

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-013294**Date Inspected:** 17-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 10, North Tower Lift 4 CD 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 MT report for this date. The members are identified as Tower Components. The weld designations reviewed are as follows.

NSTL4-3B/L-1B (From 131M Top to 143M Diaphragm)

NSTL4-3L/L-2B

Bay 10, North Tower Lift 4 CD Corner Triangular Plate

This QA inspector performed random Visual Testing (VT) of the area previously tested and accepted by ZPMC Quality Control personnel. The members are identified as Tower Components. The weld designations reviewed are as follows.

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NSTL4-3H/L-72, 74
NSTL4-3I/L-3, 5, 72, 74
NSTL4-3J/L-1, 3, 72, 74
NSTL4-3K/L-1, 3, 70, 74

Bay 11, West Tower Lift 4 BC Corner Triangular Plate

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 MT report for this date. The members are identified as Tower Components. The weld designations reviewed are as follows.

WSTL4-2B/L-19, 21
WSTL4-2C/L-16, 18, 88, 90
WSTL4-2F/L-16, 18, 87, 89
WSTL4-2G/L-16, 18, 88, 90
WSTL4-2H/L-15, 85, 87
WSTL4-2I/L-16, 18, 86, 88
WSTL4-2J/L-16, 18, 85, 87
WSTL4-2K/L-16, 18, 86, 88
WSTL4-2H/L-54 (MT Transverse crack found, Approx. length 20mm)

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

BAY 10

REPAIR

SMAW welding of weld joint 21A/B(Repair) located on SSD1-TL5-1B-F.
Welder IS identified as 500363. ZPMC QC is identified as Mr. Yu Zhi Lai.
The welding variables recorded by QC appeared to comply with WPS-485-SMAW-1G(1F)-REPAIR-1.

SMAW welding of weld joint 13A/B(Repair) located on SSD1-TL5-1B-F.
Welder IS identified as 500363. ZPMC QC is identified as Mr. Yu Zhi Lai.
The welding variables recorded by QC appeared to comply with WPS-485-SMAW-1G(1F)-REPAIR-1.

FAÇADE ASSEMBLY

SMAW welding of weld joint 3 located on SD1-SFSA3-71-2.
Welder is identified as 050289. ZPMC QC is identified as Mr. Yuan hui Gang.
The welding variables recorded by QC appeared to comply with WPS-B-P-2112.

During the Quality Assurance Magnetic Particle Testing (MT) review of welds located on West Tower Lift 4, weld number WSTL4-2H/L-54, this Quality Assurance (QA) Inspector discovered one (1) transverse crack found on the weld measuring approximately 20mm in length. The weld is identified as: WSTL4-2H/L-54. The Weld is a fillet weld joining the triangular plate with skin B. The member is located in Bay 11

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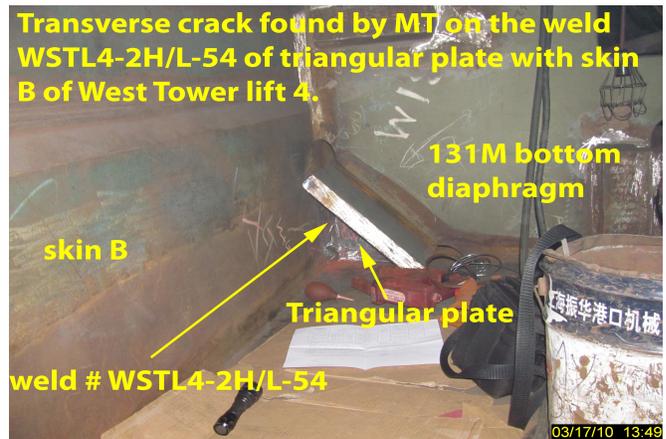
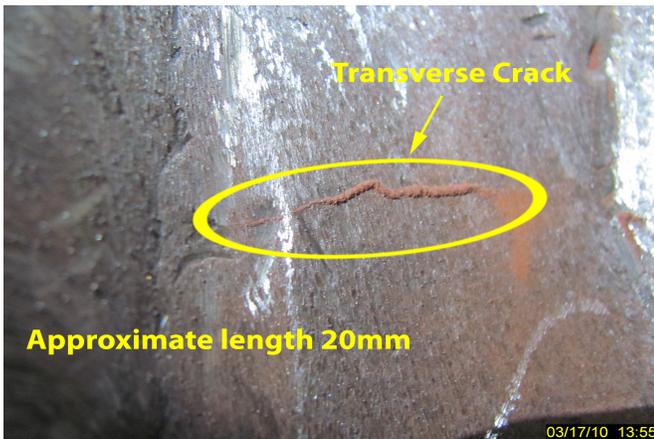
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The Notice of Witness Inspection Number (NWIT) is 005362. The indication is located outside the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. The attached photographs provide additional detail. This issue has an incident report.

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.



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
