

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-018089**Date Inspected:** 07-Nov-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:** Zhao Chen Sun**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:

TOWER JETTY, LIFT 4 SKIN "E" SUBASSEMBLY (NWIT # 07262)

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as Tower Components. The weld designations reviewed are as follows.

SSD1-FESA4-1B/F-005, 006, 028

NSD1-FESA4-3B/F-017, 018, 020

TOWER JETTY, LIFT 4 SKIN "E" SUBASSEMBLY (NWIT # 07262)

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

SSD1-FESA4-1B/F-005, 006

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NSD1-FESA4-3B/F-017, 018

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

TOWER JETTY

SOUTH TOWER LIFT 4

SMAW welding of weld joint 014 located on SSD1-FASA4-1B/E.

Welder is identified as 057220. ZPMC QC is identified as Mr. Sun Zi Wang.

The welding variables recorded by QC appeared to comply with WPS-B-T-3212-B-U2a-2.

SMAW welding of weld joint 016 located on SSD1-FASA4-1B/E.

Welder is identified as 057220. ZPMC QC is identified as Mr. Sun Zi Wang.

The welding variables recorded by QC appeared to comply with WPS-B-T-4212-Tc-U4c-4.

EAST TOWER LIFT 4

SMAW welding of weld joint 026 located on ESD1-FASA4-2B/E.

Welder is identified as 046769. ZPMC QC is identified as Mr. Sun Zi Wang.

The welding variables recorded by QC appeared to comply with WPS-B-T-3212-B-U2a-2.

SMAW welding of weld joint 005 located on ESD1-FASA4-2B/E.

Welder is identified as 046769. ZPMC QC is identified as Mr. Sun Zi Wang.

The welding variables recorded by QC appeared to comply with WPS-B-T-4212-Tc-U4c-4.

NORTH TOWER LIFT 4

SMAW welding of weld joint 017 located on NSD1-FASA4-1B/E.

Welder is identified as 040582. ZPMC QC is identified as Mr. Sun Zi Wang.

The welding variables recorded by QC appeared to comply with WPS-B-T-3212-B-U2a-2.

SMAW welding of weld joint 015 located on NSD1-FASA4-1B/E.

Welder is identified as 040582. ZPMC QC is identified as Mr. Sun Zi Wang.

The welding variables recorded by QC appeared to comply with WPS-B-T-4214-Tc-U4c.

WEST TOWER LIFT 4

SMAW welding of weld joint 026 located on WSD1-FASA4-2B/E.

Welder is identified as 040690. ZPMC QC is identified as Mr. Sun Zi Wang.

The welding variables recorded by QC appeared to comply with WPS-B-T-3212-B-U2a-2.

SMAW welding of weld joint 005 located on WSD1-FASA4-2B/E.

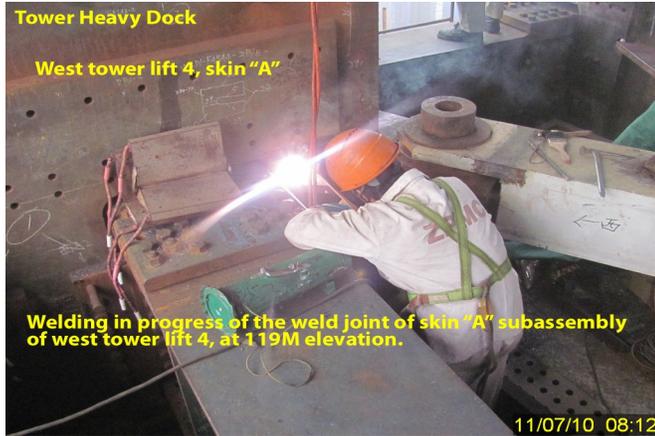
Welder is identified as 040690. ZPMC QC is identified as Mr. Sun Zi Wang.

The welding variables recorded by QC appeared to comply with WPS-B-T-4212-Tc-U4c-4.

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 Thomas Ho - 150002048250, who represents the Office of Structural Materials for your project.

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