

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-010132**Date Inspected:** 30-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, Gong Liang Zhu			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:

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

Bay 10

FCAW welding of weld joint 22 located on SD1-A440D/E-4.

Welder is identified as 057206. ZPMC CWI is identified as Mr. Du Zhi Qun.

The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

SMAW welding of weld joint 10A/B (Repair) located on ND1-A6002-4.

Welder is identified as 040582. ZPMC QC is identified as Mr. Yu Zhi Lai.

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

SMAW welding of weld joint 9B located on ND1-A6002-8.

Welder is identified as 040333. 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.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

SMAW welding of weld joint 29 located on ED1-A6001-3.

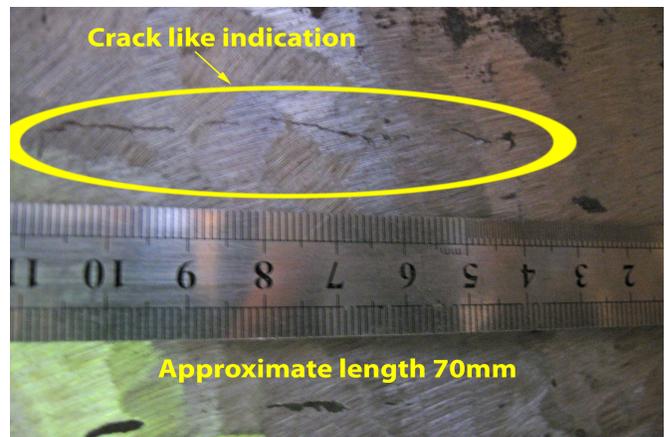
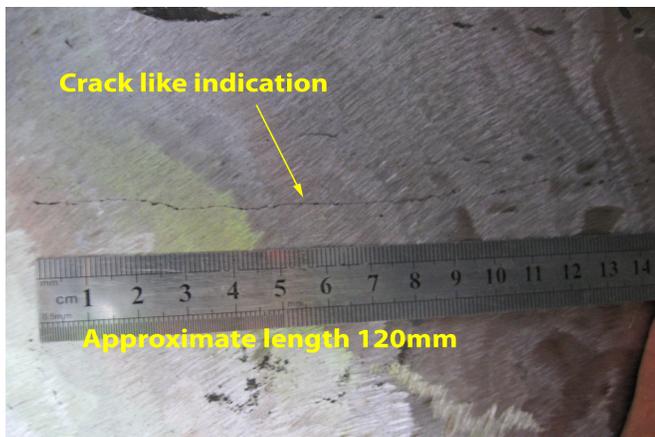
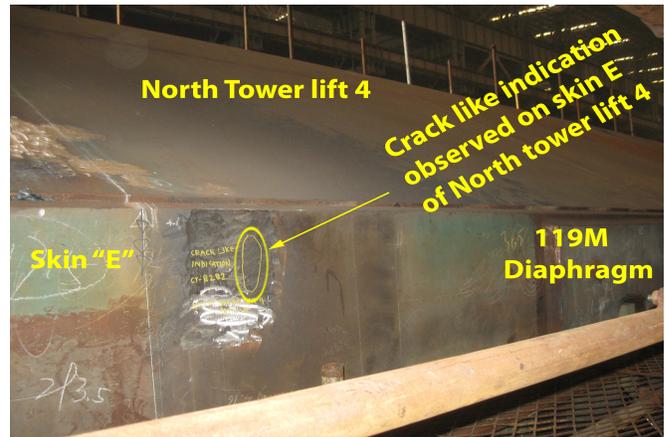
Welder is identified as 040268. ZPMC CWI is identified as Mr. Chen Ying Xin.

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

During random verification Visual Testing (VT), Caltrans Quality Assurance (QA) Inspector observed crack like indications on temporary attachment weld removed area of skin E of North tower lift 4. The attached photographs provide additional detail.

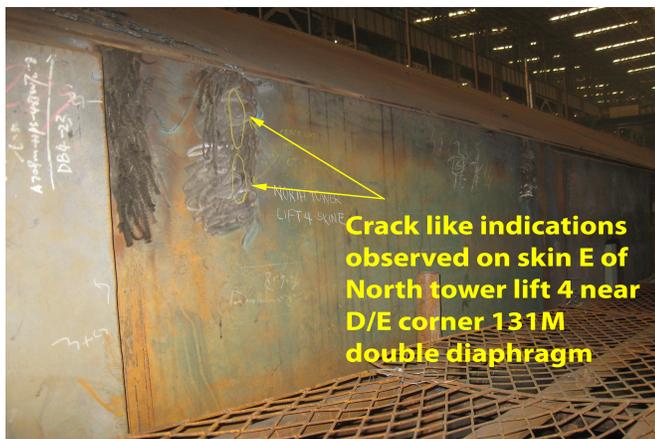
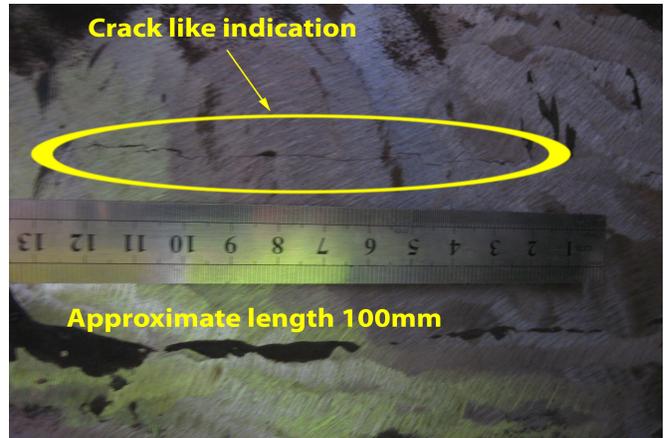
During random verification Visual Testing (VT), Caltrans Quality Assurance (QA) Inspector observed a padeye was missing on skin E of North tower lift 1 in between 43M and 47.6M double diaphragm. The attached photographs provide additional detail.

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



WELDING INSPECTION REPORT

(Continued Page 3 of 3)



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