

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: 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-009638**Date Inspected:** 12-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:** Yu Dong Ping, Feng Guo.**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 11 Tower Connection Bracket

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.

ED1-SA183-38M-4 (After Repair) Green Tag No. 9274

Bay 11 Tower Spare Strut

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.

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WD1-A6001-2

Bay 11 Tower Angle Plate

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.

ED1-SA183-47.6M-1

ED1-SA183-47.6M-4

ED1-SA183-43M-1 Green Tag No. 9276

ED1-SA183-23M-3

ED1-SA183-43M-4

WD1-SA183-43M-3

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

Bay 11

SAW welding of weld joint 1B located on WD1-SA3-18-109M-1.

Welder is identified as 042195. ZPMC QC is identified as Mr. Mao Bin Bin.

The welding variables recorded by QC appeared to comply with WPS-B-T-3221-Tc-U5-S-1.

SMAW welding of weld joint 1A located on WD1-SA3-18-89M-1.

Welder is identified as 058009. ZPMC CWI is identified as Yu Dong Ping.

The welding variables recorded by QC appeared to comply with WPS-B-T-3211-Tc-U5b-1.

SMAW welding of weld joint 1B located on SD1-SA3-16-99M-1.

Welder is identified as 040614. ZPMC QC is identified as Mr. Liu Dao Feng.

The welding variables recorded by QC appeared to comply with WPS-B-T-3211-Tc-U5b-1.

Strut Plate Repair

SMAW welding of weld joint 10A/B located on WD1-A6003-2.

Welder is identified as 040733. ZPMC QC is identified as Mr. Mao Bin Bin.

The welding variables recorded by QC appeared to comply with WPS-485-SMAW-2G(2F)-FCM-REPAIR-1.

SMAW welding of weld joint 7A/B located on WD1-A6003-4.

Welder is identified as 049099. ZPMC QC is identified as Mr. Mao Bin Bin.

The welding variables recorded by QC appeared to comply with WPS-485-SMAW-2G(2F)-FCM-REPAIR-1.

During random verification Visual Testing (VT), Caltrans Quality Assurance (QA) Inspector observed crack like indication on temporary weld removed area of skin E of west tower lift 3. After confirmation by MT, linear

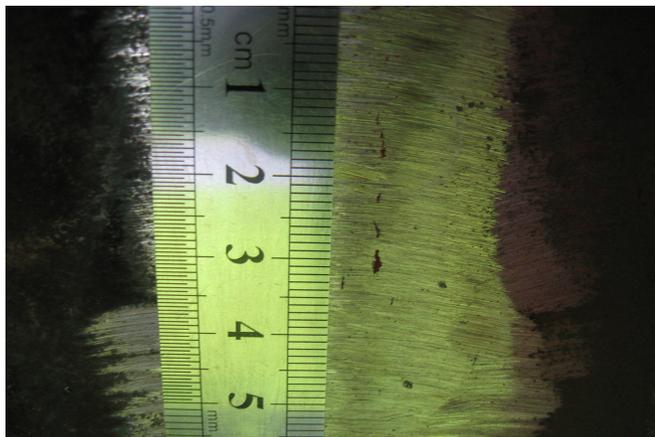
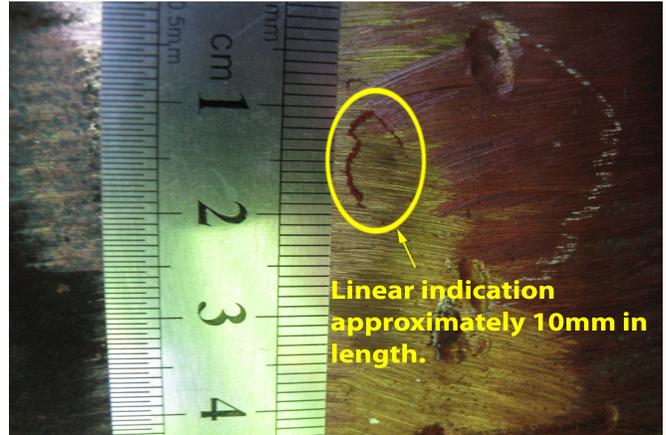
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indications observed.

The attached photographs provide additional detail.

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 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