

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-017575**Date Inspected:** 14-Oct-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:** Mr. 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:** Tower and Orthotropic Box Girder (OBG)**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:

NDT

BAY 11

This QA Inspector performed randomly Visual Inspection and Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6027 (UT) report for this date. The member is identified as Tower lift 5 Bracket stiffener. The weld designations reviewed are as follows.

ND1-BRSA5-2-7A/B, 8A/B, 9A/B, 10A/B, 11A/B, 12A/B, 13A/B, 14A/B

NDT Notification No-06948

This QA Inspector observed the following work in progress:

BAY 10

OBG Bike path plate FCAW process Repair welding:

This QA Inspector observed ZPMC qualified welding personnel identified as 040302, Perform Flux Core Arc Welding (FCAW) on OBG bike path side plate corner joint. Joint identified as BK004A6-025-044. ZPMC QC

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Identified as Yu Zhi Lai 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-1G (1F)-Repair.

SMAW process Repair welding:

This QA Inspector observed ZPMC qualified welding personnel identified as 052493, Perform Shielded metal Arc Welding (SMAW) on OBG bike path side plate corner joint. Joint identified as BK004A6-025-044. ZPMC QC Identified as Yu Zhi Lai with temporary welding repair report. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-4G (4F)-Repair. For more information see below attached picture number 1.

This QA Inspector observed ZPMC qualified welding personnel identified as 052075, 053869, 057180, Perform Flux Core Arc Welding (FCAW) on OBG bike path stringer plate to deck plate. Joint identified as BK007A3-001-051, 052. ZPMC QC Identified as Li Peng fei. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2132. For more information see below attached picture number 2.

This QA Inspector observed ZPMC qualified welding personnel identified as 057180, 057258, Perform Flux Core Arc Welding (FCAW) on OBG bike path stringer plate. Joint identified as BK007A4-001-014, 015. ZPMC QC Identified as Li Peng fei. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2132.

This QA Inspector observed ZPMC qualified welding personnel identified as 053869, 052075, Perform Flux Core Arc Welding (FCAW) on OBG bike path plate. Joint identified as BK007A7-001-025, 026, 031, 032, 158, 159, 165, 166, 085, 086, 091, 092. ZPMC QC Identified as Li Peng fei. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2132.

BAY 11

OBG Bike path plate FCAW process:

This QA Inspector observed ZPMC qualified welding personnel identified as 040736, Perform Flux Core Arc Welding (FCAW) on OBG bike path plate. Joint identified as BK004A5-022-129, 144. ZPMC QC Identified as Shao Hai Lang. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2233.

This QA Inspector observed ZPMC qualified welding personnel identified as 040736, Perform Flux Core Arc Welding (FCAW) on OBG bike path plate. Joint identified as BK004A-022-018, 019, 020, 021. ZPMC QC Identified as Shao Hai Lang. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2233.

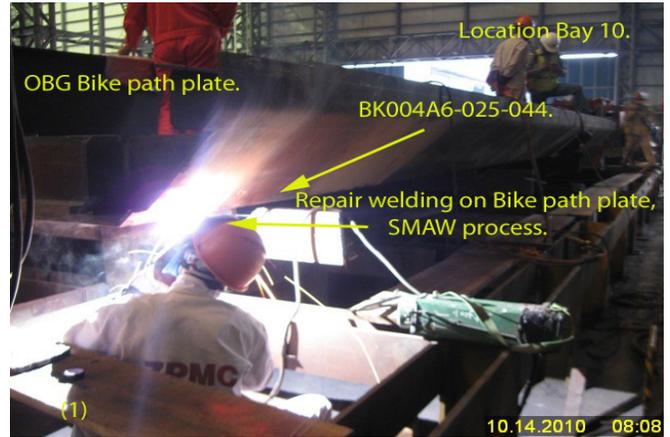
This QA Inspector observed ZPMC qualified welding personnel identified as 042218, 053316, Perform Flux Core Arc Welding (FCAW) on OBG bike path plate. Joint identified as BK004A8-021-063, 070, 080, 078. ZPMC QC Identified as Shao Hai Lang. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2132.

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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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 Michael Ng Phone: 15921845703, who represents the Office of Structural Materials for your project.

Inspected By: Gaikwad,Shailesh

Quality Assurance Inspector

Reviewed By: Clifford,William

QA Reviewer