

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-018087**Date Inspected:** 05-Nov-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:** Qiu Wen, Yu Dong Ping**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 10, OBG BIKE PATH (NWIT # 07240)

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

BK004A3-027-002, 010

BK004A5-027-002, 008

BAY 11, OBG BIKE PATH (NWIT # 07242)

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

BK004ASD1-019-005, 006, 018, 021

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BK004A1-019-044

BK004ASD1-023-005, 006, 018, 021

BK004A1-023-044

BAY 11, OBG BIKE PATH (NWIT # 07247)

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

BK0045B1-004-043

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

BAY 11

FCAW welding of weld joints 001 & 002 located on GGC-MQ-1958-60.

Welder is identified as 042218. ZPMC QC is identified as Mr. Li Bin.

The welding variables recorded by QC appeared to comply with WPS-B-T-2231-Tc-U4b-F.

OBG BIKE PATH, CENTRE PLATE

SMAW welding of weld joint 044 located on BK005A8-004.

Welder is identified as 044541. ZPMC CWI is identified as Mr. Yu Dong Ping.

The welding variables recorded by QC appeared to comply with WPS-B-T-2113.

TOWER BRACKET

SMAW welding of weld joint 005A located on ND1-BRSA5-2.

Welder is identified as 040724. ZPMC QC is identified as Mr. Zhao Mao.

The welding variables recorded by QC appeared to comply with WPS-B-T-3212-Tc-U4b.

BAY 10

OBG BIKE PATH, BK004A-028

During random in process inspection this QA inspector observed that AB/F NDT personnel Mr. Tao Lin Yin was performing Magnetic Particle Testing on the temporary attachment removal area of base metal of deck plate of OBG bike path. During inspection AB/F NDT personnel found several of MT linear indications and ZPMC personnel excavated those locations upto 7~8mm deep to remove those MT indications. This issue has been discussed with ZPMC CWI Mr. Qiu Wen and ZPMC agreed to do the repair as per contract document and approved repair procedure.

OBG BIKE PATH, CENTRE PLATE

FCAW welding of weld joints 029 & 030 located on BK004A8-030.

Welder is identified as 053869. ZPMC QC is identified as Mr. Yu Zhi Lai.

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

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FCAW welding of weld joints 041 & 042 located on BK004A8-030.

Welder is identified as 057180. ZPMC QC is identified as Mr. Yu Zhi Lai.

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

OBG BIKE PATH, END PLATE

SMAW welding of weld joint 044 located on BK004A1-030.

Welders are identified as 057258, 056200 & 500363. ZPMC QC is identified as Mr. Yu Zhi Lai.

The welding variables recorded by QC appeared to comply with WPS-B-P-2214-B-U2.

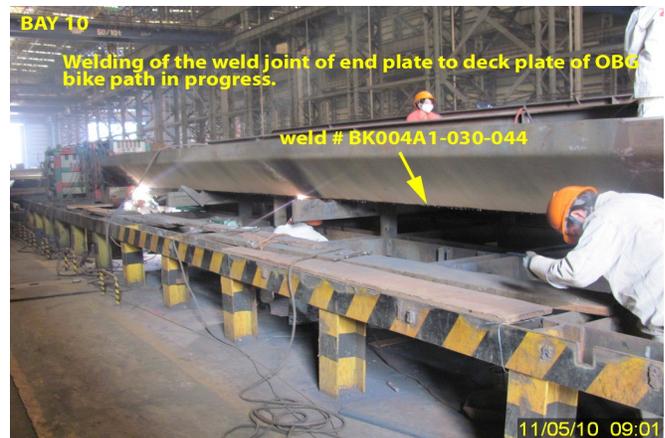
TOWER GRILLAGE COVER PLATE

SAW welding of weld joint 043A located on NSD1-TL5-3B-F.

Welder is identified as 040460. ZPMC QC is identified as Mr. Yuan Hui Gang.

The welding variables recorded by QC appeared to comply with WPS-B-T-3221-B-U3c-S-1.

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.

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/ Thomas Ho - 150002048250, who represents the Office of Structural Materials for your project.

Inspected By: Gaikwad, Umesh

Quality Assurance Inspector

Reviewed By: Clifford, William

QA Reviewer