

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-009912**Date Inspected:** 30-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1630**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **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 North Tower Lift 3 B/C corner seam between 102.5M ~ 105.5M diaphragm

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15%, Ultrasonic Testing (UT) of approximately 10% 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.

NSTL3-3B/K-82A (MT & VT)

NSTL3-3B/K-82 (UT)

Bay 10 North Tower Lift 3 Triangle Plate of B/C corner

This QA inspector performed random Visual Testing (VT) of the area previously tested and accepted by ZPMC Quality Control personnel. The members are identified as Tower Components. The weld designations reviewed are as follows.

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NSTL3-3D/K-22, 23

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

Bay 10

North Tower lift 3 B/C diagonal splice

FCAW welding of weld joint 28 located on NSTL3-3K/K.

Welder is identified as 062782. ZPMC QC is identified as Mr. Gong Liang Zhu.

The welding variables recorded by QC appeared to comply with WPS-B-T-2233-B-U2a-F.

Strut Plates

SMAW welding of weld joint 7A located on ND1-A6002-15.

Welder is identified as 040582. ZPMC QC 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 48 located on ED1-A6001-1.

Welder is identified as 070432. ZPMC CWI is identified as Mr. Chen Ying Xin.

The welding variables recorded by QC appeared to comply with WPS-B-T-2112.

South Tower Lift 4 B/C corner seam

SMAW welding of weld joint 5A located on SSTL4-1B/L.

Welder is identified as 040491. ZPMC CWI is identified as Mr. Wan Wen Zhong.

The welding variables recorded by QC appeared to comply with WPS-B-P-2214-C-U2.

South Tower Lift 4 C/D corner seam

FCAW welding of weld joint 1A located on SSTL4-1B/L.

Welder is identified as 066064. ZPMC CWI is identified as Mr. Wan Wen Zhong.

The welding variables recorded by QC appeared to comply with WPS-B-T-2232-C-U2-F.

South Tower Lift 4 D/E corner seam

FCAW welding of weld joint 2A located on SSTL4-1B/L.

Welder is identified as 070046. ZPMC CWI is identified as Mr. Wan Wen Zhong.

The welding variables recorded by QC appeared to comply with WPS-B-T-2231-C-U2-F.

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

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remedial efforts please contact Jim Simonis - 134-7246-3441, who represents the Office of Structural Materials for your project.

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