

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-011957**Date Inspected:** 20-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:** Yu Dong Ping.**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 Shailesh 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:

OBG TRIAL ASSEMBLY:

This QA Inspector performed Magnetic Particle Testing (MT) of approximately 15% and randomly Visual Testing of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL- 6028 (MT) report for this date. The member is identified as U Ribs, Deck Panel and Deck Panel Diaphragm. The weld designations reviewed are as follows.

SEG 5AW.

PP31-DP108-002-81,82,84,86,87,89,91,92,94,95,97,100,99,102,103,105,108,107,110,111,113.

PP31-DP189-001-100,101,103,105,106,108,111,110,113,114,116,118,119,121,122,124,127,126,129,130,132,134,135,137,138,140

PP31-DP216-001-100,101,103,105,106,108,111,110,113,114,116,18,119,121.122,124,126,127,129,130,132,134,135,137,138,140.

PP31-DP243-001-100,101,103,105,106,108,111,110,113,114,116,18,119,121.122,124,126,127,129,130,132,134,135,137,138,140.

PP31-DP270-001-62,63,65,67,68,70,72,73,75,76,78,80,81,83,84,86.

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This QA Inspector observed the following work in progress:

BAY 10

This QA Inspector observed ZPMC qualified welding personnel identified as 040365. Perform Shielded Metal Arc Welding (SMAW) on South Tower Lift 5 A/E corner joint. Joint identified as SSD1-TL5-1B-F-36B, ZPMC QC Identified as Wang Hao. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-3212-Tc-U5b-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 057258. Perform Shielded Metal Arc Welding (SMAW) on South Tower Lift 5 A/B corner joint. Joint identified as SSD1-TL5-1B-F-37B, ZPMC QC Identified as Wang Hao. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-3211-Tc-U4b-1.

BAY 11

This QA Inspector observed ZPMC qualified welding personnel identified as 040690. Perform Shielded Metal Arc Welding (SMAW) on Sub Assembly. Joint identified as ED1-SA4-68-139M-3-1A,4-1A,5-1A, ZPMC QC Identified as Liu Dao Feng. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-3211-Tc-U5b-1.

Repair Welding:

This QA Inspector observed ZPMC qualified welding personnel identified as 049220, 040759. Perform Flux Core Arc Welding (FCAW) on West Tower Lift 4 D/E corner joint. Joint identified as WSTL4-2B/L-61A/B, ZPMC QC Identified as Shao Hai Lang, with welding Repair Report, WRR-T-WR2966. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-FCAW-2G (2F) Repair.

Repair Welding:

This QA Inspector observed ZPMC qualified welding personnel identified as 040723. Perform Flux Core Arc Welding (FCAW) on West Tower Lift 4 A/B corner joint. Joint identified as WSTL4-2B/L-59A/B, ZPMC QC Identified as Xu Jin Long, with welding Repair Report, WRR-T-WR2969. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-FCAW-1G (1F) Repair.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the 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 Skyler Guest phone: 15000422360, who represents the Office of Structural Materials for your project.

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