

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:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017053**Date Inspected:** 22-Sep-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, Qiu Wen**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:** OBG/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:

TOWER JETTY, NORTH TOWER 109M (NWIT # 06732)

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% and random Visual Testing (VT) of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector has generated MT report for this date. The member(s) are identified as Tower components. The weld designations reviewed are as follows:

NSD1-FASA3-1B/E-22, 24, 29, 30, 33, 34

BAY 11, LIFT 5 EAST TOWER (NWIT # 06730)

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector has generated UT report for this date. The member(s) are identified as Tower components. The weld designations reviewed are as follows:

ESD1-TL5-2B/F-17

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ESD1-TL5-2E/F-16A/B, 29A/B
ESD1-TL5-2F/F-9A/B
ESD1-TL5-2B/F-7A/B, 5A/B

BAY 10, LIFT 5 NORTH TOWER (NWIT # 06734)

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector has generated UT report for this date. The member(s) are identified as Tower components. The weld designations reviewed are as follows:

NSD1-TL5-3B-F-010, 005, 007, 004, 009
NSD1-TL5-3F-F-13A/B, 16A/B

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

BAY 11, BK004A-021 (HSR-9416)

During random in process inspection this QA inspector observed that ZPMC personnel performing heat straightening on the weld joint of deck plate of bike path. The CWI monitoring all the data is identified as Yu Dong Ping. The members are identified as OBG components and the weld designations reviewed are as follows.

BK004A-021

BAY # 10, BK004A-021

During random in process inspection this QA inspector observed that ZPMC NDT personnel performing Ultrasonic Testing (UT) on the weld joint of deck plate of bike path. The members are identified as OBG components and the weld designations reviewed are as follows.

BK004A1-029-009

BAY 10 BIKE PATH

FCAW welding of weld joint 040 located on BK004A4-027.
Welder is identified as 053116. ZPMC QC is identified as Mr. Yuan Hui Gang.
The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

FCAW welding of weld joint 178 located on BK004A7-027.
Welder is identified as 054069. ZPMC QC is identified as Mr. Yuan Hui Gang.
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.

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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 Eric Tsang : 15000422372, who represents the Office of Structural Materials for your project.

Inspected By: Gaikwad,Umesh

Quality Assurance Inspector

Reviewed By: Carreon,Albert

QA Reviewer
