

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-018094**Date Inspected:** 04-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:** Mr. 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:** Tower and Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Shailesh 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:

NDT

BAY 10

This QA Inspector performed randomly Visual Inspection and Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL- 6028 (MT) report for this date. The member is identified as OBG Bike Path. The weld designations reviewed are as follows.

BK004A1-029-044,

BK004A8-029-45, 47, 49, BK004A7-029-204, 206, 208, BK004A6-029-45, 47, 49

BK004A8-029-104, 106, 108, BK004A6-029-104, 106, 108, BK004A8-029-030, 032, 115, 042, 118

NDT Notification No-07226

BAY 10

This QA Inspector performed randomly Visual Inspection and Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL- 6028 (MT) report for this date. The member is identified as Tower lift 4 Facade. The weld designations

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reviewed are as follows.

SD1-SFSA4-63-2, 4, 6, 8

SD1-SA4-24-1, 3, 6, 7

NDT Notification No-07233

This QA Inspector observed the following work in progress:

BAY 10

OBG Bike path plate FCAW process:

This QA Inspector observed ZPMC qualified welding personnel identified as 040302, Perform Flux Core Arc Welding (FCAW) on OBG bike path plate. Joint identified as BK004A2-027-018. ZPMC QC Identified as Yu Zhi Lai. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2231-B-L1b-F.

This QA Inspector observed ZPMC qualified welding personnel identified as 053869, 057180, 040533, 052075, Perform Flux Core Arc Welding (FCAW) on OBG bike path plate. Joint identified as BK004A1-030-044, 043. ZPMC QC Identified as Yu Zhi Lai. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2231-B-U2-F, and WPS-B-T-2232-Tc-U4c-F.

This QA Inspector observed ZPMC qualified welding personnel identified as 053869, 040533, Perform Flux Core Arc Welding (FCAW) on OBG bike path plate. Joint identified as BK004A6-030-015, 016, 019, 020, 055, 056, 059, 060. ZPMC QC Identified as Yu Zhi Lai. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2133.

This QA Inspector observed ZPMC qualified welding personnel identified as 053869, 040533, Perform Flux Core Arc Welding (FCAW) on OBG bike path plate. Joint identified as BK004A8-030-015, 016, 019, 020. ZPMC QC Identified as Yu Zhi Lai. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2133.

This QA Inspector observed ZPMC qualified welding personnel identified as 057180, 052075, Perform Flux Core Arc Welding (FCAW) on OBG bike path plate. Joint identified as BK004A6-030-047, 048, 049, 050 and BK004A8-030-047, 048, 049, 050. ZPMC QC Identified as Yu Zhi Lai. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2133.

SMAW Process, Repair welding:

This QA Inspector observed ZPMC qualified welding personnel identified as 040320, 500363 Perform Shielded Metal Arc Welding (SMAW) on U Rib splice plate. Joint identified as GGL-MQ-1958-1~12-1, 2. ZPMC QC Identified as Sun Tian Liang with temporary repair report WRR-T-WR 16519~16528. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-1G (1F) –Repair. For more information see below attached picture number 1.

BAY 11

SMAW Process, Repair welding:

This QA Inspector observed ZPMC qualified welding personnel identified as 044541, Perform Shielded Metal Arc

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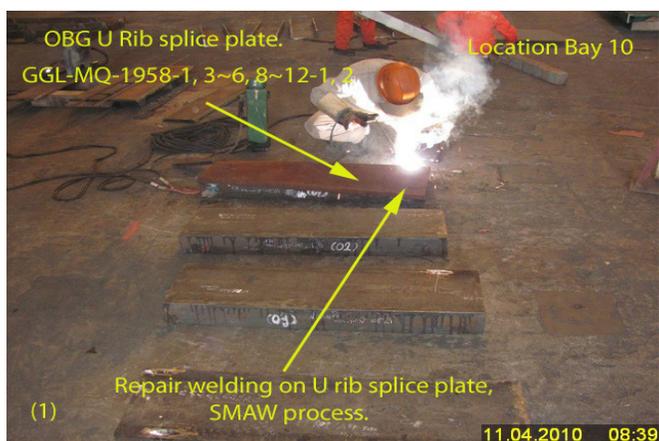
Welding (SMAW) on OBG bike path. Joint identified as BK005A1-003-043. ZPMC QC Identified as Zhao Mao Mao with temporary repair report. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-2G (2F) –Repair.

This QA Inspector observed ZPMC qualified welding personnel identified as 040704, 040723, 056640, 042218 Perform Flux Core Arc Welding (FCAW) on U Rib splice plate. Joint identified as GGL-MQ-1958-69~89-1, 2. ZPMC QC Identified as Libin. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2231-Tc-U4b-F.

Tower SMAW process:

This QA Inspector observed ZPMC qualified welding personnel identified as 040724, Perform Shielded Metal Arc Welding (SMAW) on Tower Bracket Stiffener lift 5. Joint identified as ND1-BRSA5-2-19B. ZPMC QC Identified as Libin. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-3213-Tc-U5b.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the 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 Thomas Ho phone : 150002048250, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Shailesh	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
