

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-017631**Date Inspected:** 08-Oct-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:** Yu Dong Ping, Qiu Wen**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/TOWER**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 12, OBG (NWIT # 06884, GREEN TAG NO. 12463)

This QA inspector performed Ultrasonic Testing (UT) of approximately more than 10% lot testing of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT reports for this date. The members are identified as OBG Components. The weld designations reviewed are as follows.

SA3051B-8-003, 004

SA3051B-9-003, 004

SA3051B-10-003, 004

SA3051B-11-003, 004

SA3051B-12-003, 004

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

BAY 11, OBG BIKE PATH

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ZPMC personnel heat straightening Orthotropic Box Girder (OBG) member identified as BK004A-022. Distortion appeared to be caused by welding of the material. ZPMC Quality Control (QC) inspector identified as Mr. Shao Hai Lang was present to monitor the heat straightening process. The heat straightening appeared to comply with Heat Straightening Report (HSR) number 9564.

FCAW welding of weld joints 014 & 015 located on BK004A4-019. Welders are identified as 049220 & 042218. ZPMC QC is identified as Mr. Mao Bin Bin. The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

FCAW welding of weld joints 051 & 052 located on BK004A3-019. Welders are identified as 049220 & 042218. ZPMC QC is identified as Mr. Mao Bin Bin. The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

FCAW welding of weld joints 040 & 041 located on BK004A4-019. Welders are identified as 040704 & 053316. ZPMC QC is identified as Mr. Mao Bin Bin. The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

TOWER BRACKETS

SMAW welding of weld joint 007B located on SD1-BRSA5-1. Welder is identified as 040614. ZPMC CWI is identified as Mrs. Yu Dong Ping. The welding variables recorded by QC appeared to comply with WPS-B-T-3213-Tc-U4b.

SMAW welding of weld joint 011B located on SD1-BRSA5-1. Welder is identified as 040610. ZPMC CWI is identified as Mrs. Yu Dong Ping. The welding variables recorded by QC appeared to comply with WPS-B-T-3213-Tc-U4b.

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



Summary of Conversations:

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