

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-017714**Date Inspected:** 29-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:** Xu Le Feng, Yu Dong Ping**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 # 07148)

This QA inspector performed random Visual Testing (VT) for step 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-017

BK004A-021

TOWER DOCK, CROSS BRACING

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.

WD1-GUSA3-3-119M-N-3A/B

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WD1-GUSA3-3-119M-N-4A/B

WD1-GUSA3-3-119M-S-4A/B

BAY 10, OBG BIKE PATH (GREEN TAG NO. 13756)

This QA inspector performed green tagging for the weld joints of bearing stiffener to end plate of OBG bike path. The members are identified as OBG Components. The weld designations reviewed are as follows.

BK004A3-026-002, 010

BK004A5-026-002, 008

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

BAY 10

TOWER GRILLAGE COVER PLATE

SAW welding of weld joint 044A located on SSD1-TL5-1B-F.

Welder is identified as 040414. ZPMC QC is identified as Mr. Li Peng Fei.

The welding variables recorded by QC appeared to comply with WPS-B-T-3221-B-U3c-S-1.

OBG BIKE PATH

FCAW welding of weld joint 043 located on BK004A1-029.

Welders are identified as 040302 & 053869. ZPMC QC is identified as Mr. Yu Zhi Lai.

The welding variables recorded by QC appeared to comply with WPS-B-T-2232-Tc-U4c-F.

SMAW welding of weld joint 044 located on BK004A1-029.

Welders are identified as 056200, 057258 & 500363. ZPMC QC is identified as Mr. Yu Zhi Lai.

The welding variables recorded by QC appeared to comply with WPS-B-P-2214-B-U2.

OBG BIKE PATH, BK004A-026

During random in process inspection this QA inspector observed that the fit up for the weld number BK004A5-026-004 of exterior end diaphragm plate to the end plate of OBG bike path has been performed by ZPMC personnel by using noncontinuous steel backing. As per AWS D1.5, Section 3.13.2; Steel backing shall be continuous for the full length of each weld made with backing. This issue discussed with ZPMC CWI Mr. Qiu Wen and ZPMC agreed to replace the noncontinuous steel backing bar with continuous steel backing bar.

BAY 11

OBG BIKE PATH

FCAW welding of weld joints 016 & 017 located on BK004C5-024.

Welder is identified as 040759. ZPMC QC is identified as Mr. Xu Jie.

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

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FCAW welding of weld joints 022 & 023 located on BK004C5-024.
Welder is identified as 042218. ZPMC QC is identified as Mr. Xu Jie.
The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

FCAW welding of weld joints 030 & 031 located on BK004A1-018.
Welder is identified as 056316. ZPMC QC is identified as Mr. Wang Chuan Xin.
The welding variables recorded by QC appeared to comply with WPS-B-P-2113.

FCAW welding of weld joints 025 & 026 located on BK004A3-020.
Welder is identified as 054460. ZPMC QC is identified as Mr. Wang Chuan Xin.
The welding variables recorded by QC appeared to comply with WPS-B-T-2133.

SMAW welding of weld joints 014 & 015 located on BK004A1-018.
Welder is identified as 040724. ZPMC QC is identified as Mr. Wang Chuan Xin.
The welding variables recorded by QC appeared to comply with WPS-B-P-2113.

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, who represents the Office of Structural Materials for your project.

Inspected By: Gaikwad,Umesh

Quality Assurance Inspector

Reviewed By: Clifford,William

QA Reviewer