

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-010937**Date Inspected:** 12-Dec-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:** Du Zhi Qun, 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 SOUTH TOWER LIFT 2 SKIN C CABLE TRAY

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.

B22-2-EL60.524M-2-1-S

B22-2-EL60.524M-2-2-S

B22-2-EL73.831M-1-1-S

B22-2-EL73.831M-1-2-S

B22-2-EL75.154M-1-1-S

B22-2-EL75.154M-1-2-S

B22-2-EL76.077M-1-1-S

B22-2-EL79.160M-1-1-S

B22-2-EL79.160M-1-2-S

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B22-2-EL79.160M-2-1-S
B22-2-EL79.160M-2-2-S
B22-2-EL80.584M-1-1-S
B22-2-EL80.584M-1-2-S
B22-2-EL80.584M-2-1-S
B22-2-EL80.584M-2-2-S

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

Bay 10

SPARE STRUT

SMAW welding of weld joint 24B located on ED1-STSA3-2-109M-1.

Welder is identified as 040333. ZPMC QC is identified as Mr. Chen Ying Xin.

The welding variables recorded by QC appeared to comply with WPS-B-T-2212-Tc-U5b.

SMAW welding of weld joint 32 located on ED1-STSA3-2-89M-1.

Welder is identified as 056364. ZPMC QC is identified as Mr. Yu Zhi Lai.

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

SMAW welding of weld joint 20 located on ED1-STSA3-2-99M-2.

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-2113.

SMAW welding of weld joint 29 located on ED1-STSA3-2-89M-1.

Welder is identified as 066155. ZPMC QC is identified as Mr. Yu Zhi Lai.

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

NORTH TOWER LIFT 5 BEARING PLATE

SMAW welding of weld joint 5A located on ND1-BPSA5-1-2.

Welder is identified as 040269. ZPMC QC is identified as Jiang La Mei.

The welding variables recorded by QC appeared to comply with WPS-B-T-3212-Tc-U5b-1.

NORTH TOWER LIFT 4 C/D CORNER SEAM

FCAW welding of weld joint 2B located on NSTL4-3L/L.

Welder is identified as 050289. ZPMC QC is identified as Mr. Deng Zhi Bing.

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

NORTH TOWER LIFT 4 D/E CORNER SEAM

FCAW welding of weld joint 1B located on NSTL4-3L/L.

Welder is identified as 052930. ZPMC QC is identified as Mr. Deng Zhi Bing.

The welding variables recorded by QC appeared to comply with WPS-B-T-3211-Tc-U4b-1.

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

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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
