

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:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016760**Date Inspected:** 21-Aug-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:** Le Zhi Jiang**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.

OBG # BAY 3

This QA inspector received ZPMC Non Destructive Testing (NDT) notification 06451 to perform Magnetic particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated a Magnetic particle Test report for this date. The member is identified as Floor beam. The weld tested is identified as follows:

(FB3123-001-041,042,036,037,024,025,018,019,014,015,038,039,034,035,030,031,026,027)

(FB3123-001-020,021,012,013,127,121,122,008,009,010,011)

OBG # BAY 6

This QA inspector received ZPMC Non Destructive Testing (NDT) notification 06454 to perform Magnetic particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated a Magnetic particle Test report for this date. The member is identified as Side Panel. The weld tested is identified as follows:

(SP3117F-001-048,049)

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(SP3130A-001-028)
(SP3128A-001-038,039)
(SP3118E-001-038,039)
(SP3142E-001-030,031,006)

This QA Inspector randomly observed the following work in progress:

OBG # BAY 6

This QA observed ZPMC qualified welding personnel identified as 054458 perform Submerged Arc Welding (SAW) Process on weld joint SA3075-001-001. ZPMC Quality Control Personnel (QC) identified as Mr. Li Jia 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-2221-B-L2C-S-2.

This QA observed ZPMC qualified welding personnel identified as 054458 perform Submerged Arc Welding (SAW) Process on weld joint SA3075-002-001. ZPMC Quality Control Personnel (QC) identified as Mr. Li Jia 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-2221-B-L2C-S-2.

During random in-process inspection, this QA inspector observed that ZPMC Magnetic particle Testing (MT) technician identified as Mr. Tan cho wei was found one (1) transverse linear indication measured approximately 10mm length. The transverse linear indication is located in weld identified as DP3114-001-003. Y location of this indication is 620mm from south end of the deck panel. This QA informed ZPMC QC identified as Mr. Li Jia of this issue. Mr. Li jia informed this QA that the indication would be corrected in a manner compliant with the contract documents. See attached pictures.

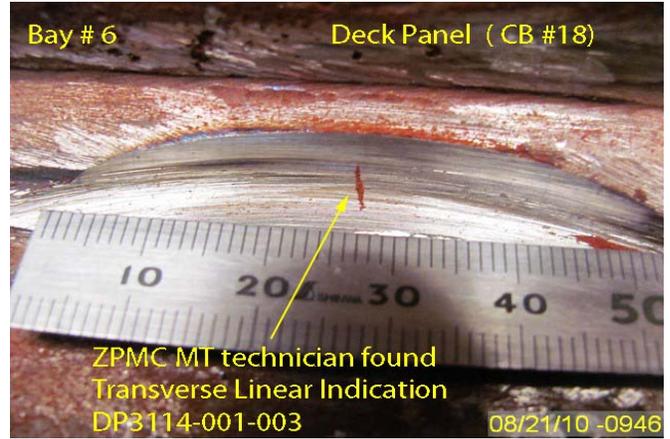
OBG # BAY 7

This QA observed ZPMC qualified welding personnel identified as 053748 perform Submerged Arc Welding (SAW) Process on weld joint CB3002C-001-003. ZPMC Quality Control Personnel (QC) identified as Mr. Cui jun jie 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-2221-B-U3C-S-2.

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