

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-013233**Date Inspected:** 06-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 Shailesh 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 QA Inspector observed the following work in progress:

BAY 10

This QA Inspector observed ZPMC qualified welding personnel identified as 053869 Perform Flux Core Arc Welding (FCAW) on Skirt extension block, The joint identified as, SSD1-SA447-1-7,8. ZPMC QC Identified as Zhu Zhong jie. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2132. For more information see below attached photo.

Repair Welding

This QA Inspector observed ZPMC qualified welding personnel identified as 057258, 500363. Perform Shielded Metal Arc Welding (SMAW) on North Tower lift 4 C/D corner joint. Joint identified, as NSTL4-3B/L-1B, and Y location as 13000, 24800mm. ZPMC QC Identified as Li Peng Fei. With Critical welding repair report, CWR-T-CWR533 Rev. 4, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-1G (1F)-Repair.

Repair Welding

This QA Inspector observed ZPMC qualified welding personnel identified as 052493, 052930. Perform Shielded

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Metal Arc Welding (SMAW) on North Tower lift 4 B/C corner joint. Joint identified, as NSTL4-3B/L-5B. and Y location as 8715, 11100, 2270mm. ZPMC CWI Identified as Gang Liang Zhu. With Critical welding repair report, CWR-T-CWR591 Rev. No. 2, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-2G (2F)-Repair. For more information see below attached photo.

Repair Welding

This QA Inspector observed ZPMC qualified welding personnel identified as 040268. Perform Shielded Metal Arc Welding (SMAW) on Angle connection beam base metal repair. Item identified, as ND1-BPSA5-3, ZPMC QC Identified as Sun Tian Liang. With Temporary welding repair report, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-485-SMAW-1G, 2G (1F, 2F)-Repair-1. For more information see below attached photo.

BAY 11

This QA Inspector observed ZPMC qualified welding personnel identified as 047304. Perform Submerged Arc Welding (SAW) on Tower web, flange plate. Joint identified WD1-STSA4-5-135M, 131M, 127M-1-3A, SD1-STSA4-5-135M, 131M-1-3A, ZPMC CWI Identified as Yu Dong Ping. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-4221-B-U3c-S-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 047304. Perform Submerged Arc Welding (SAW) on Tower web, flange plate. Joint identified SD1-STSA4-5-119M, 123M, 127M-1-3A, WD1-STSA4-5-119M, 123M-1-3A, ZPMC CWI Identified as Yu Dong Ping. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-4221-B-U3c-S-1.

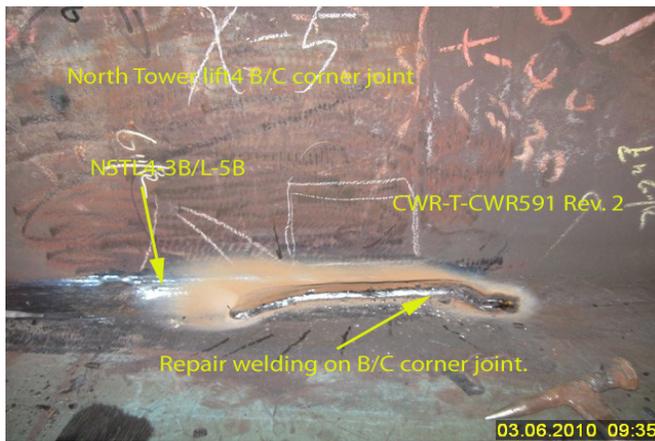
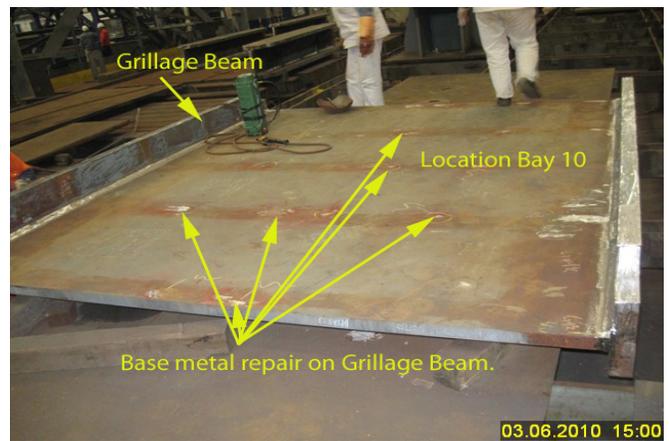
This QA Inspector observed ZPMC qualified welding personnel identified as 049099. Perform Shielded Metal Arc Welding (SMAW) on West Tower lift 5 A/B corner joint. Joint identified, as WSD1-TL5-4B/F-20B, ZPMC QC Identified as Shao Hai Long, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-3212-Tc-U4b-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 046704, 040656. Perform Shielded Metal Arc Welding (SMAW) on West Tower lift 5 A/B corner joint. Joint identified, as WSD1-TL5-4B/F-32B, ZPMC QC Identified as Shao Hai Long, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-3212-Tc-U4b-1. For more information see below attached photo.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the 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 phone: 15000422360, who represents the Office of Structural Materials for your project.

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