

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-013237**Date Inspected:** 10-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:** Gang Liang Zhu**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:

BAY 10:

This QA Inspector performed Randomly Visual Inspection and Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL- 6028 (MT) report for this date. The member is identified as North Tower lift 4 Pad eyes of Skin C. The weld designations reviewed are as follows.

NSD1-FCSA4-1A/C-89, 96, 97, 98, 99

NDT Notification No-005306

BAY 10:

This QA Inspector performed Randomly Visual Inspection and Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL- 6028 (MT) report for this date. The member is identified as North Tower lift 4 C/D corner joint Double diaphragm area, and B/C corner joint Single and Double diaphragm area. The weld designations reviewed are as follows.

NSTL4-3B/L-1B, NSTL4-3B/L-5B

NDT Notification No-005307

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This QA Inspector observed the following work in progress:

BAY 10

Repair Welding

This QA Inspector observed ZPMC qualified welding personnel identified as 040582. Perform Shielded Metal Arc Welding (SMAW) on North Tower lift 4 Skin E. base metal repair area after removing temporary attachment. ZPMC QC Identified as Wang Hao. With Temporary welding repair report WRR-T-WR3033, 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.

This QA Inspector observed during random Visual inspection, ZPMC Ultrasonic Testing (UT) Inspector performed UT on Tower Grillage beam plate. Item identified as NSD1-TL5-3B-F-6A. For more information see below attached photo.

BAY 11:

This QA Inspector observed ZPMC qualified welding personnel identified as 044560. Perform Submerged Arc Welding (SAW) on Tower web, flange plate. Joint identified WD1-STSA4-5-127M-1-3B, WD1-STSA4-5-131M-1-3B, WD1-STSA4-5-135M-1-3B, SD1-STSA4-5-131M-1-3B, SD1-STSA4-5-135M-1-3B 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 042195. Perform Submerged Arc Welding (SAW) on Tower web, flange plate. Joint identified WD1-STSA4-5-127M-1-21B, WD1-STSA4-5-123M-1-21B, SD1-STSA4-5-127M-1-21B 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. For more information see below attached photo.

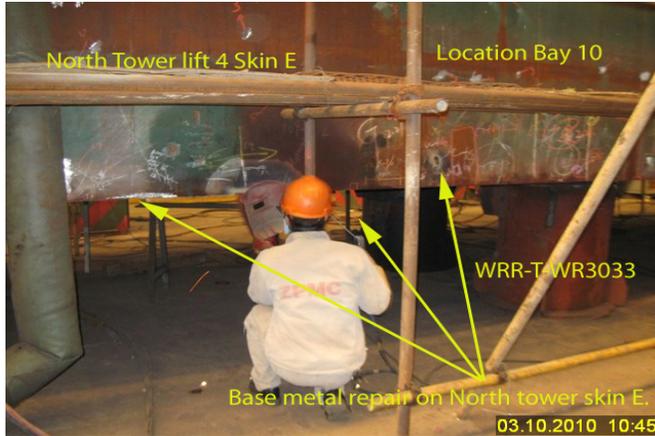
This QA Inspector observed ZPMC qualified welding personnel identified as 040690, 049099, Perform Shielded Metal Arc Welding (SMAW) on West Tower lift 5 B/C corner joint. Joint identified, as WSD1-TL5-4B/F-39A. ZPMC QC Identified as Shao Hai Long, The welding parameters as measured using QC's calibrated 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 040655, 046704, 040656, Perform Shielded Metal Arc Welding (SMAW) on West Tower lift 5 A/E corner joint. Joint identified, as WSD1-TL5-4B/F-12B, 33A. 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-U5b-1.

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.

Inspected By: Gaikwad,Shailesh

Quality Assurance Inspector

Reviewed By: Clifford,William

QA Reviewer
