

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-018064**Date Inspected:** 26-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 Xian 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:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this date Caltrans Office of Structural Material (OSM) Quality Assurance (QA) Inspector, D.Sukanthan was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

OBG # BAY 6

This QA observed ZPMC qualified welding personnel identified as 053742 perform Flux Cored Arc Welding (FCAW) Process on weld joint CB3002J-001-280. ZPMC Quality Control Personnel (QC) identified as Mr. Zheng Zhi Wei was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2134.

This QA observed ZPMC qualified welding personnel identified as 053609 perform Flux Cored Arc Welding (FCAW) Process on weld joint CB3002K-004-278. ZPMC Quality Control Personnel (QC) identified as Mr. Zheng Zhi Wei was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2134.

OBG # BAY 7

During the Caltrans Quality Assurance in-process observations of the fabrication of Cross beam CB19, this Quality Assurance Inspector (QA) discovered the following issue. ZPMC has tack welded temporary fixtures to

WELDING INSPECTION REPORT

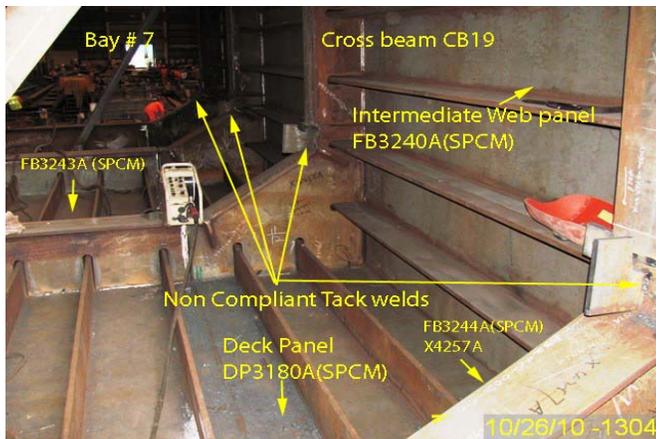
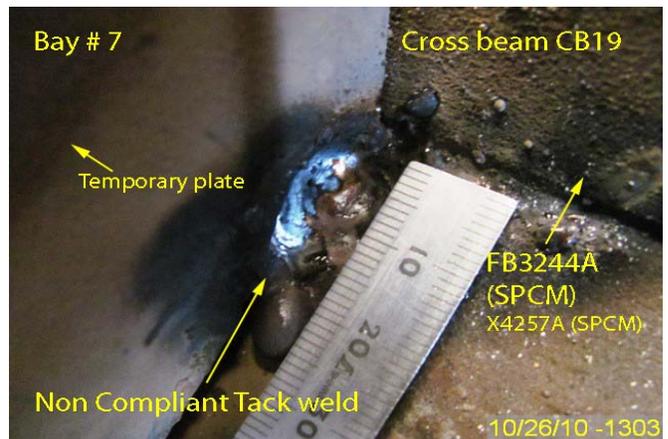
(Continued Page 2 of 3)

Seismic Performance Critical Member (SPCM) without Engineers approval. Additionally, the size and length of the tack welds do not meet the requirements of AWS D1.5 2002, table 12.2. The approved shop drawings do not specify any welds in these areas. The tack welds are located on floor beam diaphragms identified as X4257A (SPCM) and Intermediate web panel FB3240A (SPCM). The length of these tack welds measured 10mm to 30mm in length. This condition exists in the following locations: FB3246-001, FB3245-001, FB3245-002, FB3246-002, FB3244-001, FB3243-001, FB3243-002, FB3244-002 and FB 3240A. This QA notified ZPMC QC identified as Mr. Xu xiang ping of this issue and that an incident report would be generated. For further information, please see the attached pictures below.

OBG # BAY 8

This QA observed ZPMC qualified welding personnel identified as 054459 perform Flux Cored Arc Welding (FCAW) Process on weld joint BK004A4-054-014,015. ZPMC Quality Control Personnel (QC) identified as Mr. Feng ya jun was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance 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:

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

As mention above

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 150-00422372, who represents the Office of Structural Materials for your project.

Inspected By:	Sukanthan,Dhanasingh	Quality Assurance Inspector
----------------------	----------------------	-----------------------------

Reviewed By:	Hall,Steven	QA Reviewer
---------------------	-------------	-------------