

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-018734**Date Inspected:** 12-Dec-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. Zhu Zhong Hai.**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 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

OBG TRAL ASSEMBLY

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 Segment 11EE Hold Back area. The weld designations reviewed are as follows.

DP708-001-009, 010

DP721-001-017, 018

EP161-001-009, 010

EP174-001-009, 010

SP705-001-021, 022, 027, 028

SP117-001-031, 032, 039, 040,

SP144-001-029, 030, 033, 034,

SP171-001-031, 032

SP786-001-035, 036

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

SP746-001-035, 036
SP508-001-029, 030
SP718-001-027, 028
BP109-001-025, 026, 035, 036,
BP055-001-025, 026
BP163-001-035, 036
NDT Notification No-07743

This QA Inspector observed the following work in progress:

OBG TRIAL ASSEMBLY

OBG Segment 12AE-12BE

This QA Inspector observed ZPMC qualified welding personnel identified as 047353, 040458 Perform Flux Core Arc Welding (FCAW) on OBG segment 12AE + 12BE Bottom plate to Bottom plate joint. Joint identified as OBE12B-001. ZPMC QC Identified as Wang Li Yang. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2231-T-ESAB. For more information see below attached picture number 1.

OBG Segment 12AE-12BE

This QA Inspector observed ZPMC qualified welding personnel identified as 040367 Perform Flux Core Arc Welding (FCAW) on OBG segment 12AE + 12BE "T" rib of bottom plate. Joint identified as BP3001-001-038. ZPMC QC Identified as Wang Li Yang. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2233-ESAB. For more information see below attached picture number 2.

Segment 12BW Repair welding:

This QA Inspector observed ZPMC qualified welding personnel identified as 045268 Perform Shielded Metal Arc Welding (SMAW) on OBG segment 12BW T rib lug repair welding. Joint identified as SEG3005E-090, 091, 092, 093, 094, 095. ZPMC QC Identified as Zhang Qiang with temporary welding repair report WRR-B-WR 16209. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-3G (3F)-Repair.

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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



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 phone :150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By: Gaikwad,Shailesh

Quality Assurance Inspector

Reviewed By: Carreon,Albert

QA Reviewer