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

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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-013666
Date Inspected: 03-May-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 SKIRT PLATE WD1-A597 (GREEN TAG NO. 11738)

This QA Inspector performed green tagging for the below mentioned components. The components are identified as Tower components. The weld designations are identified as follows.

WD1-A597A/C-1~24
WD1-A597B/C-1~8-1~8, 11
WD1-A597C/C-1~8-1~12
WD1-A597B/C-9, 10
WD1-A597A/C-32~61
WD1-A597A/C-28~31

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

BAY11

TOWER GRILLAGE PLATE
SMAW welding of weld joint 35A located on ESD1-TL5-2B/F.
Welder is identified as 040619. ZPMC CWI is identified as Mr. Li Lin.
The welding variables recorded by QC appeared to comply with WPS-B-T-3213-B-U3b.

LIFT 4 STRUT PLATE
SMAW welding of weld joint 67 located on ED1-STSA4-6-139M-1.
Welders are identified as 046769. ZPMC QC is identified as Mr. Xu Jie.
The welding variables recorded by QC appeared to comply with WPS-B-T-2113.

SMAW welding of weld joint 84 located on ND1-STSA4-6-131M-1.
Welder is identified as 202100. ZPMC QC is identified as Mr. Xu Jie.
The welding variables recorded by QC appeared to comply with WPS-B-T-4113-1.

SMAW welding of weld joint 10A located on ND1-STSA4-6-127M-2.
Welders are identified as 046709. ZPMC QC is identified as Mr. Xu Jin Long.
The welding variables recorded by QC appeared to comply with WPS-B-T-2212-Tc-U5b.

SMAW welding of weld joint 6B located on ED1-STSA4-6-135M-1.
Welder is identified as 044541. ZPMC QC is identified as Mr. Xu Jin Long.
The welding variables recorded by QC appeared to comply with WPS-B-T-3212-Tc-U5b-1.

TOWER GRILLAGE PLATE
This QA inspector witnessed the Ultrasonic Testing (UT) performed by ZPMC NDT personnel on the weld joints GTSA5-B/G-1A/B & GTSA5-B/G-2A/B of Tower Grillage Plate and found to be acceptable. Attached photograph provides additional details.

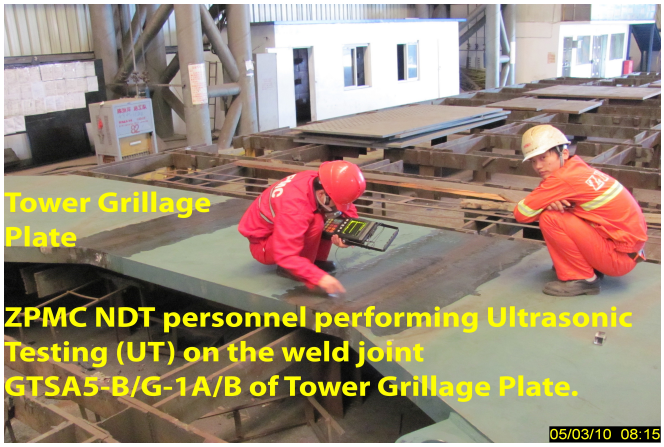
BAY 10

FACADE PLATE
FCAW welding of weld joint 7 located on ND1-SFSA4-710-1.
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.

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

Inspected By:	Gaikwad,Umesh	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer