

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-018110**Date Inspected:** 13-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:** Mr. 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:** 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 10

This QA Inspector performed randomly Visual Inspection and Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL- 6028 (MT) report for this date. The member is identified as Tower Façade Pad eye. The weld designations reviewed are as follows.

ND1-SFSA4-16-2, ND1-SFSA4-14-2, ND1-SFSA4-13-2, ND1-SFSA4-15-2,

ND1-SFSA4-4-2, ND1-SFSA4-27-2,

NDT Notification No-07336

BAY 11

This QA Inspector performed randomly Visual Inspection and Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL- 6028 (MT) report for this date. The member is identified as OBG Bike Path. The weld designations reviewed are as follows.

BK004A8-019-021, 029, 030, 034, 041, 042, 116, 118

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BK004A6-019-021, 029, 030, 034, 041, 042, 116, 118
NDT Notification No-07342

This QA Inspector observed the following work in progress:

BAY 11

OBG Bike path, FCAW process:

This QA Inspector observed ZPMC qualified welding personnel identified as 042218, Perform Flux Core Arc Welding (FCAW) on OBG Bike path. Joint identified as BK005B6-004-023, 024, 035, 160. ZPMC CWI Identified as Yu Dong Ping. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2132.

Tower Bracket Stiffener, SMAW process:

This QA Inspector observed ZPMC qualified welding personnel identified as 040724, Perform Shielded Metal Arc Welding (SMAW) on Tower Bracket Stiffener lift 5. Joint identified as ND1-BRSA5-2-2A. ZPMC QC Identified as Xu Jie. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-3213-Tc-U4b. For more information see below attached picture number 1.

This QA Inspector observed ZPMC qualified welding personnel identified as 040724, Perform Shielded Metal Arc Welding (SMAW) on Tower Bracket Stiffener lift 5. Joint identified as ND1-BRSA5-2-3A. ZPMC QC Identified as Xu Jie. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-3213-Tc-U4b.

Heat Straightening:

This QA Inspector observed ZPMC personnel Perform Heat straightening on Tower lift 5 bracket stiffener. Joint identified as SD1-BRSA5-1-6A/B, The maximum deformation observed is about 3mm. ZPMC QC Identified as Xu Jie with heat straightening report HSR1 (T) - 11556.

BAY 10

OBG FCAW process:

This QA Inspector observed ZPMC qualified welding personnel identified as 052075 Perform Flux Core Arc Welding (FCAW) on OBG Bike path. Joint identified as BK004A5-032-078, 079, 080, 081. ZPMC QC Identified as Yu Zhi Lai. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2133.

This QA Inspector observed ZPMC qualified welding personnel identified as 040533 Perform Flux Core Arc Welding (FCAW) on OBG Bike path. Joint identified as BK004A6-028-001, 165. ZPMC QC Identified as Yu Zhi Lai. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2332-Tc-P4-F.

This QA Inspector observed ZPMC qualified welding personnel identified as 053869 Perform Flux Core Arc Welding (FCAW) on OBG Bike path. Joint identified as BK004A8-028-001, 130, . ZPMC QC Identified as Yu Zhi Lai. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2332-Tc-P4-F.

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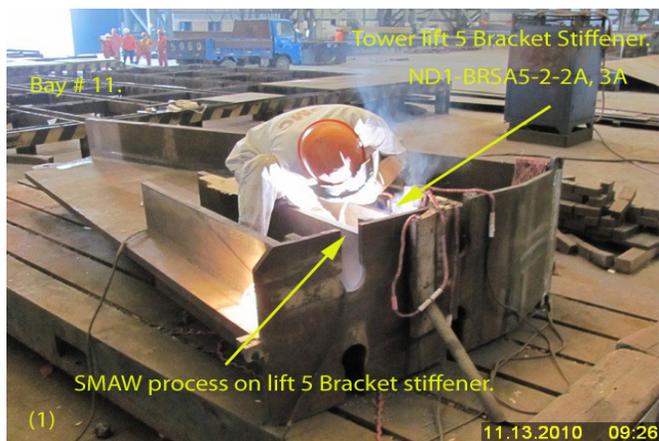
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This QA Inspector observed ZPMC qualified welding personnel identified as 052075 Perform Flux Core Arc Welding (FCAW) on OBG Bike path. Joint identified as BK004A7-032-129, 144, 145, 160, 167, 182, 183, 198. ZPMC QC Identified as Yu Zhi Lai. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2133.

OBG FCAW process:

This QA Inspector observed ZPMC qualified welding personnel identified as 057180, 052763 Perform Flux Core Arc Welding (FCAW) on U Rib splice plate. Joint identified as GGL-MQ-2021-46, 47-1, 2. ZPMC QC Identified as Deng Zhi Bing. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2231-Tc-U4b-F. For more information see below attached picture number2.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the 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 phone : 150002048250, who represents the Office of Structural Materials for your project.

Inspected By: Gaikwad,Shailesh

Quality Assurance Inspector

Reviewed By: Clifford,William

QA Reviewer