

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-017874**Date Inspected:** 25-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:** Gong Wai**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 COMPONENT**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

In process Inspection

Bay#14

This QA Inspector observed the following work in progress:

FCAW in the 2G position for the OBG segment 13AE, weld No.VP3007-001-051. The welder is identified as #067520. ZPMC QC is identified as Mr.Zhang Guo Hui. The welding variables recorded by QC appear to comply with WPS-B-T-2232-Tc-U4B-F.

FCAW in the 2G position for the OBG segment 13AE, weld No.VP3007-001-011. The welder is identified as #066439. ZPMC QC is identified as Mr.Zhang Guo Hui. The welding variables recorded by QC appear to comply with WPS-B-T-2232-Tc-U4B-F.

FCAW in the 2G position for the OBG segment 13AE, weld No.VP3005-001-051. The welder is identified as #044795. ZPMC QC is identified as Mr.Zhang Guo Hui. The welding variables recorded by QC appear to comply with WPS-B-T-2232-Tc-U4B-F.

FCAW in the 2G position for the OBG segment 13AE, weld No.VP3005-001-025. The welder is identified as #066763. ZPMC QC is identified as Mr.Zhang Guo Hui. The welding variables recorded by QC appear to comply

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with WPS-B-T-2232-Tc-U4B-F.

FCAW in the 2G position for the OBG segment 13AE, weld No.VP3005-001-018. The welder is identified as #069089. ZPMC QC is identified as Mr.Zhang Guo Hui. The welding variables recorded by QC appear to comply with WPS-B-T-2232-Tc-U4B-F.

FCAW in the 2G position for the OBG segment 13AE, UT repair weld No.VP3002A-001-002. The welder is identified as #044774. ZPMC QC is identified as Mr.Zhang Guo Hui. The welding variables recorded by QC appear to comply with WPS-345-FCAW-2G(2F)-FCM-REPAIR.

FCAW in the 2F position for the OBG segment 14W, weld No. AP3018-001-053/054. The welder is identified as #201215. ZPMC QC is identified as Mr.Xia Chun Hui. The welding variables recorded by QC appear to comply with WPS-B-T-2232.

SMAW in the 1G position for the OBG segment 13AW,Base metal repair for bottom plate BP3074. The welder is identified as #044774. ZPMC QC is identified as Mr. Xia Chun Hui. The welding variables recorded by QC appear to comply with WPS-345-FCAW-2G(2F)-FCM-REPAIR.

SAW in the 1G position for the OBG segment 13AW, weld No.SEG3013-005. The welder is identified as #045270. ABF QA is identified as Mrs.Lv Yu . The welding variables recorded by QC appear to comply with WPS-B-T-2221-B-L2c-S-2.

SAW in the 1G position for the OBG segment 13CE to 13BE splice joint, weld No.OBE13C-001. The welder is identified as #044771. ZPMC QC is identified as Mr.Zhang Li .The welding variables recorded by QC appear to comply with WPS-B-T-223(2)1T-2.

Ultrasonic Testing (UT) for Bike Path

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as bike Path weld joints.

The welds designation reviewed are as follows:

BK004A1-004-008
BKSD1-004-005,006,019

During the Quality Assurance Ultrasonic Testing (UT) review of welds located on Orthotropic Box Girder (OBG) bike path, this Quality Assurance Inspector (QA) discovered the following issues One (1) longitudinal linear Class "A" rejectable indication measuring approximately 15mm in length. The indication dbfs rating is a +8. Material thickness is 16mm. The depth of the indication is approximately 12.2mm. The weld is identified as BKSD1-004-018 at Side plate to Side plate splice butt joint. The weld is Complete Joint Penetration (CJP) butt joint. The weld is designated as Non Seismic Performance Critical Material (Non SPCM). The indication is clearly marked on or near the weld. The Y distance for this indication is 90 mm from top cedge. The bike path is located

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at bay#19. The Notice of Witness Inspection (NWIT) No. is 006767. The indication is located within an area previously tested and accepted by ZPMC Quality Control (QC) personnel. As per the contract documents, ZPMC's QC personnel are required to perform hundred (100%) percent UT inspection of this weld.

This QA did not generate any incident report on this date.

Visual Inspection after Blast at 11CE

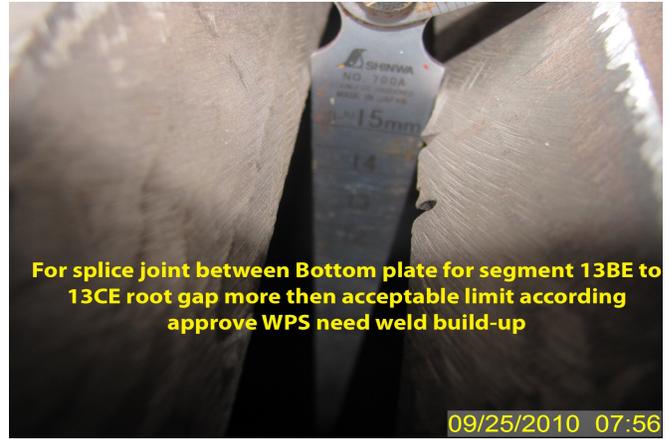
This Quality Assurance (QA) Inspector performed random visual inspection of OBG segment 11CE External side panel, edge panel , bottom panel and Deck panel surfaces after grit blasting in. Areas that marked for repair were recorded for future repair. Areas requiring additional grinding were marked by QA and repaired by ZPMC personnel.

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



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Summary of Conversations:

No relevant conversations

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 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Bera,Subhasis	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
