

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-021547**Date Inspected:** 06-Mar-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:** Li Yang**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 16

This QA observed ZPMC qualified welding personnel identified as 222396 perform Flux Cored Arc Welding (FCAW) Process on weld joint W2-SB14-002-126,127,128,129. ZPMC Quality Control Personnel (QC) identified as Mr. Ma qian li 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-ESAB.

This QA observed ZPMC qualified welding personnel identified as 048625 perform Flux Cored Arc Welding (FCAW) Process on weld joint W2-SB28-001-082,083,084,085. ZPMC Quality Control Personnel (QC) identified as Mr. Ma qian li 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-2133-ESAB.

This QA observed ZPMC qualified welding personnel identified as 053753 perform Shielded Metal Arc Welding (SMAW) Process on weld joint W2-SB26-001-001,002,003,004. ZPMC Quality Control Personnel (QC) identified as Mr. Ma qian li 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-P-2113.

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This QA observed ZPMC qualified welding personnel identified as 201905 perform Shielded Metal Arc Welding (SMAW) Process on weld joint E5-SB25-001-032,033,034,035. ZPMC Quality Control Personnel (QC) identified as Mr. Ma qian li 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-P-2113.

This QA observed ZPMC qualified welding personnel identified as 201074 perform Flux Cored Arc Welding (FCAW) Process on weld joint W2-SB17-001-081. ZPMC Quality Control Personnel (QC) identified as Mr. Ma qian li 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-2231-ESAB.

This QA inspector observed that ZPMC Magnetic particle Testing (MT) technician perform MT on Lift13AE, FL#3 bottom panel is identified as BP3050-001. During testing ZPMC MT technician found Transverse cracks. The affected fillet weld joints is identified as BP3050-001-weld 42, weld 41, weld 50, weld 49 and weld 44. ZPMC Certified Welding Inspector (CWI) identified as Mr. Xu tao informed this QA that the crack welds would be corrected in a manner compliant with the contract document. See attached photos.

OBG # SEGMENT 12AE

This QA observed ZPMC qualified welding personnel identified as 200113 perform Shielded Metal Arc Welding (SMAW) Process on weld joint SEG3001Y-070,071. ZPMC Quality Control Personnel (QC) identified as Mr. Li yang 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-P-2114-FCM-1.

OBG # CROSSBEAM CB18

This QA observed that no significant work was being performed on this crossbeam during the time QA was present.

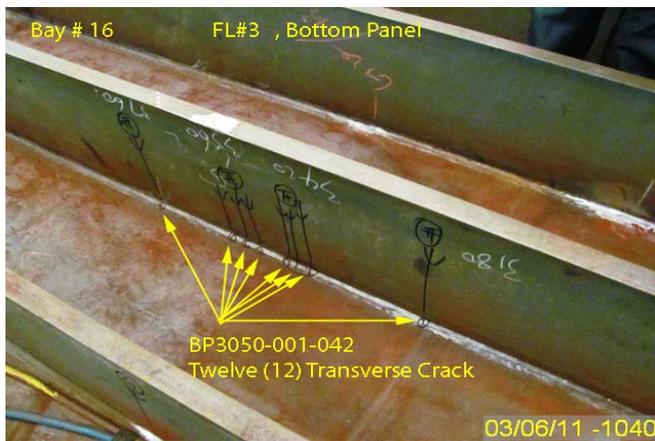
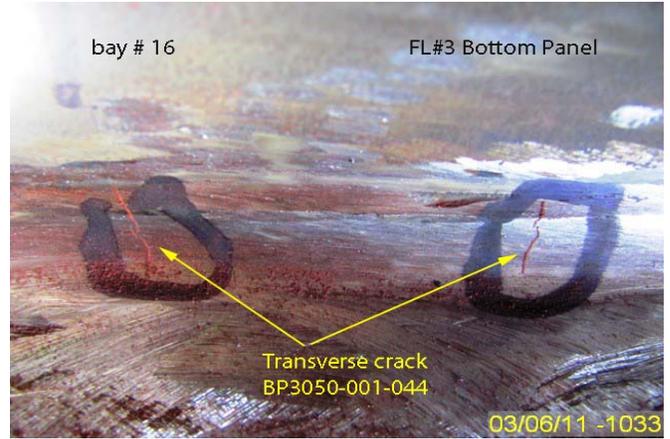
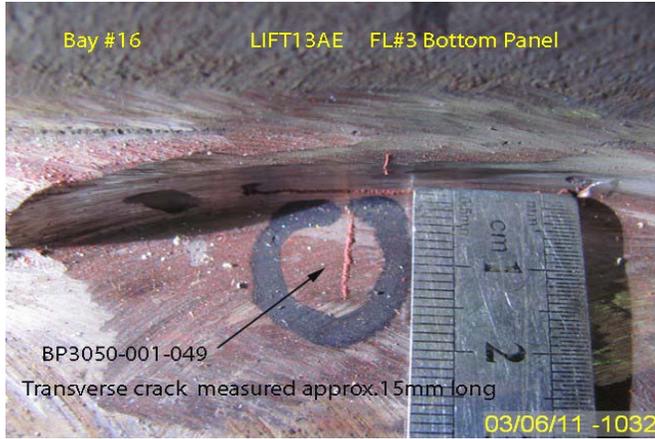
OBG # CROSSBEAM CB19

This QA observed that no significant work was being performed on this crossbeam during the time QA was present.

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

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Summary of Conversations:

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