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

Bay Area Branch
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Contract #: 04-0120F4
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-012514
Date Inspected: 12-Feb-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:	Li Lin, 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:

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

BAY 10

NORTH TOWER LIFT 4, C/D CORNER REPAIR (T-CWR533, REV. 2)
FCAW welding of weld joint 1A/B (Repair) located on NSTL4-3B/L.
Welder is identified as 066733. ZPMC CWI is identified as Mr. Du Zhi Qun.
The welding variables recorded by QC appeared to comply with WPS-345-FCAW-1G(1F)-REPAIR.

SOUTH TOWER LIFT 4, FIT LUG ON SKIN E
FCAW welding of weld joint 29 located on SSTL4-1K/L.
Welder is identified as 066236. ZPMC CWI is identified as Mr. Gong Liang Zhu.
The welding variables recorded by QC appeared to comply with WPS-B-T-2333-Tc-P4-F.

FCAW welding of weld joint 30 located on SSTL4-1K/L.
Welder is identified as 066236. ZPMC CWI is identified as Mr. Gong Liang Zhu.

The welding variables recorded by QC appeared to comply with WPS-B-T-4333-Tc-P4-F.

FCAW welding of weld joint 94 located on SSTL4-1J/L.
Welder is identified as 066236. ZPMC CWI is identified as Mr. Gong Liang Zhu.
The welding variables recorded by QC appeared to comply with WPS-B-T-2333-Tc-P4-F.

FCAW welding of weld joint 95 located on SSTL4-1J/L.
Welder is identified as 066236. ZPMC CWI is identified as Mr. Gong Liang Zhu.
The welding variables recorded by QC appeared to comply with WPS-B-T-4333-Tc-P4-F.

NORTH TOWER LIFT 2, ELEVATOR BRACKET ON SKIN D
SMAW welding of weld joint 1-N located on Z69-O-B-F-22.
Welder is identified as 057258. ZPMC QC is identified as Mr. Sun Tian Liang.
The welding variables recorded by QC appeared to comply with WPS-B-T-2314.

TOWER STRUT REPAIR
SMAW welding of weld joint 85(Repair) located on ED1-A6001-1.
Welder is identified as 057258. ZPMC QC is identified as Mr. Sun Tian Liang.
The welding variables recorded by QC appeared to comply with WPS-485-SMAW-3G(3F)-FCM-REPAIR.

BAY 11

TOWER STRUT ANGLE CONNECTION PLATE
SAW welding of weld joint 1B located on ED1-SA4-68-131M-5.
Welder is identified as 041716. ZPMC CWI is identified as Mr. Li Lin.
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.

Summary of Conversations:

WELDING INSPECTION REPORT

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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