

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-013310**Date Inspected:** 10-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:** 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 Lift 4 Strut 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.

ED1-STSA4-6-143M-2-1A/B, 3A/B

ND1-STSA4-6-143M-1-1A/B, 3A/B

ND1-STSA4-6-143M-2-1A/B, 3A/B

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

BAY 10

SHEAR PLATE ED1-A27 (T-WR3074, REV. 0)

During random in process Visual inspection, this QA inspector observed that ZPMC personnel performing

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approximately 6~17mm buttering on the edge of Tower Shear Plate ED1-A27. Welders are identified as 052075, 040367. ZPMC QC is identified as Mr. Yuan Hui Gang. The welding variables recorded by QC appeared to comply with WPS-345-FCAW-2G(2F)-REPAIR-1. Attached photograph provide additional details.

TOWER SKIRT PLATE M231-P1795

During random in process Visual inspection, this QA inspector observed that ZPMC personnel performing approximately 2~10mm buttering on the edge of Tower Skirt Plate M231-P1795. Welder is identified as 057258. ZPMC QC is identified as Mr. Jiang Xiao Bo. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G(2F)-REPAIR. Attached photograph provide additional details.

BAY11

STRUT ANGLE CONNECTION PLATE

SAW welding of weld joint 1B located on SD1-SA4-56-123M-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-3221-Tc-U5-S-1.

SAW welding of weld joint 1B located on SD1-SA4-56-119M-4.

Welder is identified as 040699. ZPMC CWI is identified as Yu Dong Ping.

The welding variables recorded by QC appeared to comply with WPS-B-T-3221-Tc-U5-S-1.

TOWER SKIRT PLATE

FCAW welding of weld joint 21 located on WSD1-A801B/D.

Welder is identified as 040713. ZPMC QC is identified as Mr. Xu Jin Long.

The welding variables recorded by QC appeared to comply with WPS-B-T-2132/WPS-B-T-2133.

FCAW welding of weld joint 10 located on WD1-A597B/C.

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-2132.

FCAW welding of weld joint 53 located on ESD1-A63D/D.

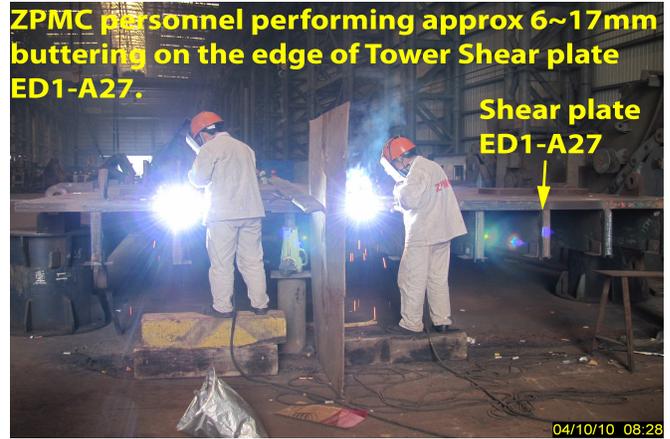
Welder is identified as 040609. ZPMC QC is identified as Mr. Xu Jin Long.

The welding variables recorded by QC appeared to comply with WPS-B-T-2133.

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