

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-013260**Date Inspected:** 06-Apr-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 performed 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 Tower Strut flange. The weld designations reviewed are as follows.

SD1-STSA4-5-119M-1-21A/B, 22A/B

WD1-STSA4-5-119M-1-21A/B, 22A/B

SD1-STSA4-5-123M-1-21A/B, 22A/B

NDT Notification No-005477

This QA Inspector observed the following work in progress:

BAY 10

This QA Inspector observed ZPMC qualified welding personnel identified as 500363. Perform Shielded Metal Arc Welding (SMAW) on North tower lift 4. Skin A, B, C, D, E. Base metal repair. ZPMC CWI Identified as Tu Jun with temporary welding repair report. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW- 3G, 4G (3F) (4F)-Repair.

This QA Inspector observed ZPMC qualified welding personnel identified as 052493. Perform Shielded Metal Arc

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

Welding (SMAW) on North Tower lift 5 C/D corner joint. Joint identified as NSD1-TL5-3B-F-8A, 37A. ZPMC CWI Identified Du Zhi Qun. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-3212-C-U2. For more information see below attach photo No. 1.

This QA Inspector observed ZPMC qualified welding personnel identified as 052075. Perform Flux Core Arc Welding (FCAW) on North tower lift 4 A/E corner Back fill plate welding. Joint identified as NSTL4-3J/L-96. ZPMC QC Identified as Deng Zhi Bing, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-4333-Tc-P4-F.

This QA Inspector observed ZPMC qualified welding personnel identified as 053870. Perform Flux Core Arc Welding (FCAW) on North tower lift 4 A/E corner Back fill plate welding. Joint identified as NSTL4-3J/L-31. ZPMC QC Identified as Deng Zhi Bing, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-4333-Tc-P4-F.

This QA Inspector observed ZPMC qualified welding personnel identified as 057180. Perform Flux Core Arc Welding (FCAW) on North tower lift 4 A/E corner Back fill plate welding. Joint identified as NSTL4-3I/L-97. ZPMC QC Identified as Deng Zhi Bing, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-4333-Tc-P4-F.

This QA Inspector observed ZPMC qualified welding personnel identified as 053869. Perform Flux Core Arc Welding (FCAW) on North tower lift 4 A/E corner Back fill plate welding. Joint identified as NSTL4-3I/L-30. ZPMC QC Identified as Deng Zhi Bing, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-4333-Tc-P4-F.

This QA Inspector observed ZPMC qualified welding personnel identified as 057258. Perform Flux Core Arc Welding (FCAW) on Skirt Plate. Joint identified as NSD1-A802B/D-1. ZPMC QC Identified Yuan Hai Gang, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2133.

BAY 11:

During random Visual inspection This QA Inspector observed, ZPMC Magnetic Particle Testing (MT) inspector performing MT on Tower Strut after Heat Straightening, Item identified as WD1-A6003-6, WD1-A6001-5 and SD1-A002-12. For more information see below attach photo No. 3.

This QA Inspector observed ZPMC qualified welding personnel identified as 044560. Perform Submerged Arc Welding (SAW) on Angle connection plate. Joint identified as WD1-SA4-56-139M-1,2,3,4-1B, 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-3221-B-U5-S-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 040699. Perform Submerged Arc Welding (SAW) on Angle connection plate. Joint identified as ND1-SA4-69-119M-1, 2, 3, 4-1B, 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-3221-B-U5-S-1.

WELDING INSPECTION REPORT

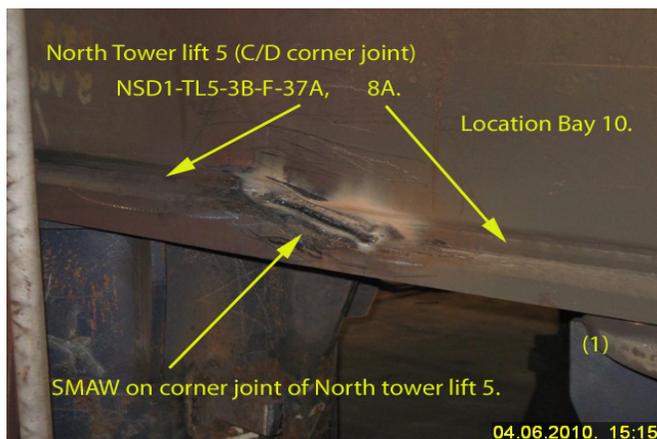
(Continued Page 3 of 4)

This QA Inspector observed ZPMC qualified welding personnel identified as 040667, 040614. Perform Shielded Metal Arc Welding (SMAW) on Angle connection plate. Joint identified as WD1-SA4-56-135M-1, 2, 3, 4-1A, 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-3211-Tc-U5b-1.

Repair Welding:

This QA Inspector observed ZPMC qualified welding personnel identified as 040690. Perform Shielded Metal Arc Welding (SMAW) on Angle connection plate. Joint identified as ND1-SA4-68-131M-7-1B. ZPMC QC Identified as Shao Hai Long. With Critical welding repair report CWR-T-CWR610. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-485-SMAW-1G (1F)-Repair-1. For more information see below attach photo No. 2.

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

WELDING INSPECTION REPORT

(Continued Page 4 of 4)

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
