DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-012061
Date Inspected: 31-Jan-2010

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 700
OSM Departure Time: 1900
Location: Shanghai, China

CWI Name:	Liu Zhong An, 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 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 SOUTH TOWER LIFT 4, A/E CORNER SEAM
This QA inspector performed Ultrasonic Testing (UT) of approximately 10% 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.

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

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

BAY 10

SOUTH TOWER LIFT 5 A/B CORNER REPAIR
SMAW welding of weld joint 37B(Repair) located on SSD1-TL5-1B-F.
Welder is identified as 066236. ZPMC QC is identified as Mr. Deng Zhi Bing.
The welding variables recorded by QC appeared to comply with WPS-485-SMAW-1G(1F)-REPAIR-1.

SOUTH TOWER LIFT 4 SKIN A, B, C, D, E SKIN PLATE BASE METAL REPAIR (T-CWR567)
During random in process verification, this QA Inspector observed that SMAW welding on the base metal of skin "E" of South Tower lift 4. Welder is identified as 056200. ZPMC QC is identified as Mr. Gao Zhi Chun. The welding variables recorded by QC appeared to comply with WPS-485-SMAW-3G(3F)-REPAIR. Attached photographs provide additional details.

SOUTH TOWER LIFT 4 D/E CORNER SEAM
During random in process verification, this QA Inspector witnessed the Magnetic Particle Testing (MT) of D/E corner seam of South Tower lift 4 performed by ZPMC QC personnel, weld number is identified as: SSTL4-1L/L-1A. Attached photographs provide additional details.

BAY 11

TOWER STRUT FLANGE PLATE
SAW welding of weld joint 3B located on ND1-STSA4-6-135M-2.
Welder is identified as 040699. ZPMC CWI is identified as Mr. Liu Dao Feng.
The welding variables recorded by QC appeared to comply with WPS-B-T-4221-B-U3c-S-1.

SAW welding of weld joint 3B located on ED1-STSA4-6-139M-1.
Welder is identified as 040699. ZPMC CWI is identified as Mr. Liu Dao Feng.
The welding variables recorded by QC appeared to comply with WPS-B-T-4221-B-U3c-S-1.

ANGLE CONNECTION PLATE
SAW welding of weld joint 1B located on ED1-SA4-68-127M-4.
Welder is identified as 042195. ZPMC CWI is identified as Yu Dong Ping.
The welding variables recorded by QC appeared to comply with WPS-B-T-3221-Tc-U5-S-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with 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 : 15000422360, who represents the Office of Structural Materials for your project.

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