

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-013548**Date Inspected:** 25-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:

Bay 10, North Tower lift 5 B/C Corner

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15%, Ultrasonic Testing (UT) of approximately 10% and random Visual Testing (VT) of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated MT & UT reports for this date. The members are identified as Tower Components. The weld designations reviewed are as follows.

NSD1-TL5-3B-F-13B, 38B

Bay 11, Skirt Plate ESD1-A65 (GREEN TAG NO. 11736)

This QA Inspector performed green tagging for the following components. The components are identified as Tower components and weld designation are identified as follows.

ESD1-A65B/B-3, 36

ESD1-A65A/B-2~20

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Bay 11, Skirt Plate WSD1-A804 (GREEN TAG NO. 11737)

This QA Inspector performed green tagging for the following components. The components are identified as Tower components and weld designation are identified as follows.

WSD1-A804B/B-3, 36

WSD1-A804A/B-2~20

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

BAY11

TOWER GRILLAGE PLATE

SAW welding of weld joint 1B located on GTSA5-B/G.

Welder is identified as 044550. 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 2B 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.

TOWER LIFT 4, STRUT PLATE

SMAW welding of weld joint 9B located on ND1-STSA4-6-131M-2.

Welder is identified as 040614. ZPMC QC is identified as Mr. Mao Bin Bin.

The welding variables recorded by QC appeared to comply with WPS-B-T-2212-Tc-U5b.

SMAW welding of weld joint 91 located on ED1-STSA4-6-127M-2.

Welder is identified as 044541. ZPMC QC is identified as Mr. Mao Bin Bin.

The welding variables recorded by QC appeared to comply with WPS-B-T-2113.

TOWER SKIRT PLATE

FCAW welding of weld joint 37 located on WSD1-A801D/D.

Welder is identified as 042218. ZPMC QC is identified as Mr. Xu Jin Long.

The welding variables recorded by QC appeared to comply with WPS-B-T-2332-Tc-P4-F.

FCAW welding of weld joint 35 located on ESD1-A63D/D.

Welder is identified as 042218. ZPMC QC is identified as Mr. Xu Jin Long.

The welding variables recorded by QC appeared to comply with WPS-B-T-2333-Tc-P4-F.

BAY 10

TOWER FACADE PLATE

FCAW welding of weld joint 27 located on ND1-SFSA4-90-3.

Welder is identified as 052075. ZPMC QC is identified as Mr. Yu Zhi Lai.

The welding variables recorded by QC appeared to comply with WPS-B-T-2112.

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FCAW welding of weld joint 15 located on ND1-SFSA4-90-3.
Welder is identified as 057180. ZPMC QC is identified as Mr. Yu Zhi Lai.
The welding variables recorded by QC appeared to comply with WPS-B-T-2112.

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
