

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: 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-013549**Date Inspected:** 26-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 12, Tower Facade Perimeter Channel

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.

WD1-A145-7

Bay 11, East Tower Lift 4, Padeye of skin A (GREEN TAG NO. 12510)

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.

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ESD1-FASA4-2A/E-49, 50, 53, 54

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 29 located on ED1-STSA4-6-127M-2.

Welder is identified as 044541. ZPMC QC is identified as Mr. Liu Dao Feng.

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

EAST TOWER LIFT 4, FIT LUG ON SKIN E

FCAW welding of weld joint 46 located on ESTL4-2K/L.

Welder is identified as 042218. ZPMC CWI is identified as Mr. Li Lin.

The welding variables recorded by QC appeared to comply with WPS-B-T-4333-Tc-P4-F.

BAY 10

PADEYE ON SKIRT PLATE

SMAW welding of weld joint 50 located on ND1-A713A/E.

Welder is identified as 040268. ZPMC QC is identified as Mr. Jiang Xiao Bo.

The welding variables recorded by QC appeared to comply with WPS-B-P-2111-PADEYE.

SMAW welding of weld joint 52 located on SD1-A712A/F.

Welder is identified as 040268. ZPMC QC is identified as Mr. Jiang Xiao Bo.

The welding variables recorded by QC appeared to comply with WPS-B-P-2111-PADEYE.

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
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Reviewed By:	Clifford,William	QA Reviewer
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