DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-013318
Date Inspected: 20-Apr-2010

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 700
OSM Departure Time: 1900
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:

Bay 11, Tower Skirt 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.

WD1-A597B/C-9

Bay 11, West Tower Lift 5, CD Corner Seam (Green Tag No. 12500)

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-TL5-4B/F-2A/B, 38A/B

SKIRT EXTENSION BLOCK (GREEN TAG NO. 11732)

This QA inspector performed green tagging for the Skirt Extension Block. This Components are identified as Tower components and the weld designations are identified as follows.

SSD1-SA447-1-1~10
SSD1-SA447-2-1~10
SSD1-SA447-3-1~10
SSD1-SA447-4-1~10

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

BAY11

TOWER GRILLAGE PLATE
SAW welding of weld joint 9A located on GTSA5-B/G.
Welder is identified as 042195. ZPMC QC is identified as Mr. Xu Jie.
The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-U3c-S-2.

SAW welding of weld joint 10A located on GTSA5-B/G.
Welder is identified as 047304. ZPMC QC is identified as Mr. Xu Jie.
The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-U3c-S-2.

TOWER STRUT PLATE
SMAW welding of weld joint 10B located on ED1-STSA4-6-139M-1.
Welder is identified as 040724. ZPMC QC is identified as Mr. Liu Dao Feng.
The welding variables recorded by QC appeared to comply with WPS-B-T-2212-Tc-U5b.

SMAW welding of weld joint 74B located on ND1-STSA4-6-131M-1.
Welder is identified as 040619. ZPMC QC is identified as Mr. Liu Dao Feng.
The welding variables recorded by QC appeared to comply with WPS-B-T-3212-Tc-U5b-1.

PADEYE ON TOWER SKIRT PLATE
SMAW welding of weld joint 18 located on ESD1-A65A/B.
Welder is identified as 040619. ZPMC QC is identified as Mr. Xu Jie Long.
The welding variables recorded by QC appeared to comply with WPS-B-P-2112-PADEYE.

BAY 10

TOWER FACADE PLATE
FCAW welding of weld joint 4 located on SD1-SFSA3-25.
Welder is identified as 057180. ZPMC QC is identified as Mr. Zhu Zhong Jie.

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

SAW welding of weld joint 1 located on SD1-SFSA4-1A/B.
Welder is identified as 0503060. ZPMC QC is identified as Mr. Yu Zhi Lai.
The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-L2c-S.

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