

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-011082**Date Inspected:** 14-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:** 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

This QA inspector was instructed by task leaders to carry out the measurements on the stiffeners bolt hole edge to the edge of stiffener. The measurements carried out on all stiffeners of skin A, B, C, D and E wherever accessible and recorded on the sheet. The members are identified as Tower Components. The member designations reviewed are as follows.

NORTH TOWER LIFT 3 TOP

SOUTH TOWER LIFT 3 TOP

SOUTH TOWER LIFT 2 TOP

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

Bay 10

INTERIOR SPLICE PLATE

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FCAW welding of weld joint 3A located on NSD1-SPSA4-18.

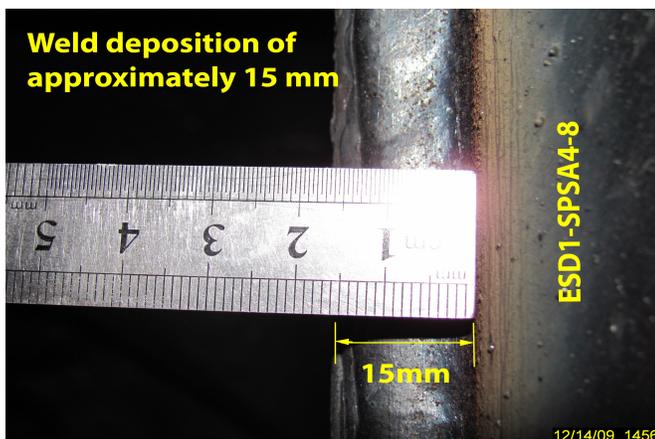
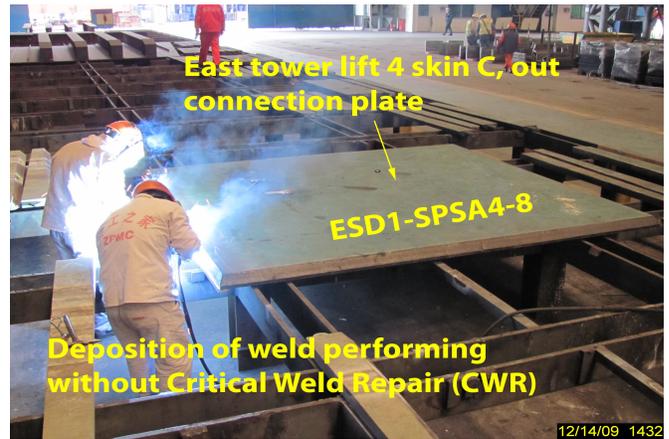
Welder is identified as 053870. ZPMC QC is identified as Mr. Lu Wei Chao.

The welding variables recorded by QC appeared to comply with WPS-B-T-2231-Tc-U5-F.

During random in-process Visual inspection of out connection plate of East tower LIFT 4 skin C, ESD1-SPSA4-8 this Caltrans Quality Assurance (QA) inspector observed the deposition of weld metal (buttering/build up) by Flux Core Arc Welding (FCAW) process on the base metal of out connection plate of skin C of East tower lift 4 measured to be approximately 15mm without approved Critical Welding Repair (CWR) report. The welders are identified as 059525 and 049220 with Welding Repair Report (WRR) T-WR2798. The maximum deposition of weld metal allowed is 10mm. This issue has an incident report.

The attached photographs provide additional detail.

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 Serge Sinevod 134-8257-0045, who represents the Office of Structural Materials for your project.

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