

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-017842**Date Inspected:** 31-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:** Shi Lei**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 # 11AE ~ 11BE

This QA Inspector observed ZPMC qualified welding personnel identified as 053871 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG066A-012; located On Orthotropic Box Girder (OBG) Bottom Plate to Side Plate CJP Weld; The Critical Welding Repair Report (CWRR) was B-CWR2121. ZPMC Quality Control (QC) is identified as Mr. An Qing Xiang. The welding variables recorded by QC appeared to comply with applicable WPS-345-SMAW-4G (4F) FCM-1. See attached Photo for further details.

Segment # 11BE ~ 11CE

This QA Inspector observed ZPMC qualified welding personnel identified as 500363 perform Shielded Metal Arc Welding (SMAW), weld joint identified as OBE11-010; located On Orthotropic Box Girder (OBG) Edge Plate to

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Edge Plate CJP Weld; ZPMC Quality Control (QC) is identified as Mr. An Qing Xiang. The welding variables recorded by QC appeared to comply with applicable WPS-B-P-2214-TC-U4b-FCM-1. See attached Photo for further details.

Segment # 11BW

This QA inspector observed ZPMC qualified welding personnel identified as 044515 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SP381-001-050; located On Orthotropic Box Girder (OBG) T-Rib to T-Rib CJP Weld; ZPMC Quality Control (QC) is identified as Mr. Zhou Peng. The welding variables recorded by QC appeared to comply with applicable WPS-B-P2213-B-U2-FCM-1.

Segment # 11CW ~ 11DW

This QA Inspector observed ZPMC qualified welding personnel identified as 046709 perform Shielded Metal Arc Welding (SMAW), weld joint identified as OBE11A-001; located On Orthotropic Box Girder (OBG) Edge Plate to Edge Plate Transverse CJP Weld; ZPMC Quality Control (QC) is identified as Mr. Zhou Peng. The welding variables recorded by QC appeared to comply with applicable WPS-B-P-2214-B-U2-FCM-1.

Segment # 11CW ~ 11DW

This QA Inspector observed ZPMC qualified welding personnel identified as 053486 perform Shielded Metal Arc Welding (SMAW), weld joint identified as OBE11C-003; located On Orthotropic Box Girder (OBG) Bottom Plate to Bottom Plate Transverse CJP Weld; ZPMC Quality Control (QC) is identified as Mr. Zhou Peng. The welding variables recorded by QC appeared to comply with applicable WPS-B-P-2231-B-U2-F.

Segment # 11AE (T-Rib Hold Back Weld)

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

BP186-001-037, 038, 049, 050.

BP078-001-033, 034, 039, 040.

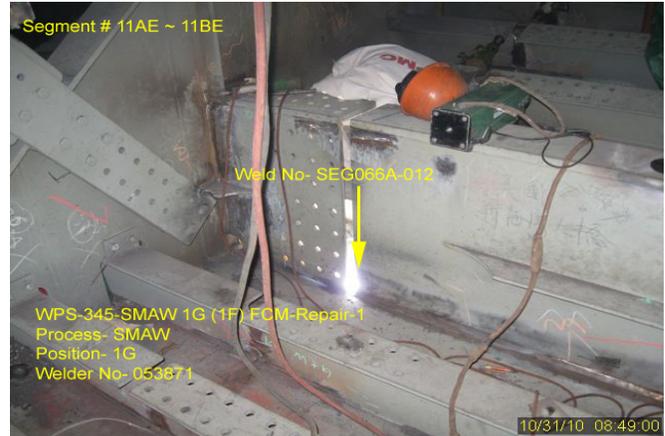
BP132-001-037, 038

Nondestructive testing (NDT) notification No. 07174

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

WELDING INSPECTION REPORT

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Summary of Conversations:

No significant conversation were reported on this date.

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

Reviewed By: Peterson,Art

QA Reviewer