

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-013560**Date Inspected:** 02-May-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:** Du Zhi Qun**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 Shailesh 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:

This QA Inspector observed the following work in progress:

BAY 11:

SMAW Process:

This QA Inspector observed ZPMC qualified welding personnel identified as 046704, 040656. Perform Shielded Metal Arc Welding (SMAW) on Tower Strut. Joint identified as WD1-STSA4-5-123M-1-5A6B, 48A. ZPMC QC Identified as Xu Jie, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-3212-Tc-U5b-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 044551, 044541. Perform Shielded Metal Arc Welding (SMAW) on Tower Strut. Joint identified as ED1-STSA4-6-131M-1-10B, ZPMC QC Identified as Liu Dao Feng, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2212-Tc-U5b.

This QA Inspector observed ZPMC qualified welding personnel identified as 040667, 040614. Perform Shielded

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Metal Arc Welding (SMAW) on Tower Strut. Joint identified as SD1-STSA4-5-127M-1-47B, 5A. ZPMC QC Identified as Xu Jie, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-3212-Tc-U5b-1. For more information see below attach photo number 1.

This QA Inspector observed ZPMC qualified welding personnel identified as 046709. Perform Shielded Metal Arc Welding (SMAW) on Tower Strut. Joint identified as ND1-STSA4-6-127M-2-10B, ZPMC QC Identified as Liu Dao Feng, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2212-Tc-U5b.

This QA Inspector observed ZPMC qualified welding personnel identified as 041271. Perform Shielded Metal Arc Welding (SMAW) on Tower Strut. Joint identified as ND1-STSA4-6-127M-2-5B, ZPMC QC Identified as Liu Dao Feng, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-3212-Tc-U5b-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 040690, 040619. Perform Shielded Metal Arc Welding (SMAW) on East Tower lift 5 Grillage plate. Joint identified as ESD1-TL5-2B/F-35A, 35B. ZPMC CWI Identified as An Xing Qin, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-3213-B-U3c.

BAY 10, Repair Welding:

This QA Inspector observed ZPMC qualified welding personnel identified as 056364. Perform Shielded Metal Arc Welding (SMAW) on North tower lift 4 B/C corner Diagonal plate, after Magnetic Particle Testing done by ZPMC Inspector, repair welding on diagonal plate. ZPMC CWI Identified as Tu Jun, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-1G (1F), 2G (2F)-Repair.

Heat straightening:

This QA Inspector observed ZPMC People doing Heat straightening on Façade plate. Plate identified as SD1-SFSA4-33A/B-5. ZPMC QC Identified as Yu Zhi Lai with heat straightening report, HSR1(T)-11273.

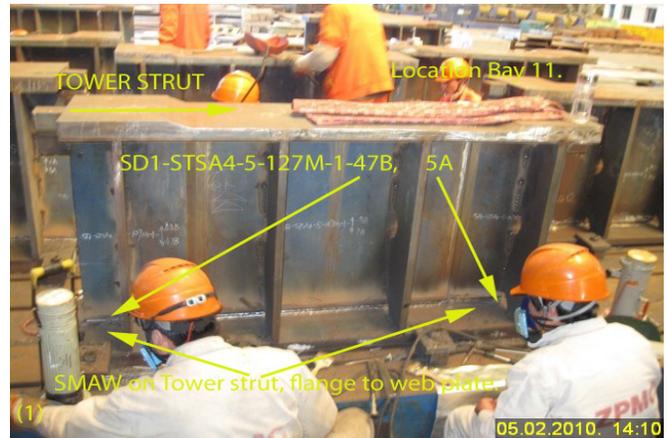
Ultrasonic Testing:

This QA Inspector observed ZPMC Ultrasonic Testing Inspector, performing UT on Façade plate. Plate identified as SD1-SFSA4-10A/B-1, SD1-SFSA4-6A/B-1. For more information see below attach photo number 2.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



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 phone: 15000422360, who represents the Office of Structural Materials for your project.

Inspected By: Gaikwad,Shailesh

Quality Assurance Inspector

Reviewed By: Clifford,William

QA Reviewer