

**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-011559**Date Inspected:** 08-Jan-2010**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:** Mr. Tujun**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 Inspector (QA) Surendra Prabhu was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (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&11(TOWER)**

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) repair of weld joint NSTL4-3B/L-3A/B located on FOURTH LIFTING TOWER(N). Welder is identified as 040269. ZPMC Certified Welding Inspector (CWI) identified as Tujun. The welding variables recorded by QC appeared to comply with WPS: 345-SMAW-2G(2F)Repair.

**BAY-10(TOWER)**

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted notification No: 005022.

**Magnetic Particle Testing (MT)**

MT of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT Report for this date. The members are identified as 1.

SSD1-A681-1-06,08,84,85,89,90,92~99,45,47,112,113,103,109,131,135,136,129,122.

2.WD1-STSA3-2-109M-2-52,60,55,3741,45,32,36,61A,19,21,23.

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# WELDING INSPECTION REPORT

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The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted notification No: 005022.

**Visual Inspection(VT)**

This QA Inspector performed VT of the area previously Tested and accepted by ZPMC QC Personnel. The members are identified as:

- 1.SSD1-A681-1-06,08,84,85,89,90,92~99,45,47,112,113,103,109,131,135,136,129,122.
- 2.WD1-STSA3-2-109M-2-52,60,55,3741,45,32,36,61A,19,21,23.

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 Quality Control (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 Skyler Guest 15000422360, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Prabhu,Surendra	Quality Assurance Inspector
<b>Reviewed By:</b>	Miller,Mark	QA Reviewer

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