

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-013112**Date Inspected:** 28-Mar-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:** 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 Manoj Prabhune 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 (Tower)

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 reports for this date. The members are identified as Tower Components. The weld designations reviewed are as follows.

ND1-SA4-68-143M-3, 4, 5, 6, 7, 8-1 a/b, ND1-STSA4-6-131M-1-1 a/b, ND1-STSA4-6-131M-2-1 a/b, ED1-STSA4-6-135-1-1 a/b, ED1-STSA4-6-2-1 a/b, ND1-STSA4-6-135M-1-1 a/b, ND1-STSA4-6-131M-1-3, 2-3a/b, ED1-STSA4-6-135-1-3, 2-3 a/b, ND1-STSA4-6-135M-1-3a/b, ED1-STSA4-6-127M-2-1a/b, ND1-STSA4-6-1-1, 2-1 a/b, ED1-STSA4-6-131M-1-1a/b, ED1-STSA4-6-131M-1-1, 2-1 a/b, ED1-STSA4-6-131M-1-3, 2-3 a/b.

Nondestructive testing (NDT) notification No. 005428

Bay # 11

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

This QA inspector observed, ZPMC qualified welding personnel identified as 041271 perform Shielded Metal Arc Welding (SMAW), weld joint identified as WD1-SA4-56-119M-1-1A and WD1-SA4-56-119M-2-1A; ZPMC QC is identified as Mr.Liu Dao Feng. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-3211-TC-U5C-1

Bay # 11

This QA inspector observed, ZPMC qualified welding personnel identified as 040667 perform Shielded Metal Arc Welding (SMAW), weld joint identified as WD1-SA4-56-119M-3-1A and WD1-SA4-56-119M-4-1A; ZPMC QC is identified as Mr.Liu Dao Feng. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-3211-TC-U5C-1

Bay # 11

During in process visual inspection of Strut Flange Plate , This QA Inspector observed ABF Quality Assurance (QA) personnel performing Magnetic Particle testing (MT) ABF Technician identified as Mr. He Zhi Shuz, of the Weld identified ED1-STSA-4-6-135-2-3a/b. See the attached below Photo.

Bay # 10

Repair Welding.

This QA inspector observed, ZPMC qualified welding personnel identified as 050969 perform Shielded Metal Arc Welding (SMAW), weld joint identified as NSTL4-3 B/L-2 A/B; The Welding Repair Report (WRR) was T-WR3068. ZPMC CWI is identified as Mr.Du Zhi Qun. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-345+485-SMAW-4G (4F) Repair. See the attached Photo.

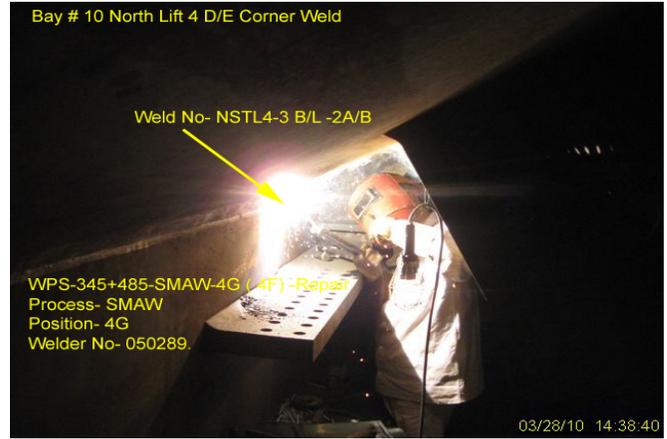
Bay # 10

This QA inspector observed, Heat Straightening Perform ZPM CWI is identified as Mr.Du Zhi Qun. The variables recorded by QC appeared to comply with the Heat Straightening Report (HSR) was HSR1 (T) -11145.

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:	Prabhune,Manoj	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer
