

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-013301**Date Inspected:** 06-Apr-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:** An Qing Xiang, 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 Strut Flange Plate

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated UT report for this date. The members are identified as Tower Components. The weld designations reviewed are as follows.

SD1-STSA4-5-119M-1-21A/B, 22A/B

WD1-STSA4-5-119M-1-21A/B, 22A/B

SD1-STSA4-5-123M-1-21A/B, 22A/B

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

BAY11

TOWER STRUT ANGLE CONNECTION PLATE

SAW welding of weld joint B located on SD1-SA4-56-139M-1.

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Welder is identified as 044560. ZPMC QC is identified as Mr. Shao Hai Long.
The welding variables recorded by QC appeared to comply with WPS-B-T-3221-Tc-U5-S-1.

SAW welding of weld joint 1B located on ND1-SA4-69-119M-1.
Welder is identified as 040699. ZPMC QC is identified as Mr. Shao Hai Long.
The welding variables recorded by QC appeared to comply with WPS-B-T-3221-Tc-U5-S-1.

SMAW welding of weld joint 1A located on WD1-SA4-56-135M-4.
Welder is identified as 040614. ZPMC QC is identified as Mr. Shao Hai Long.
The welding variables recorded by QC appeared to comply with WPS-B-T-3211-Tc-U5b-1.

TOWER SKIRT PLATE

FCAW welding of weld joint 21 located on ESD1-A63B/D.
Welder is identified as 040759. ZPMC QC is identified as Mr. Xu Jin Long.
The welding variables recorded by QC appeared to comply with WPS-B-T-2133.

BAY10

TOWER SKIRT PLATE

FCAW welding of weld joint 1 located on SSD1-A434B/D.
Welder is identified as 057258. ZPMC QC is identified as Mr. Yuan Hui Gang.
The welding variables recorded by QC appeared to comply with WPS-B-T-2133.

SMAW welding of weld joint 40 located on SD1-A440E/E.
Welder is identified as 040268. ZPMC QC is identified as Mr. Yuan Hui Gang.
The welding variables recorded by QC appeared to comply with WPS-B-P-2112.

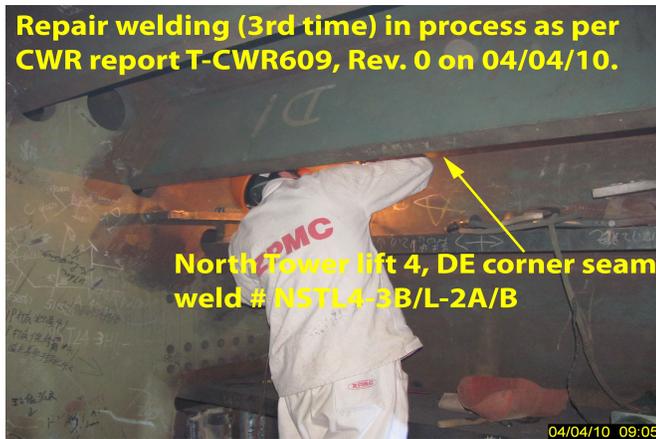
During random in-process verification of D/E corner seam of North Tower lift 4, this QA Inspector observed Shielded Metal Arc Welding (SMAW) for repair on D/E corner seam of North Tower lift 4. This repair welding (4th time) has been performed without prior approval of the engineer. This repair was previously (3rd time) performed on the same location as per CWR report T-CWR609, Rev. 0 on dated 04th April 2009. ZPMC NDT personnel rejected the 3rd time repair by Ultrasonic Testing (UT) at this same location. The weld number is identified as NSTL4-3B/L-2A/B. The Y location of the repair is identified as 1630. The welder is identified as #052493. The member is located in Bay 10. This issue has an incident report.

The attached photographs provide additional detail.

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