

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-012062**Date Inspected:** 01-Feb-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:	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 BACKFILL PLATE

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.

SSTL4-1C/L-40, 101 (119M DIAPHRAGM)
SSTL4-1F/L-32, 100 (123M DIAPHRAGM)
SSTL4-1I/L-29, 96 (135M DIAPHRAGM)
SSTL4-1J/L-28, 97 (139M DIAPHRAGM)
SSTL4-1K/L-31, 97 (143M DIAPHRAGM)

BAY 10 STRUT ANGLE CONNECTION PLATE

During random in process verification, this QA Inspector witnessed the Magnetic Particle Testing (MT) of Strut angle connection plate performed by ZPMC QC personnel. The members are identified as Tower Components. The weld designations reviewed are as follows. One of the Angle connection plate ZPMC found MT linear indication and after grinding, the excavation was about approximately 10mm in depth. Attached photographs

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provide additional details.

ED1-A5007-2, 4, 6, 8, 10, 11, 12, 13, 15, 16, 17, 19, 20, 22, 23, 24, 25, 29, 30-1A/B

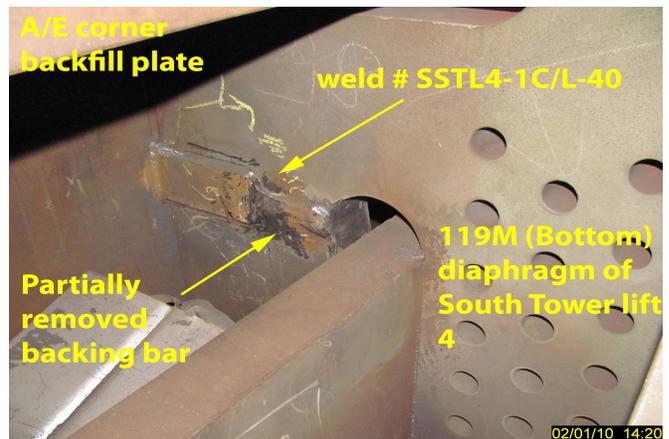
ND1-A5012-4, 8, 11, 12, 13, 16, 26, 31, 33-1A/B

ND1-A5012-29-1A/B (ZPMC found MT linear indication)

During random verification Ultrasonic Testing (UT) of A/E corner backfill plate of South Tower Lift 4, this Quality Assurance (QA) Inspector observed the backing has been removed on weld joint SSSL4-1J/L-28 at 139M (bottom) diaphragm. Approved weld details indicate that backing bar is to remain on this weld joint. Backing has been partially removed at two weld locations. These welds are identified as SSSL4-1C/L-40 at 119M (bottom) diaphragm and SSSL4-1F/L-100 at 123M (top) diaphragm. These welds join the backfill plates and double diaphragm plates of South Tower lift 4. The members are located in Tower Bay 10. This issue has an incident report.

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:

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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
