

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-011963**Date Inspected:** 31-Jan-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:** You Qi Guo.**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:

BAY 10

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 South Tower Lift 4 A/E Corner Joint. The weld designations reviewed are as follows.

SSTL4-1L/L-5A, SSTL4-1B/L-3A

NDT Notification No: 005156

This QA Inspector observed the following work in progress:

BAY 10

Repair Welding:

This QA Inspector observed ZPMC qualified welding personnel identified as 066028. Perform Shielded Metal Arc Welding (SMAW) on North Tower lift 2, Skin B/C and Skin C/D Diagonal stiffener plate, ZPMC QC Identified as Yuan Hui Gang, with Temporary welding repair report. The welding parameters as measured using QC's

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

calibrated instrument appeared to be in general compliance with WPS-345-SMAW-3G (3F) Repair.

Repair Welding:

This QA Inspector observed ZPMC qualified welding personnel identified as 056200, 052493. Perform Shielded Metal Arc Welding (SMAW) on South Tower lift 4, Skin A,B,C, D, E 485 material, Base metal repair on temporary Diaphragm area, from Inside. ZPMC QC Identified as Gao Zhi Chun , with Critical welding repair report. CWR-T-CWR567, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-485-SMAW-1G (1F) Repair-1, WPS-485-SMAW-2G (2F) Repair-1, WPS-485-SMAW-3G (3F) Repair-1, WPS-485-SMAW-4G (4F) Repair-1,

Repair Welding:

This QA Inspector observed ZPMC qualified welding personnel identified as 066236. Perform Shielded Metal Arc Welding (SMAW) on South Tower lift 5, Skin A/B corner joint, joint identified as SSD1-TL5-1B/F-37B, ZPMC QC Identified as Sun Tian Liang, with Temporarily welding repair report. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-485-SMAW-1G (1F) Repair-1.

This QA Inspector observed during random Visual inspection, ZPMC Ultrasonic Testing (UT) Inspector performed UT on repair area of North Tower lift 4 C/D corner joint. The Critical welding repair report No is CWR-T-CWR533. For more information see attached photos.

This QA Inspector observed during random Visual inspection, ZPMC Magnetic Particle Testing (MT) Inspector performed MT on Tower Strut plate. Item identified as ED1-STSA3-2-99M-2 and ED1-STSA3-2-99M-1. For more information see attached photos.

BAY 11

This QA Inspector observed ZPMC qualified welding personnel identified as 042195. Perform Submerged Arc Welding (SAW) on Strut web plate. Joint identified as ND1-STSA4-10-119M-2-1B, ND1-STSA4-10-119M-1-1B, ND1-STSA4-10-119M-2-2A, ND1-STSA4-10-119M-1-2A, ZPMC QC Identified as Yuan Ging. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-4221-B-U3c-S-1.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



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.

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