

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-022002**Date Inspected:** 16-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:** Mr. An Qing Xian.**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 Chang xing Island in Shanghai, China. QA observed and/or found the following:

BAY # 14

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 Deck Panel U Rib. The weld designations reviewed are as follows.

DP3162-001-203, 206, 038, 039, 046, 047, 054, 055, 062, 063, 070, 071, 092, 093, 100

DP3162-001-101, 108, 109, 116, 117, 124, 125, 148, 156, 157, 164, 165, 172, 173, 180,

DP3162-001-077,078, 291,292,

NDT Notification No-08556

This QA Inspector observed the following work in progress:

OBG 14EAST

SMAW process:

This QA Inspector observed ZPMC qualified welding personnel identified as 067656 Perform Shielded Metal Arc

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Welding (SMAW) on OBG Segment Deck panel to longitudinal diaphragm. Joint identified as DP3104-001-246. ZPMC QC Identified as Zhan Hai Feng. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2213-Tc-U4b-FCM-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 066326 Perform Shielded Metal Arc Welding (SMAW) on OBG Segment. Joint identified as DP3105-001-045, 046. ZPMC QC Identified as Zhan Hai Feng. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2114 -FCM-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 070432, 066002 Perform Shielded Metal Arc Welding (SMAW) on OBG Segment 13BW Deck panel. Joint identified as SA3231D-001-171, 181, 175, 176. ZPMC QC Identified as Shi Lei. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-4113-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 068097 Perform Shielded Metal Arc Welding (SMAW) on OBG Segment. Joint identified as SEG3019H-021. ZPMC QC Identified as Zhu Yuan Yuan. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2114-FCM-1. For more information see attached picture number 1.

SMAW Process, Repair welding:

This QA Inspector observed ZPMC qualified welding personnel identified as 066398 Perform Shielded Metal Arc Welding (SMAW) on OBG Segment Saddle support beam. Joint identified as SA3174-001-025. ZPMC QC Identified as Shi Lei with temporary welding repair report WRR-B-WR20383. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-2G (2F)-FCM-Repair. For more information see attached picture number 2.

SMAW Process, Repair welding:

This QA Inspector observed ZPMC qualified welding personnel identified as 067571, 037723 Perform Shielded Metal Arc Welding (SMAW) on OBG Segment anchorage plate. Joint identified as SEG3019Z-005, 006. ZPMC QC Identified as Zhu Yuan Yuan with temporary welding repair report WRR-B-WR20361. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-2G (2F)-FCM-Repair.

FCAW process:

This QA Inspector observed ZPMC qualified welding personnel identified as 066263 Perform Flux Core Arc Welding (FCAW) on OBG Segment 13CE Deck panel U rib. Joint identified as VP3007-001-020, 021. ZPMC QC Identified as Zhan Hai Feng. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2211-ESAB.

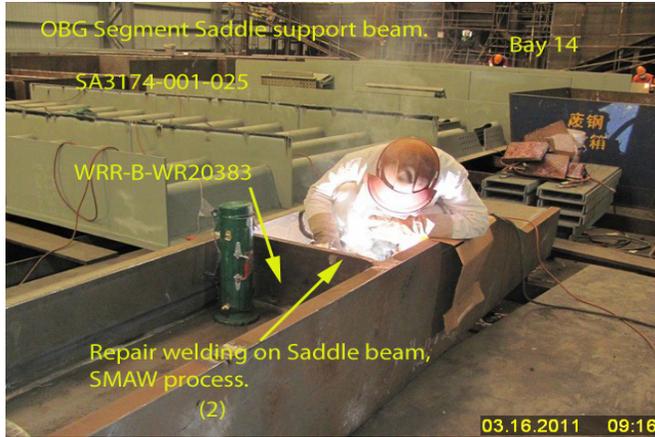
SMAW Process:

This QA Inspector observed ZPMC qualified welding personnel identified as 037779, 067520 Perform Shielded Metal Arc Welding (SMAW) on OBG Segment 13west. Joint identified as SEG3020AW-089. ZPMC CWI Identified as An Qing Xing. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2212-Tc-U4b-FCM-1.

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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: 150002048250, who represents the Office of Structural Materials for your project.

Inspected By: Gaikwad,Shailesh

Quality Assurance Inspector

Reviewed By: Patterson,Rodney

QA Reviewer