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-013288
Date Inspected: 10-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	**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 West Tower Lift 4, TRIANGULAR PLATE WITH SKIN C & D

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.

WSTL4-2H/L-3, 5, 72, 74
WSTL4-2I/L-3, 5, 73, 75
WSTL4-2J/L-3, 5, 73, 75
WSTL4-2K/L-3, 5, 73, 75

Bay 11 TOWER SHEARING PLATE

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15%, Ultrasonic Testing (UT) of approximately 10% and random Visual Testing (VT) of the area previously tested and accepted by ZPMC Quality

Control personnel. This QA Inspector generated an MT and UT reports for this date. The members are identified as Tower Components. The weld designations reviewed are as follows.

E-P1850-1A/B (A SIDE ONLY)
W-P1850-1A/B (A SIDE ONLY)

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

BAY 11

TOWER STRUT FLANGE PLATE
SAW welding of weld joint 21B located on WD1-STSA4-5-123M-1.
Welder is identified as 042195. 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.

SAW welding of weld joint 21B located on SD1-STSA4-5-127M-1.
Welder is identified as 042195. 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.

SAW welding of weld joint 3B located on WD1-STSA4-5-131M-1.
Welder is identified as 044560. 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.

SAW welding of weld joint 3B located on SD1-STSA4-5-135M-1.
Welder is identified as 044560. 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 WD1-SA4-56-119M-1.
Welder is identified as 041271. ZPMC QC is identified as Mr. Liu Dao Feng.
The welding variables recorded by QC appeared to comply with WPS-B-T-3211-Tc-U5b-1.

SMAW welding of weld joint 1A located on WD1-SA4-56-119M-3.
Welder is identified as 040667. ZPMC QC is identified as Mr. Liu Dao Feng.
The welding variables recorded by QC appeared to comply with WPS-B-T-3211-Tc-U5b-1.

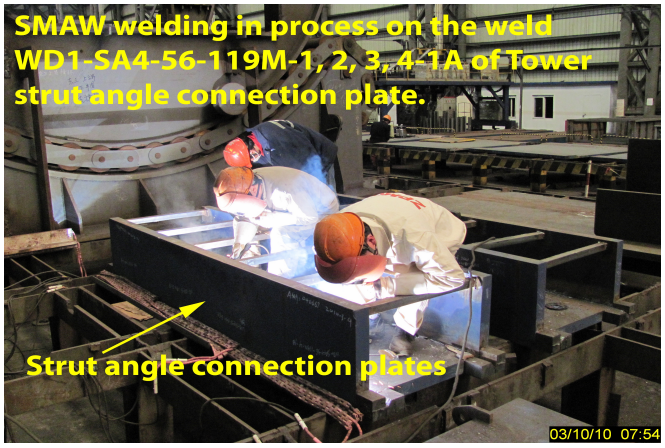
PHASED ARRAY ULTRASONIC TESTING (PAUT) TRAINING

This QA inspector attend the Phased Array Ultrasonic Testing (PAUT) training session organized by ASNT level III.

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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



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