

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-009480**Date Inspected:** 05-Oct-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:	Xu Xian Ping	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:	OBG / Tower Subassemblies	

Summary of Items Observed:

On this day Caltrans OSM Quality Assurance (QA) Inspector Stefan Holmes was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China.

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #010 located on Traveller Rail - 11TR2-015. Welder is identified as 205390. ZPMC QC is identified as Li Yong. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-TC-U5-F.

FCAW process welding of weld joint #014 located on Traveller Rail - 11TR2-015. Welder is identified as 068858. ZPMC QC is identified as Li Yong. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-TC-U5-F.

SMAW process welding of weld joint #007A located on Tower Strut - WD1-A305-53M-3. Welder is identified as 067707. ZPMC QC is identified as Xu Xian Ping. The welding variables recorded by QC appeared to comply with the WPS-485-SMAW-2G(2F)-FCM-Repair-1.

SMAW process welding of weld joint #065 located on Cross Beam (CB8) - CB202G-020. Welder is identified as 070007. ZPMC QC is identified as Xu Xian Ping. The welding variables recorded by QC appeared to comply with the

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WPS-B-P-2112.

SMAW process welding of weld joint #081 located on Cross Beam (CB8) - CB202G-020. Welder is identified as 070007. ZPMC QC is identified as Xu Xian Ping. The welding variables recorded by QC appeared to comply with the

WPS-B-P-2112.

Magnetic Particle Testing

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 members are identified as Tower Components. The weld designations reviewed are as follows:

143M Tower Diaphragm - Green Tag No. 09252

1. NSD1-DPSA4-9A/B-3-8, 26, 1
2. NSD1-SA4-57-3-8
3. NSD1-DPSA4-9B/B-27, 2
4. NSD1-DPSA4-9B/B-8-11, 14, 15, 18, 19

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

No relevant conversations.

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 , who represents the Office of Structural Materials for your project.

Inspected By:	Holmes,Stefan	Quality Assurance Inspector
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Reviewed By:	Hall,Steven	QA Reviewer
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