

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-024400**Date Inspected:** 30-Apr-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. Gang Wei
Inspected CWI report: Yes No N/A
Electrode to specification: Yes No N/A
Qualified Welders: Yes No N/A
Approved Drawings: Yes No N/A

CWI Present: Yes No
Rod Oven in Use: Yes No N/A
Weld Procedures Followed: Yes No N/A
Verified Joint Fit-up: 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:

OBG Trial Assembly

This QA Inspector performed randomly Visual Inspection and Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6027 (UT) report for this date. The member is identified as OBG Segment 14 East. The weld designations reviewed are as follows.

SEG3019D-1-005, 006, 008, 009, 010, 065, 070, 075, 080

SEG3019E-1-007, 008, 009, 010, 070, 075, 080

NDT Notification No-08989

This QA Inspector observed the following work in progress:

OBG Trial Assembly**SMAW Process:**

This QA Inspector observed ZPMC qualified welding personnel identified as 0447791, 215553 Perform Shielded Metal Arc Welding (SMAW) on OBG Segment 14 East. Joint identified as SEG3019G-003, 004. ZPMC CWI

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Identified as Lv Li Qing. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS -B-P-2114-FCM-1.

FCAW Process:

This QA Inspector observed ZPMC qualified welding personnel identified as 055564 Perform Flux Core Arc Welding (FCAW) on OBG Segment 13 East. Joint identified as SEG3019M-021. ZPMC CWI Identified as Lv Li Qing. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2132-ESAB.

Repair welding, SMAW Process:

This QA Inspector observed ZPMC qualified welding personnel identified as 037723 Perform Shielded Metal Arc Welding (SMAW) on OBG Segment 14 East. Joint identified as SEG3019AL-009. ZPMC CWI Identified as Lv Li Qing with Temporary welding repair report WWR-B-WR20235. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-4G (4F)-FCM-Repair-1.

Repair welding, SMAW Process:

This QA Inspector observed ZPMC qualified welding personnel identified as 215553 Perform Shielded Metal Arc Welding (SMAW) on OBG Segment 14 East. Joint identified as SEG3019AL-002. ZPMC CWI Identified as Lv Li Qing with Temporary welding repair report WWR-B-WR20235. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-4G (4F)-FCM-Repair-1.

Repair welding, SMAW Process:

This QA Inspector observed ZPMC qualified welding personnel identified as 066422 Perform Shielded Metal Arc Welding (SMAW) on OBG Segment 14 East. Joint identified as SEG3019Q-2-223. ZPMC CWI Identified as Lv Li Qing with Temporary welding repair report WWR-B-WR20619. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-3G (3F)-FCM-Repair-1.

Repair welding, SMAW Process:

This QA Inspector observed ZPMC qualified welding personnel identified as 216086 Perform Shielded Metal Arc Welding (SMAW) on OBG Segment 14 East. Joint identified as SEG3019N-304. ZPMC CWI Identified as Lv Li Qing with Temporary welding repair report WWR-B-WR20620. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-3G (3F)-FCM-Repair-1.

Repair welding, SMAW Process:

This QA Inspector observed ZPMC qualified welding personnel identified as 068917 Perform Shielded Metal Arc Welding (SMAW) on OBG Segment 14 East Bottom plate, after removing temporary attachment area. ZPMC CWI Identified as Lv Li Qing with Critical welding repair report CWR-B-CWR2944. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-4G (4F)-FCM-Repair-1. For more information see attached picture number 1.

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

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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: 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Shailesh	Quality Assurance Inspector
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Reviewed By:	Patterson,Rodney	QA Reviewer
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