

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-018356**Date Inspected:** 21-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, Tower lift 4, Padeye of skin A & E (NWIT # 7446)

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

WSD1-FASA4-2A/E-047, 048 GREEN TAG NO. 13653

WSD1-FESA4-4A/F-024 GREEN TAG NO. 13653

TOWER JETTY, Tower lift 4, Fit Lug (NWIT # 7446, FOR CLOSE NCR ZPMC-817)

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

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

ESTL4-2C/L-118, 049
WSTL4-2C/L-118, 049

TOWER JETTY, MANHOLE DOUBLER OPENING PLATE

This QA inspector performed green tagging for the weld joints of manhole doubler opening plate of tower lift 4 at 127M and 139M elevation level. The members are identified as Tower Components. The weld designations reviewed are as follows.

E 127M MANHOLE, GREEN TAG NO. 13651

DA4-1-1~7-E-127M

DA4-1-1~7-W-127M

DA4-1-1~7-S-127M

DA4-1-1~7-N-127M

E 139M MANHOLE, GREEN TAG NO. 13652

DA4-5-1~7-E-139M

DA4-5-1~7-W-139M

DA4-5-1~7-S-139M

DA4-5-1~7-N-139M

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

TOWER JETTY, TOWER LIFT 5

During random in process inspection of tower lift 5, this QA inspector observed that ZPMC personnel were drilling hole on the grillage stiffeners of skin A of South tower lift 5 and North tower lift 5. Attached photograph provide additional details.

During random in process inspection this QA inspector observed that ZPMC personnel were performing trial for the fit up of grillage stiffeners of skin A and skin E of tower lift 5.

TOWER JETTY, TOWER LIFT 4

During random in process inspection this QA inspector observed that ZPMC personnel were performing trial for the fit up of tower façade plate on skin D of North and South tower lift 4 at 119M elevation level. Attached photograph provide additional details.

BAY 11

TOWER LIFT 6, SKIN SUBASSEMBLY

FCAW welding of weld joints 004 & 006 located on WSD1-FCSA6-4.

Welder is identified as 040723. ZPMC QC is identified as Mr. Shao Hai Lang.

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

FCAW welding of weld joints 003 & 005 located on WSD1-FCSA6-4.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Welder is identified as 053316. ZPMC QC is identified as Mr. Shao Hai Lang.
The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

FCAW welding of weld joints 006 located on ESD1-FBSA6-2.
Welder is identified as 040736. ZPMC QC is identified as Mr. Shao Hai Lang.
The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

FCAW welding of weld joints 007 located on ESD1-FBSA6-2.
Welder is identified as 040706. ZPMC QC is identified as Mr. Shao Hai Lang.
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 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
