

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-014157**Date Inspected:** 11-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:	An Xiang Qin	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:

BAY 10

This QA Inspector performed randomly Visual Inspection Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL- 6028 (MT) report for this date. The member is identified as Shear plate A24, first bearing plate. The weld designations reviewed are as follows.

ND1-A24A/B-23, 24

NDT Notification No-005711

This QA Inspector observed the following work in progress:

BAY 11:**SMAW Process:**

This QA Inspector observed ZPMC qualified welding personnel identified as 040611, 040614. Perform Shielded Metal Arc Welding (SMAW) on Tower Strut. Joint identified as WD1-STSA4-5-135M-1-48B, 6A. ZPMC CWI Identified as Yu Dong Ping, The welding parameters as measured using QC's calibrated instrument appeared to be

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in general compliance with WPS-B-T-3212-Tc-U5b-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 040611, 040614. Perform Shielded Metal Arc Welding (SMAW) on Tower Strut. Joint identified as WD1-STSA4-5-135M-1-8B. ZPMC CWI Identified as Yu Dong Ping, 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 046704, 040656. Perform Shielded Metal Arc Welding (SMAW) on Tower Strut. Joint identified as WD1-STSA4-5-143M-1-48B, 6A. ZPMC CWI Identified as Yu Dong Ping, 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 Tower Strut. Joint identified as SD1-STSA4-5-123M-1-5B, 47A. ZPMC CWI Identified as Yu Dong Ping, 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 Tower Strut. Joint identified as SD1-STSA4-5-123M-1-7A. ZPMC CWI Identified as Yu Dong Ping, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2212-Tc-U5b.

SMAW Process: Repair Welding:

This QA Inspector observed ZPMC qualified welding personnel identified as 040655. Perform Shielded Metal Arc Welding (SMAW) on Tower Strut. Joint identified as ED1-STSA4-6-131M-2-73A, ZPMC QC Identified as Liu Dao Feng, with temporary welding repair report. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-485-SMAW-2G (2F)-Repair-1.

FCAW Process: Repair Welding,

This QA Inspector observed ZPMC qualified welding personnel identified as 049541, 040725. Perform Flux Core Arc Welding (FCAW) on 9M External diaphragm connection plate Buttering up to 6~19mm. Item identified as ED1-A27, WD1-A25. ZPMC QC Identified as Libin with temporary welding repair report, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-FCAW-2G(2F)Repair. For more information see below attach photo.

FCAW Process:

This QA Inspector observed ZPMC qualified welding personnel identified as 040759, 040723, 040609, Perform Flux Core Arc Welding (FCAW) on bearing plate. Joint identified as WD1-A25B/E-22, 19, 11. ZPMC QC Identified as Shao Hao Long. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2331-Tc-P4-F.

This QA Inspector observed ZPMC qualified welding personnel identified as 042218, 053316, Perform Flux Core Arc Welding (FCAW) on bearing plate. Joint identified as WD1-A25B/E-14, 4, 30. ZPMC QC Identified as Shao

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Hao Long. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2331-Tc-P4-F.

BAY 10

SMAW Process:

This QA Inspector observed ZPMC qualified welding personnel identified as 500363, 500373. Perform Shielded Metal Arc Welding (SMAW) on South Tower lift 5 Grillage plate. Joint identified as SSD1-TL5-1B/F- 35A, 2A, ZPMC QC Identified as Deng Zhi Beng, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-3213-B-U3b. For more information see below attach photo.

FCAW Process:

This QA Inspector observed ZPMC qualified welding personnel identified as 204868, 057258, 057266, Perform Flux Core Arc Welding (FCAW) on bearing plate. Joint identified as ED1-A27B/E-48, 41, 35. ZPMC CWI Identified as You Qi Guo. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2331-Tc-P4-F.

This QA Inspector observed ZPMC qualified welding personnel identified as 057244, 047350, 052926, Perform Flux Core Arc Welding (FCAW) on bearing plate. Joint identified as ED1-A27B/E-33, 28, 25. ZPMC CWI Identified as You Qi Guo. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2331-Tc-P4-F.

This QA Inspector observed ZPMC qualified welding personnel identified as 500363. Perform Flux Core Arc Welding (FCAW) on Bracket plate of North tower lift 3 skin D. Joint identified as E69-0-C/F-26, 27, 28, 29, 30-(1, 2)-N, ZPMC QC Identified as Sun Tian Lian, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2332-Tc-P4-F.

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