

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-017650**Date Inspected:** 24-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:** Zhu Zhong Hai**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 Manoj Prabhune 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:

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD

WELDING**Segment # 11BW ~ 11CW**

This QA inspector observed ZPMC qualified welding personnel identified as 040656 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SP168-001-054; located On Orthotropic Box Girder (OBG) Side Plate T-Rib Web to Web CJP Weld; ZPMC Quality Control (QC) is identified as Mr. Wang Zhu. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2213-B-U2-FCM-1.

Segment # 11BW ~ 11CW

This QA inspector observed ZPMC qualified welding personnel identified as 057333 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SP742-001-047; located On Orthotropic Box Girder (OBG) Side Plate T-Rib Web to Web CJP Weld; ZPMC Quality Control (QC) is identified as Mr. Wang Zhu. The welding variables

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recorded by QC appeared to comply with the Applicable WPS-B-P-2213-B-U2-FCM-1

Segment # 11BW ~ 11CW

This QA inspector observed ZPMC qualified welding personnel identified as 053486 perform Shielded Metal Arc Welding (SMAW), weld joint identified as BP106-001-030; located On Orthotropic Box Girder (OBG) Bottom Plate to Bottom Plate CJP Weld; ZPMC Quality Control (QC) is identified as Mr. Wang Zhu. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-B-U2-FCM-1.

Segment # 10AW/FL3 (I-Rib Hold Back Weld)

This QA inspector performed Magnetic Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT reports for this date. The members are identified as Orthotropic Box Girder (OBG) Components. The weld designations reviewed are as follows.

FB019-005-011, 012, 015 & 016.
FB023-008-009, 010, 015 & 016.
FB027-009-011, 012, 015 & 016
BP025-013-026, 027, 030, 031, 036, 037, 040 & 041.

Nondestructive testing (NDT) notification No. 07071

Segment # 10CW/FL3 (I-Rib Hold Back Weld)

This QA inspector performed Magnetic Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT reports for this date. The members are identified as Orthotropic Box Girder (OBG) Components. The weld designations reviewed are as follows.

FB019-006-011, 012, 015 & 016.
FB023-009-013, 014, 015 & 016,
FB027-010-013, 014, 015 & 016.
BP025-014-026, 027, 030, 031, 034, 035, 040 & 041.

Nondestructive testing (NDT) notification No. 07071

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

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

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

Inspected By:	Prabhune,Manoj	Quality Assurance Inspector
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Reviewed By:	Peterson,Art	QA Reviewer
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