

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-013296**Date Inspected:** 26-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:

Tower Jetty, Bearing Stiffeners of skin B

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.

WSD1-SA279-19, 22, 25, 28, 31, 34 (West Tower Lift 1)

SSD1-SA18-22, 23, 28, 29, 34, 35 (South Tower Lift 1, Green Tag No. 11772)

NSD1-SA11-20, 23, 26, 29, 32, 35 (North Tower Lift 1, Green Tag No. 11771)

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

BAY 10

NORTH TOWER LIFT 5, BC CORNER SEAM

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SMAW welding of weld joint 38A located on NSD1-TL5-3B-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-B-T-3211-Tc-U5b-1.

NORTH TOWER LIFT 5, AE CORNER SEAM

SMAW welding of weld joint 40B located on NSD1-TL5-3B-F.

Welder IS identified as 052930. ZPMC QC is identified as Mr. Yu Zhi Lai.

The welding variables recorded by QC appeared to comply with WPS-B-T-3212-Tc-U5b-1.

NORTH TOWER LIFT 4, BC CORNER DIAPHRAGM TO DIAGONAL PLATE

FCAW welding of weld joint 121 located on NSTL4-3H/L.

Welder IS identified as 067550. ZPMC QC is identified as Mr. Deng Zhi Bing.

The welding variables recorded by QC appeared to comply with WPS-B-T-4333-Tc-P5-F.

NORTH TOWER LIFT 4, CD CORNER DIAPHRAGM TO DIAGONAL PLATE

FCAW welding of weld joint 6 located on NSTL4-3B/L.

Welder IS identified as 068858. ZPMC QC is identified as Mr. Li Peng Fei.

The welding variables recorded by QC appeared to comply with WPS-B-T-2333-Tc-P5-F.

TOWER SKIRT PLATE

FCAW welding of weld joint 9 located on SSD1-A683B/B.

Welder IS identified as 040330. ZPMC QC is identified as Mr. Yuan Hui Gang.

The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

BAY11

WEST TOWER LIFT 4, BC CORNER DIAGONAL PLATE

FCAW welding of weld joint 22 located on WSTL4-2B/L.

Welder IS identified as 053316. ZPMC QC is identified as Mr. Xu Jie.

The welding variables recorded by QC appeared to comply with WPS-B-T-2331-Tc-P4-F-2.

WEST TOWER LIFT 5, DE CORNER SEAM

SAW welding of weld joint 6B located on WSD1-TL5-4B/F.

Welder is identified as 040699. ZPMC QC is identified as Mr. Li Jun.

The welding variables recorded by QC appeared to comply with WPS-B-T-3221-C-U2b-S.

PHASED ARRAY ULTRASONIC TESTING (PAUT) TRAINING

This Quality Assurance (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.

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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
