

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-018335**Date Inspected:** 15-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:** Xu Le Feng**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:

BAY 10, OBG BIKE PATH (NWIT # 07355)

This QA inspector performed random Visual Testing (VT) of an area previously tested and accepted by ZPMC Quality Control personnel. The members are identified as OBG Components. The weld designations reviewed are as follows.

BK004A-028 (GREEN TAG NO. 13772, STEP # 10)

TOWER JETTY, TOWER DOUBLER OPENING (NWIT # 07356)

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% and random Visual Testing (VT) 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.

DA4-1-3-S-127M

DA4-1-4-S-127M

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DA4-1-3-N-127M
DA4-1-4-N-127M
DA4-1-3-S-139M
DA4-1-4-S-139M
DA4-1-3-N-139M
DA4-1-4-N-139M

BAY 11, GRILLAGE COVER PLATE (NWIT # 07362)

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.

WSD1-TL5-4B/F-59A/B, 64A/B, 67A/B, 69A/B, 73A/B, 79A/B, 42A/B, 45A/B, 48A/B, 51A/B, 52A/B, 55A/B, 58A/B
ESD1-TL5-2B/F-62A/B, 65A/B, 69A/B, 72A/B, 73A/B, 78A/B, 79A/B, 45A/B, 46A/B, 50A/B, 52A/B, 53A/B, 58A/B

BAY 10, OBG BIKE PATH (NWIT # 07368)

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 OBG Components. The weld designations reviewed are as follows.

BK004A1-031-043

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

BAY 10

U-RIB SPLICE PLATE

FCAW welding of weld joints 001 & 002 located on GGL-MQ-2021-32.

Welder is identified as 057180. ZPMC QC is identified as Mr. Li Peng Fei.

The welding variables recorded by QC appeared to comply with WPS-B-T-2232-Tc-U4b-F.

FCAW welding of weld joints 001 & 002 located on GGL-MQ-2021-43.

Welder is identified as 040458. ZPMC QC is identified as Mr. Li Peng Fei.

The welding variables recorded by QC appeared to comply with WPS-B-T-2232-Tc-U4b-F.

TOWER FACADE

SMAW welding of weld joints 011 & 012 located on SD1-SFSA4-500.

Welder is identified as 050038. ZPMC QC is identified as Mr. Jiang Xiao Bo.

The welding variables recorded by QC appeared to comply with WPS-B-P-2114.

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SMAW welding of weld joints 005 & 006 located on SD1-SFSA4-500.
Welder is identified as 057220. ZPMC QC is identified as Mr. Jiang Xiao Bo.
The welding variables recorded by QC appeared to comply with WPS-B-P-2114.

OBG BIKE PATH, CLOSURE BOX

FCAW welding of weld joint 015 & 016 located on BK004ASD1-028.
Welder is identified as 052075. ZPMC QC is identified as Mr. Li Jun.
The welding variables recorded by QC appeared to comply with WPS-B-T-2133.

BAY 11

OBG BIKE PATH, PLUG WELD OF BOTTOM COVER PLATE

SMAW welding of weld joint 015 located on BK004A2-020.
Welder is identified as 66326. ZPMC QC is identified as Mr. Shao Hai Lang.
The welding variables recorded by QC appeared to comply with WPS-B-P-2112-PLUG.

TOWER JETTY

During random in process inspection this QA inspector observed that the hand railing on skin A and skin B of East tower lift 4 at 139M elevation level observed to be bended. The hand railing on skin D and skin E observed to be broken. This issue has been discussed with ZPMC CWI Mr. Zhao Chen Sun and as per discussion ZPMC agreed to replace those broken and bended hand railing as per contract documents. Attached photographs provide additional details.

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 Eric Tsang : 15000422372/ Thomas Ho - 150002048250, who represents the Office of Structural Materials for your project.

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