

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-011108**Date Inspected:** 22-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, Du Zhi Qun**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 TOWER SPARE STRUT

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% and random Visual Testing (VT) of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as Tower Components. The weld designations reviewed are as follows.

ND1-A6002-10-7, 8, 9, 10, 11, 12 GREEN TAG NO. 9331

ND1-A6002-4-7, 8, 9, 10, 11, 12 GREEN TAG NO. 9332

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

Bay 10

TOWER CORNER SPLICE PLATE REPAIR

FCAW welding of weld joint 1A/B(Repair) located on NSD1-SPSA4-15.

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Welder is identified as 040261. ZPMC CWI is identified as Mr. Du Zhi Qun.

The welding variables recorded by QC appeared to comply with WPS-345-FCAW-1G(1F)-REPAIR.

TOWER STRUT PLATE REPAIR

SMAW welding of weld joint 3B(Repair) located on ED1-STSA3-2-99M-1.

Welder is identified as 057258. ZPMC CWI is identified as Mr. Chen Ying Xin.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G(2F)-FCM-REPAIR.

BAY 11

INTERIOR SPLICE PLATE

FCAW welding of weld joint 4B located on WSD1-SPSA4-3.

Welder is identified as 040723. ZPMC QC is identified as Mr. Li Jun.

The welding variables recorded by QC appeared to comply with WPS-B-T-2231-Tc-U4b-F.

FCAW welding of weld joint 4A located on ESD1-SPSA4-3.

Welder is identified as 040775. ZPMC QC is identified as Mr. Li Jun.

The welding variables recorded by QC appeared to comply with WPS-B-T-2231-Tc-U4b-F.

During random in-process Visual inspection of North Tower lift 4 skin A, this QA inspector observed the crack like indication of approximately 35mm in length on skin A near AE corner at 116M. The member is located in Bay 10.

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

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