Jiang Xiao Bo.
The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G-REPAIR.

Bay 11

FCAW welding of weld joint 2A/B located on ESD1-SPSA3-53.
Welder is identified as 048810. ZPMC QC is identified as Mr. Li Lin.
The welding variables recorded by QC appeared to comply with WPS-345-FCAW-2G(2F)-REPAIR.

FCAW welding of weld joint 2A/B located on ESD1-SPSA3-55.
Welder is identified as 053316. ZPMC QC is identified as Mr. Li Lin.
The welding variables recorded by QC appeared to comply with WPS-345-FCAW-2G(2F)-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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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
Reviewed By:	Clifford,William	QA Reviewer
