

**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-010264**Date Inspected:** 05-Nov-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

<b>CWI Name:</b>	Chen Ying Xin, Wang Chuan Qing			<b>CWI Present:</b>	<b>Yes</b>	<b>No</b>	
<b>Inspected CWI report:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Approved WPS:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
				<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Bridge No:</b>	34-0006			<b>Component:</b>	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 Strut Web Plate

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% 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.

ND1-STSA3-1-89M-1-51A/B  
ND1-STSA3-1-99M-1-51A/B  
ND1-STSA3-1-109M-1-51A/B  
ND1-STSA3-1-89M-1-2A/B  
ND1-STSA3-1-99M-1-2A/B  
ND1-STSA3-1-109M-1-2A/B

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

Bay 10

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SMAW welding of weld joint 1A located on ED1-SA3-18-99M-5.

Welder is identified as 050289. ZPMC CWI is identified as Mr. Chen Ying Xin.

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 ND1-SA3-16-109M-1.

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-3211-Tc-U5b-1.

SMAW welding of weld joint 29 located on ND1-A6002-15.

Welder is identified as 066443. ZPMC QC is identified as Mr. Yuan Hui Gang.

The welding variables recorded by QC appeared to comply with WPS-B-T-4113-1.

South Tower Lift 4 D/E corner seam

SMAW welding of weld joint 1A located on SSSL4-1L/L.

Welder is identified as 052493. ZPMC QC is identified as Mr. Gao Zhi Chun.

The welding variables recorded by QC appeared to comply with WPS-B-T-3212-Tc-U4b-1.

North Tower Lift 4 B/C corner seam

SMAW welding of weld joint 5A located on NSTL4-3B/L.

Welder is identified as 056200. ZPMC CWI is identified as Mr. Gong Liang Zhu.

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

During random in process Visual inspection, Caltrans QA inspector observed ZPMC personnel performing repair welding without any relevant documents in presence of ZPMC QA on Spare Strut plate WD1-A6003-2 which was UT rejected by Caltrans QA inspector.

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



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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.

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<b>Inspected By:</b>	Gaikwad,Umesh	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

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