DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-009631
Date Inspected: 04-Oct-2009

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 700
OSM Departure Time: 1900
Location: Shanghai, China

CWI Name: Wan Wen Zhong, Chen Ying Xin.

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 Lift 3 AB corner seam (Inside)

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.

SSTL3-1B/K-83A (The area 330mm from 105.5M diaphragm) Green Tag No. 10665

Bay 11 Angle Plate

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.

ED1-SA183-28M-3

WD1-SA183-28M-4
ED1-SA183-33M-2
ED1-SA183-38M-4 (One Class “A” indication found, UT Rejected, Incident Report)
ED1-SA183-47.6M-2
WD1-SA183-38M-3
WD1-SA183-33M-4
WD1-SA183-43M-1
ED1-SA183-18M-2

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

Bay 10

FCAW welding of weld joint 3B located on NSD1-SPSA3-70.
Welder is identified as 040261. ZPMC CWI is identified as Mr. Gong Liang Zhu.
The welding variables recorded by QC appeared to comply with WPS-B-T-2231-Tc-U5-F.

SMAW welding of weld joint 9B located on ED1-A6003-5.
Welder is identified as 052930. ZPMC CWI is identified as Mr. Chen Ying Xin.
The welding variables recorded by QC appeared to comply with WPS-B-T-3212-Tc-U5b-1.

SMAW welding of weld joint 49 located on ED1-A6003-4.
Welder is identified as 066028. ZPMC CWI is identified as Mr. Chen Ying Xin.
The welding variables recorded by QC appeared to comply with WPS-B-T-2112.

SAW welding of weld joint 4B located on ED1-STSA3-2-109M-1.
Welder is identified as 052917. ZPMC QC is identified as Mr. Yu Zhi Lai.
The welding variables recorded by QC appeared to comply with WPS-B-T-4221-B-U3c-S-1.

Bay 11

SAW welding of weld joint 8A located on WD1-STSA3-2-89M-1.
Welder is identified as 040699. ZPMC CWI is identified as Mr. An Qing Xiang.
The welding variables recorded by QC appeared to comply with WPS-B-T-4221-B-U3c-S-1.

During random 10% verification Ultrasonic Testing (UT) on weld joint ED1-SA183-38M-4, Caltrans Quality Assurance (QA) Inspector discovered class “A” non conforming indication measuring approximately 10mm in length. This weld was previously tested and accepted by ZPMC Quality Control (QC) UT technician. (NDT Inspection Notification Sheet # 004346). This issue has an incident report.
The attached photographs provide additional detail.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

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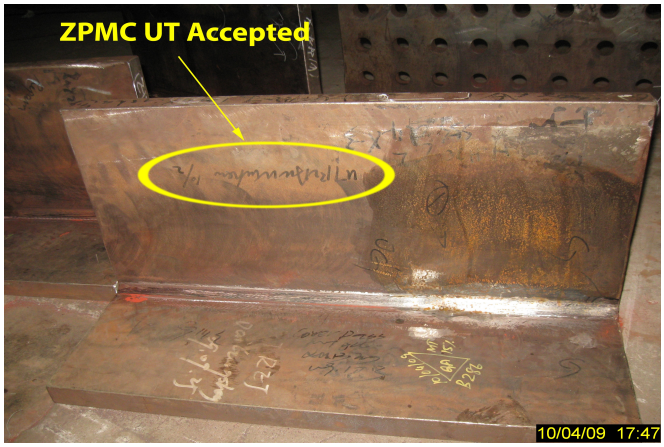

Summary of Conversations:

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 Serge Sinevod 134-8257-0045, who represents the Office of Structural Materials for your project.

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