

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-009487**Date Inspected:** 28-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:	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:

SMAW process welding of weld joint #001 located on Traveller Rail - 10TR2-021. Welder is identified as 068858. ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-BU2-F.

SMAW process welding of weld joint #001 located on Traveller Rail - 10TR2-022. Welder is identified as 068858. ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-BU2-F.

SMAW process welding of weld joint #002 located on Traveller Rail - 10TR2-021. Welder is identified as 205390. ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-BU2-F.

SMAW process welding of weld joint #002 located on Traveller Rail - 10TR2-022. Welder is identified as 205390. ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-BU2-F.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

SMAW process welding of weld joint #001 located on Traveller Rail - 10TR1-026. Welder is identified as 215009. ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-BU2-F.

SMAW process welding of weld joint #001 located on Traveller Rail - 10TR1-027. Welder is identified as 215009. ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-BU2-F.

SMAW process welding of weld joint #002 located on Traveller Rail - 10TR1-026. Welder is identified as 217185. ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-BU2-F.

SMAW process welding of weld joint #002 located on Traveller Rail - 10TR1-027. Welder is identified as 217185. ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-BU2-F.

FCAW process welding of weld joint #148 located on Cross Beam (CB8) - CB202G-020. Welder is identified as 053609. ZPMC QC is identified as Xu Xian Ping. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132.

FCAW process welding of weld joint #166 located on Cross Beam (CB8) - CB202G-020. Welder is identified as 053609. ZPMC QC is identified as Xu Xian Ping. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132.

FCAW process welding of weld joint #148 located on Cross Beam (CB8) - CB202G-019. Welder is identified as 053742. ZPMC QC is identified as Xu Xian Ping. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132.

FCAW process welding of weld joint #166 located on Cross Beam (CB8) - CB202G-019. Welder is identified as 053742. ZPMC QC is identified as Xu Xian Ping. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132.

Ultrasonic Testing

This QA inspector performed MT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a UT report for this date. The members are identified as TOWER Components. The weld designations reviewed are as follows:

TOWER STRUT ANGLE

- | | | |
|-------------------------|-------------------------|--------------------------|
| 1. ND1-SA658-53M-5-1A/B | 2. ND1-SA658-53M-3-1A/B | 3. ND1-SA658-53M-14-1A/B |
| 4. ND1-SA658-53M-6-1A/B | 5. ND1-SA658-53M-1-1A/B | 6. ND1-SA658-53M-2-1A/B |

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

- | | | |
|---------------------------|---------------------------|---------------------------|
| 7. ND1-SA658-53M-7-1A/B | 8. ND1-SA658-53M-9-1A/B | 9. ND1-SA658-53M-13-1A/B |
| 10. ND1-SA658-53M-12-1A/B | 11. ND1-SA658-53M-8-1A/B | 12. ND1-SA658-53M-11-1A/B |
| 13. ND1-SA658-53M-4-1A/B | 14. ND1-SA658-53M-10-1A/B | 15. ND1-SA658-53M-16-1A/B |
| | | |
| 1. ND1-SA658-77M-11-1A/B | 2. ND1-SA658-77M-4-1A/B | 3. ND1-SA658-77M-16-1A/B |
| 4. ND1-SA658-77M-14-1A/B | 5. ND1-SA658-77M-15-1A/B | 6. ND1-SA658-77M-6-1A/B |
| 7. ND1-SA658-77M-13-1A/B | 8. ND1-SA658-77M-3-1A/B | 9. ND1-SA658-77M-9-1A/B |
| 10. ND1-SA658-77M-2-1A/B | 11. ND1-SA658-77M-10-1A/B | 12. ND1-SA658-77M-1-1A/B |
| | | |
| 1. ND1-SA658-65M-16-1A/B | 2. ND1-SA658-65M-15-1A/B | 3. ND1-SA658-65M-4-1A/B |
| 4. ND1-SA658-65M-5-1A/B | 5. ND1-SA658-65M-7-1A/B | 6. ND1-SA658-65M-13-1A/B |
| 7. ND1-SA658-65M-9-1A/B | 8. ND1-SA658-65M-14-1A/B | 9. ND1-SA658-65M-6-1A/B |

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
Reviewed By:	Hall,Steven	QA Reviewer
