

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-013242**Date Inspected:** 18-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:** Ye Yong Jun**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 Trial Assembly**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:

TOWER TRIAL ASSEMBLY:

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 West and South Tower Lift 1, bearing Plate. The weld designations reviewed are as follows.

WSD1-SA653D/F-9, 10, SSD1-SA15D/F-10, 11

NDT Notification No-005369

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 1, bearing Plate of skin A. The weld designations reviewed are as follows.

NSD1-SA33D/F-10, 14

NDT Notification No-005373

WEST TOWER LIFT 1

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This QA Inspector observed ZPMC qualified welding personnel identified as 049541. Perform Flux Core Arc Welding (FCAW) on West Tower lift 1 skin E inside, bearing stiffener. Joint identified as WSD1-SA225F/H-13, ZPMC QC Identified as Liu Zhi, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2333-Tc-P4-F.

This QA Inspector observed ZPMC qualified welding personnel identified as 068753, 066251. Perform Flux Core Arc Welding (FCAW) on West Tower lift 1 skin E outside, bearing stiffener. Joint identified as WSD1-SA225F/H-34, 5. ZPMC QC Identified as Fu Wei Min, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2333-Tc-P4-F.

EAST TOWER LIFT 1

This QA Inspector observed ZPMC qualified welding personnel identified as 040713. Perform Flux Core Arc Welding (FCAW) on East Tower lift 1 skin D inside, bearing stiffener. Joint identified as ESD1-SA296B/E-3, ZPMC QC Identified as Yong Ming Ming, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2333-Tc-P4-F.

This QA Inspector observed ZPMC qualified welding personnel identified as 059525, 040723. Perform Flux Core Arc Welding (FCAW) on East Tower lift 1 skin E outside, bearing stiffener. Joint identified as ESD1-SA227B/H-3, 11, ZPMC QC Identified as Yong Ming Ming, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2333-Tc-P4-F.

This QA Inspector observed ZPMC qualified welding personnel identified as 066482. Perform Flux Core Arc Welding (FCAW) on East Tower lift 1 skin C outside, bearing stiffener. Joint identified as ESD1-SA294F/H-37, ZPMC QC Identified as Sun Tian Liang, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2333-Tc-P4-F. For more information see below attached photo.

NORTH TOWER LIFT 1

This QA Inspector observed ZPMC qualified welding personnel identified as 068753, 069043. Perform Flux Core Arc Welding (FCAW) on North Tower lift 1 skin E outside, bearing stiffener. Joint identified as NSD1-SA76-F/H-34, 57. ZPMC QC Identified as Fu Wei Min, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2333-Tc-P4-F.

This QA Inspector observed ZPMC qualified welding personnel identified as 040330. Perform Flux Core Arc Welding (FCAW) on North Tower lift 1 skin C inside, bearing stiffener. Joint identified as NSD1-SA17-F/G-29. ZPMC QC Identified as Liu Zhi, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2333-Tc-P4-F.

This QA Inspector observed ZPMC qualified welding personnel identified as 066283. Perform Flux Core Arc Welding (FCAW) on North Tower lift 1 skin D inside, bearing stiffener. Joint identified as NSD1-SA22-B/E-33. ZPMC QC Identified as Liu Zhi, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2333-Tc-P4-F.

This QA Inspector observed during random Visual inspection, ZPMC Magnetic Particle Testing (MT) Inspector

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performed MT on Bearing Plate of skin A, North Tower lift 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.



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
