

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-017050**Date Inspected:** 19-Sep-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:** Ye Yong Jun**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**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh 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 Changxing Island in Shanghai, China. QA observed and/or found the following:

BAY 10, BOTTOM PLATE (NWIT # 06709, GREEN TAG NO. # 13740)

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector has generated MT report for this date. The member(s) are identified as OBG components. The weld designations reviewed are as follows:

BP3087-001-001, 002, 005, 006, 065, 066, 009~011, 017~022, 024~026, 028~031, 055, 056, 041, 042, 049, 050

BAY 04, OBG DECK PANEL (NWIT # 06715)

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector has generated MT report for this date. The member(s) are identified as OBG components. The weld designations reviewed are as follows:

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DP3175(PL3488A)-001-001~010 GREEN TAG NO. # 14628

DP3175(PL3488B)-001-011~020 GREEN TAG NO. # 14629

This Quality Assurance (QA) Inspector observed the following work in progress:

BAY 10, EDGE PLATE, EP3029A (HSR-B417)

During random in process inspection this QA inspector observed that ZPMC personnel performing heat straightening on the weld joint of edge plate EP3029A. The members are identified as OBG components and the weld designations reviewed are as follows.

EP3029-001

SIDE PLATE OF BIKE PATH, BK005A-BKPL3B (B-WR11364)

During random in process inspection this QA inspector observed that ZPMC personnel performing buttering on the edge of side plate of bike path BK005A-BKPL3B by Flux Cored Arc Welding (FCAW) process. Welder is identified as 057266. ZPMC QC is identified as Mr. Sun Tain Liang. The welding variables recorded by QC appeared to comply with WPS-345-FCAW-2G(2F)-REPAIR.

BAY 10 BIKE PATH

FCAW welding of weld joint 041 located on BK004A4-026.

Welder is identified as 053116. ZPMC QC is identified as Mr. Ma Qian Li.

The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

FCAW welding of weld joint 042 located on BK004A4-026.

Welder is identified as 054069. ZPMC QC is identified as Mr. Ma Qian Li.

The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

TOWER FACADE

FCAW welding of weld joint 012 located on ND1-SFSA4-267.

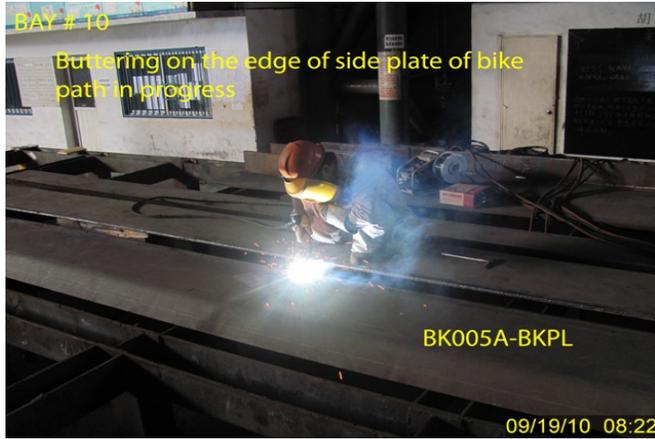
Welder is identified as 057266. ZPMC QC is identified as Mr. Yin Chun Fang.

The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

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

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| Inspected By: | Gaikwad,Umesh | Quality Assurance Inspector |
| Reviewed By: | Carreon,Albert | QA Reviewer |
