

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-013289**Date Inspected:** 12-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 West Tower Lift 4, BC corner seam

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.

WSTL4-2B/L-58A/B

WSTL4-2L/L-3A/B

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-STSA4-5-131M-1.

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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 21B 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.

WEST TOWER LIFT 5, DE CORNER SEAM

SMAW welding of weld joint 6B located on WSD1-TL5-4B/F.
Welder is identified as 040656. 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, CD CORNER SEAM

SMAW welding of weld joint 38A located on WSD1-TL5-4B/F.
Welder is identified as 040667. 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.

WEST TOWER LIFT 4, A/B CORNER SEAM REPAIR (T-CWR603, REV. 0, Y-26340)

SMAW welding of weld joint 59A/B(Repair) located on WSTL4-2B/L.
Welder is identified as 049099. ZPMC CWI is identified as Mr. Gong Liang Zhu.
The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G(2F)-REPAIR.

WEST TOWER LIFT 4, D/E CORNER SEAM REPAIR (T-WR3072, REV. 0, Y-18340)

SMAW welding of weld joint 61A/B(Repair) located on WSTL4-2B/L.
Welder is identified as 040733. ZPMC QC is identified as Mr. Xu Jin Long.
The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G(4F)-REPAIR.

BAY 10

NORTH TOWER LIFT 4, D/E CORNER SEAM REPAIR (T-WR3068, REV. 0, Y-21700)

SMAW welding of weld joint 2A/B(Repair) located on NSTL4-3B/L.
Welder is identified as 500363. ZPMC CWI is identified as Mr. Tu Jun.
The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G(2F)-REPAIR.

NORTH TOWER LIFT 4, TRIANGULAR PLATE WITH SKIN

FCAW welding of weld joint 70 located on NSTL4-3K/L.
Welder is identified as 067876. ZPMC QC is identified as Mr. Li Peng Fei.
The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

PHASED ARRAY ULTRASONIC TESTING (PAUT) TRAINING

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

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

Inspected By:	Gaikwad,Umesh	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
