

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-014099**Date Inspected:** 15-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:** Yu Dong Ping, Yu Qi Guo**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:

OBG Bay 9, Deck Panel DP3120-001

QA inspector performed conventional Ultrasonic Testing (UT) Inspection on deck panel tack weld areas. The inspection is preliminary prior to using the phased array (PAUT) testing system to verify indications found with conventional Ultrasonic testing. QA inspector performed UT on deck panel 13AW-DP3120-001, 2 ribs, 4 welds, 112 total tack welds inspected.

Weld 5 scanned 28 locations with 0 indications.

Weld 6 scanned 28 locations with 1 indication.

Weld 7 scanned 28 locations with 0 indications.

Weld 8 scanned 28 locations with 3 indications.

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

BAY11

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

TOWER STRUT PLATE

SMAW welding of weld joint 48B located on SD1-STSA4-5-143M-1.

Welder is identified as 046704. ZPMC CWI is identified as Yu Dong Ping.

The welding variables recorded by QC appeared to comply with WPS-B-T-3212-Tc-U5b-1.

SMAW welding of weld joint 8B located on WD1-STSA4-5-143M-1.

Welder is identified as 040656. ZPMC CWI is identified as Yu Dong Ping.

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

STRUT ANGLE CONNECTION PLATE (T-CWR624. Rev. 0)

During random in process verification this QA inspector observed that ZPMC personnel were performing base metal repair on the error occurred area due to milling on strut angle connection plate ED1-SA4-68-143M-5.

Welder is identified as 040655. ZPMC QC is identified as Mr. Xu Jin Long. The welding variables recorded by QC appeared to comply with WPS-485-SMAW-1G(1F)-FCM-REPAIR-1.

BAY 10

FAÇADE PLATE

FCAW welding of weld joint 3 located on ND1-SFSA4-72.

Welder is identified as 057244. ZPMC QC is identified as Mr. Yu Zhi Lai.

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

FCAW welding of weld joint 2 located on ND1-SFSA4-62.

Welder is identified as 057266. ZPMC QC is identified as Mr. Yu Zhi Lai.

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

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
---------------------	------------------	-------------