

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-009639**Date Inspected:** 13-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:** Chen Ying Xin, 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:

Milling Section East Tower Lift 3 A/B corner seam

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.

ESTL3-4B/K-85A (MT Linear Indication observed, Incident Report)

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-4.

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.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

SMAW welding of weld joint 1B located on WD1-SA3-18-89M-8.

Welder is identified as 040669. 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.

East Tower Lift 4 Diaphragm to skin C

FCAW welding of weld joint 141 located on ESTL4-2C/L.

Welder is identified as 048810. ZPMC CWI is identified as Mr. Zhao Bo.

The welding variables recorded by QC appeared to comply with WPS-B-T-4332-Tc-P5-F.

Bay 10

SAW welding of weld joint 51B located on ND1-STSA3-1-89M-1.

Welder is identified as 040252. ZPMC QC is identified as Mr. Yuan Hui Gang.

The welding variables recorded by QC appeared to comply with WPS-B-T-4221-B-U3c-S-1.

SAW welding of weld joint 4A located on ND1-STSA3-1-109M-1.

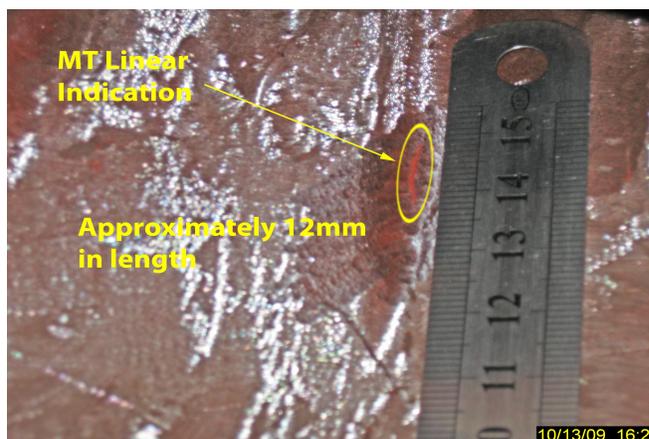
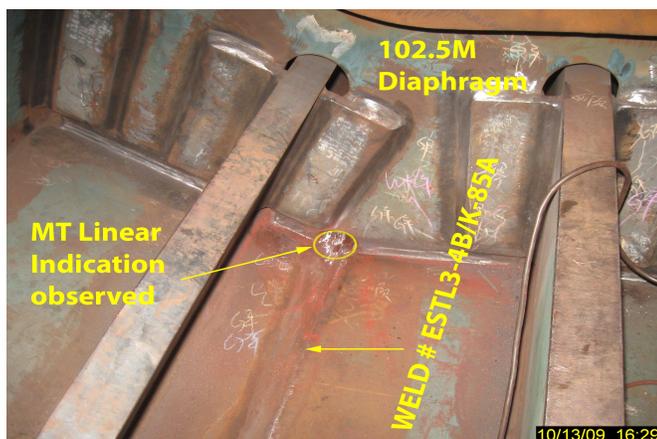
Welder is identified as 052917. ZPMC QC is identified as Mr. Yuan Hui Gang.

The welding variables recorded by QC appeared to comply with WPS-B-T-4221-B-U3c-S-1.

During random verification Magnetic Particle Testing (MT) of A/B corner seam of East tower lift 3, weld ESTL3-4B/K-85A located in the Milling section, Caltrans Quality Assurance (QA) Inspector discovered a linear indication of approximately 12mm in length at 102.5M diaphragm. This area had been previously tested and accepted by ZPMC NDT personnel. (NDT Inspection Notification sheet # 004395)

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:

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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
