

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-012075**Date Inspected:** 09-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:	Yu Dong Ping, Du Zhi Qun	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 AT 127M AND 131M DIAPHRAGM

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.

SSTL4-1G/L-29, 98

SSTL4-1H/L-30, 131

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

BAY 10

GRILLAGE SADDLE BEAM REPAIR (T-CWR539, REV. 1)

SMAW welding of weld joint 5A/B (Repair) located on ND1-BPSA5-2-1.

Welder is identified as 057258. ZPMC CWI is identified as Mr. Li Lin.

The welding variables recorded by QC appeared to comply with WPS-485-SMAW-2G(2F)-REPAIR-1.

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SOUTH TOWER LIFT 4

During random Visual Inspection this QA inspector observed ZPMC personnel performing grinding on base metal of skin B of South Tower lift 4 at 135M diaphragm. The components are identified as Tower components. Attached photographs provide additional detail.

NORTH TOWER LIFT 4

During random Visual Inspection this QA inspector observed the excavation on the base metal of skin D of North Tower lift 4 near D/E corner at 116m elevation. The length is approximately 160mm and depth approximately 5~6mm. The components are identified as Tower components. Attached photographs provide additional detail.

BAY 11

TOWER STRUT ANGLE CONNECTION PLATE

SAW welding of weld joint 1B located on ED1-SA4-68-135M-1.

Welder is identified as 040699. 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.

SAW welding of weld joint 1B located on ED1-SA4-68-135M-3.

Welder is identified as 040699. ZPMC CWI is identified as Yu Dong Ping.

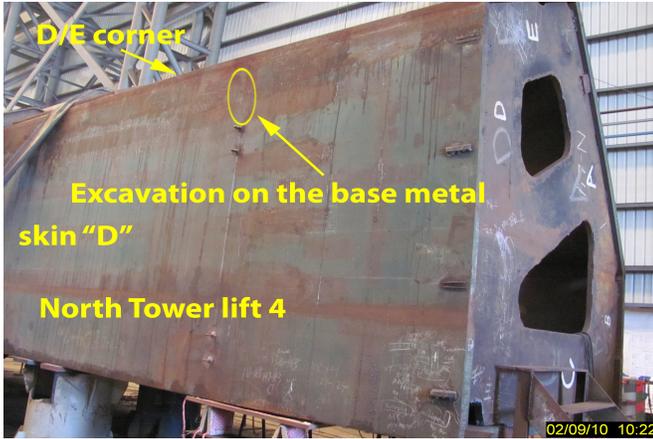
The welding variables recorded by QC appeared to comply with WPS-B-T-3221-Tc-U5-S-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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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
