

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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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-020826**Date Inspected:** 22-Feb-2011**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:** Guo Yan Fei**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 Components**Summary of Items Observed:**

During the fabrication of the Orthotropic Box Girder (OBG) Bike Path (BK) BK004A-031, this Quality Assurance (QA) Inspector discovered the following:

-ZPMC has changed a weld joint detail from fillet to Complete Joint Penetration (CJP) because the fit-up of the root exceeded 5mm.

-ZPMC indicated that the work is performed per Submittal 200R2.

-QA observed that Submittal 200R2 was not followed.

-ZPMC welded a single bevel weld without backing bar and with no access to perform backgouging.

-ZPMC used "WPS-345-SMAW-4G(4F)-Repair" for the work which is not appropriate for this new CJP joint.

-Without Engineer's approval, ZPMC is changing these welds from fillet to CJP only in certain sections of the welds, thus they are not continuous CJP with continuous backing.

-The fillet welds observed are BK004A2-031-013 and 021.

-The Y locations for the changed CJP welds on BKPL6A are:

• 0mm~1500mm, 3050mm~3550mm and 6520mm~9020mm for BK004A2-031-013.

• 0mm~2000mm for BK004A2-031-021.

-ZPMC identified the new CJP weld IDs as BK004A2-031-024, and BK004A2-031-022, 023, 025.

-The material is A709 Grade 345 Non Seismic Performance Critical Member (Non SPCM).

-The approved drawings, BK004A, specify fillet welds at these locations.

-The OBG Bike Path as located in Sub assembly Bay # 10.

For further information please find attached Pictures.

Bay#10

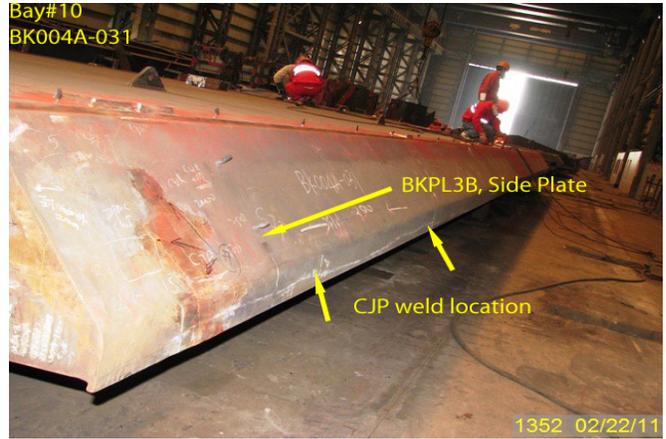
WELDING INSPECTION REPORT

(Continued Page 2 of 2)

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member is identified as OBG Components. The weld designations reviewed are as follows:

- (BK008A3-001-002, 010)
- (BK008A5-001-002, 008)

Unless otherwise noted, all observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations.

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

Inspected By:	Patel, Hiranch	Quality Assurance Inspector
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Reviewed By:	McClendon, Timothy	QA Reviewer
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