

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-013285**Date Inspected:** 07-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:** Yu Dong Ping, Tu 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**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh 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 11 East Tower Lift 5

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% and random Visual Testing (VT) of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT reports for this date. The members are identified as Tower Components. The weld designations reviewed are as follows.

ESD1-TL5-2B/F-11A/B, 38A/B (B/C CORNER SEAM)

ESD1-TL5-2B/F-24A/B, 40A/B (D/E CORNER SEAM)

This Quality Assurance (QA) Inspector observed the following work in progress:

Bay 10

TOWER SKIRT PLATE

SMAW welding of weld joint 5 located on SSD1-SA447-3.

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Welder is identified as 056364. ZPMC QC is identified as Mr. Zhu Zhong Jie.
The welding variables recorded by QC appeared to comply with WPS-B-P-2112.

SOUTH TOWER LIFT 5

SAW welding of weld joint 21B located on SSD1-TL5-1B-F.

Welder is identified as 040414. ZPMC QC is identified as Mr. Yu Zhi Lai.

The welding variables recorded by QC appeared to comply with WPS-B-T-3221-B-U3c-S-1.

SAW welding of weld joint 13B located on SSD1-TL5-1B-F.

Welder is identified as 040460. ZPMC QC is identified as Mr. Yu Zhi Lai.

The welding variables recorded by QC appeared to comply with WPS-B-T-3221-B-U3c-S-1.

SOUTH TOWER LIFT 5, A/E CORNER

SAW welding of weld joint 3A located on SSD1-TL5-1B-F.

Welder is identified as 207745. ZPMC CWI is identified as Mr. Sun Tian Liang.

The welding variables recorded by QC appeared to comply with WPS-B-T-3221-Tc-U5-S-1.

During random in process inspection this QA inspector observed that buttering of about 3~10mm on the edge of Shear Plate ED1-A27. Welders are identified as 037705 and 068501. ZPMC QC is identified as Mr. Li Peng Fei.

The welding variables recorded by QC appeared to comply with WPS-345-FCAW-2G(2F)-Repair.

BAY 11

TOWER STRUT FLANGE PLATE

SAW welding of weld joint 1A located on SD1-STSA4-5-131M-1.

Welder is identified as 047304. ZPMC QC is identified as Mr. Li Jun.

The welding variables recorded by QC appeared to comply with WPS-B-T-4221-B-U3c-S-1.

SAW welding of weld joint 7B located on ED1-STSA4-6-143M-2.

Welder is identified as 040699. ZPMC CWI is identified as Yu Dong Ping.

The welding variables recorded by QC appeared to comply with WPS-B-T-4221-B-U3c-S-1.

STRUT ANGLE CONNECTION PLATE

SMAW welding of weld joint 1A located on ND1-SA4-68-143M-2.

Welder is identified as 041271. ZPMC CWI is identified as Yu Dong Ping.

The welding variables recorded by QC appeared to comply with WPS-B-T-3211-Tc-U5b-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with 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 : 15000422360, who represents the Office of Structural Materials for your project.

Inspected By: Gaikwad,Umesh

Quality Assurance Inspector

Reviewed By: Clifford,William

QA Reviewer