

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-018372**Date Inspected:** 26-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, Geng Wei**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**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 14, OBG (NWIT # 7507)

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

SEG3014K-101

SEG3014L-195

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

Bay 14

VERTICAL PLATE REPAIR

SMAW welding of weld joint 002 located on VP3008-001.

Welder is identified as 044772. ZPMC QC is identified as Mr. Xie Meng Feng.

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The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G(2F)-FCM-REPAIR.

FCAW welding of weld joint 032 located on VP3008-001.

Welder is identified as 062782. ZPMC QC is identified as Mr. Xie Meng Feng.

The welding variables recorded by QC appeared to comply with WPS-345-FCAW-2G(2F)-FCM-REPAIR-1.

FCAW welding of weld joint 101 located on SEG3013U (B-WR17699, PP118~118.5)

Welder is identified as 045240. ZPMC QC is identified as Mr. Sun Tian Liang.

The welding variables recorded by QC appeared to comply with WPS-345-FCAW-2G(2F)-FCM-REPAIR-1.

FCAW welding of weld joint 104 located on SEG3013P (FB3176 TO LD3034 AT PP 118)

Welder is identified as 045175. ZPMC QC is identified as Mr. Sun Tian Liang.

The welding variables recorded by QC appeared to comply with WPS-B-T-2233-Tc-U4b-F.

FCAW welding of weld joint 175 located on SEG3013B (FB3200 TO LD3034 AT PP 120)

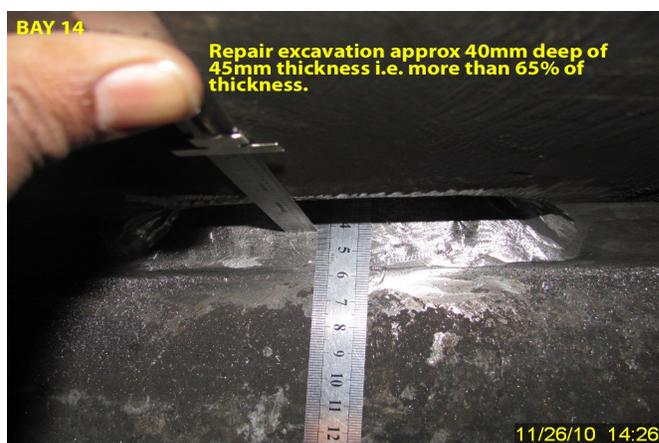
Welder is identified as 201215. ZPMC QC is identified as Mr. Sun Tian Liang.

The welding variables recorded by QC appeared to comply with WPS-B-T-2133.

During random in process inspection this QA inspector observed that ZPMC personnel performing welding of Complete Joint Penetration (CJP) weld joints without run on/off tab. The weld joints joining stiffener of side plate to floor beam (FB3223) at panel point (PP 122.5). The welder is identified as 037840. This issue has been discussed with ZPMC CWI Mr. Qiu Wen. ZPMC CWI Mr. Qiu Wen informed this QA that this issue would be corrected in a manner compliant with the contract documents.

During random in process inspection this QA inspector observed that the weld joint SEG3013F-001 of segment 13AW at panel point PP119+1500 was excavated more than 65% of thickness at two locations. Attached photograph provide additional information.

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



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

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