DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-013286
Date Inspected: 08-Mar-2010

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 700
OSM Departure Time: 1900
Location: Shanghai, China

CWI Name: Yu Dong Ping, Tu Jun

Inspected CWI report:	☐ Yes	☑ No	☐ N/A
Electrode to specification:	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A

CWI Present:	☑ Yes	☐ No	
Rod Oven in Use:	☑ Yes	☐ No	☐ N/A
Weld Procedures Followed:	☑ Yes	☐ No	☐ N/A
Verified Joint Fit-up:	☐ 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:

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

Bay 10

TOWER SKIRT PLATE
FCAW welding of weld joint 25 located on NSD1-A802D/D.
Welder is identified as 052075. ZPMC QC is identified as Mr. Jiang Xiao Bo.
The welding variables recorded by QC appeared to comply with WPS-B-T-2332-Tc-P4-F.

FCAW welding of weld joint 32 located on SSD1-A434D/D.
Welder is identified as 052075. ZPMC QC is identified as Mr. Jiang Xiao Bo.
The welding variables recorded by QC appeared to comply with WPS-B-T-2332-Tc-P4-F.

GRILLED STIFFENER
During random in process inspection this QA inspector observed that buttering of about 15mm on the edge of grilled stiffener SSD1-TL5-1A-F-TD5-9, NSD1-TL5-3A-F-TD5-9. Welders are identified as 040582 and 052930.

ZPMC QC is identified as Mr. Deng Zhi Bing. The welding variables recorded by QC appeared to comply with WPS-485-SMAW-2G(2F)-Repair-1.

BAY 11

TOWER STRUT FLANGE PLATE
SAW welding of weld joint 4A located on ED1-STSA4-10-119M-2.
Welder is identified as 040699. ZPMC QC is identified as Mr. Mao Bin Bin.
The welding variables recorded by QC appeared to comply with WPS-B-T-4221-B-U3c-S-1.

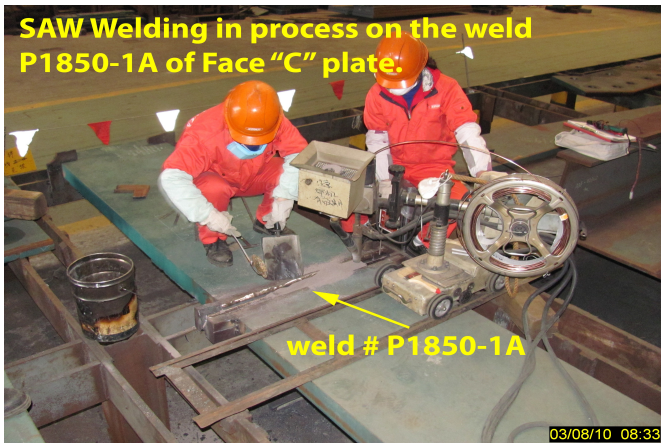
STRUT ANGLE CONNECTION PLATE
SMAW welding of weld joint 1A located on ND1-SA4-68-143M-5.
Welder is identified as 041271. ZPMC QC is identified as Mr. Mao Bin Bin.
The welding variables recorded by QC appeared to comply with WPS-B-T-3211-Tc-U5b-1.

WEST TOWER LIFT 5, AB CORNER SEAM
SMAW welding of weld joint 32B located on WSD1-TL5-4B/F.
Welder is identified as 046704. ZPMC QC is identified as Mr. Shao Hai Long.
The welding variables recorded by QC appeared to comply with WPS-B-T-3211-Tc-U4b-1.

WEST TOWER LIFT 5, BC CORNER SEAM
SMAW welding of weld joint 21B located on WSD1-TL5-4B/F.
Welder is identified as 049099. ZPMC QC is identified as Mr. Shao Hai Long.
The welding variables recorded by QC appeared to comply with WPS-B-T-3212-Tc-U4b-1.

TOWER SHEARING PLATE
SAW welding of weld joint 1A located on P1850.
Welder is identified as 052075. ZPMC QC is identified as Mr. Li Jun.
The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-U3c-S-2.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



WELDING INSPECTION REPORT

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