

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-011084**Date Inspected:** 16-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/ OUTSIDE YARD

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 of tower and interior splice plate wherever accessible and recorded on the sheet. The members are identified as Tower Components. The member designations reviewed are as follows.

EAST TOWER LIFT 2 BOTTOM

EAST TOWER LIFT 3 TOP

EAST TOWER LIFT 2 ~ LIFT 3 SKIN A, B, C, D, E SPLICE PLATE

WEST TOWER LIFT 2 ~ LIFT 3 SKIN B SPLICE PLATE

WEST TOWER LIFT 2 ~ LIFT 3 SKIN E SPLICE PLATE

SOUTH TOWER LIFT 2 ~ LIFT 3 SKIN A SPLICE PLATE

SOUTH TOWER LIFT 2 ~ LIFT 3 SKIN D SPLICE PLATE

WEST TOWER LIFT 2 ~ LIFT 3 SKIN C SPLICE PLATE

NORTH TOWER LIFT 2 ~ LIFT 3 SKIN A SPLICE PLATE

WELDING INSPECTION REPORT

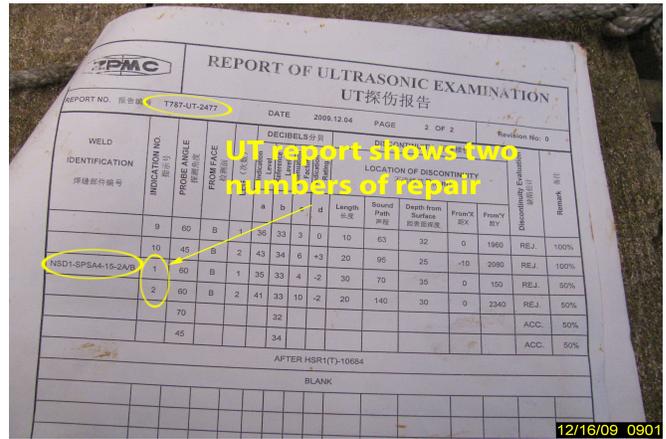
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WEST TOWER LIFT 2 ~ LIFT 3 SKIN C SPLICE PLATE

During random in-process Visual inspection of corner splice assembly of North tower lift 3 ~ lift 4, weld NSD1-SPSA4-15-2A/B, this Caltrans Quality Assurance (QA) inspector observed that the repair welding performed by ZPMC at three locations but as per Welding Repair Report (WRR) T-WR2796 with Ultrasonic Testing (UT) report no. T787-UT-2477 it shows only two numbers of repair found by ZPMC.

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 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