

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-010289**Date Inspected:** 20-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

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:

Bay 11 Rotational Capacity Test

This QA inspector witnessed the lot testing of the A325 High Strength Bolts to determine the torque values for the minimum tension required. Below is a list of the lots tested and the average torque values determined. Also witnessed the Rotational Capacity Testing on same lot numbers.

DHGM270025-847Nm
DHGM270026-827Nm
DHGM270027-860Nm
DHGM240097-580Nm
DHGM270019-827Nm
DHGM270021-853Nm
DHGM270020-847Nm
DHGM240095-580Nm
DHGM270017-893Nm

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

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

Bay 10

SMAW welding of weld joint 64B located on ED1-STSA3-2-99M-2.

Welder is identified as 057266. 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.

SMAW welding of weld joint 21 located on ND1-A6002-10.

Welder is identified as 066443. ZPMC CWI is identified as Mr. Chen Ying Xin.

The welding variables recorded by QC appeared to comply with WPS-B-T-2113.

SMAW welding of weld joint 27 located on ND1-A6002-9.

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-4113-1.

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
---------------------	------------------	-------------