

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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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-018398**Date Inspected:** 23-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:** Xu Xian 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:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this date Caltrans Office of Structural Material (OSM) Quality Assurance (QA) Inspector, D.Sukanthan was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

OBG # Crossbeam CB19

This QA observed ZPMC qualified welding personnel identified as 049769 perform Shielded Metal Arc Welding (SMAW) Process on weld joint CB3003A-019-002. ZPMC Quality Control Personnel (QC) identified as Mr. Xu hai yang was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2214-TC-U4b-FCM.

This QA observed ZPMC qualified welding personnel identified as 048659 perform Shielded Metal Arc Welding (SMAW) Process on weld joint CB3003A-019-002. ZPMC Quality Control Personnel (QC) identified as Mr. Xu hai yang was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2214-TC-U4b-FCM.

This QA observed ZPMC qualified welding personnel identified as 051246 perform Flux Cored Arc Welding (FCAW) Process on weld joint CB3003K-002-043,044. ZPMC Quality Control Personnel (QC) identified as Mr. Xu hai yang was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132.

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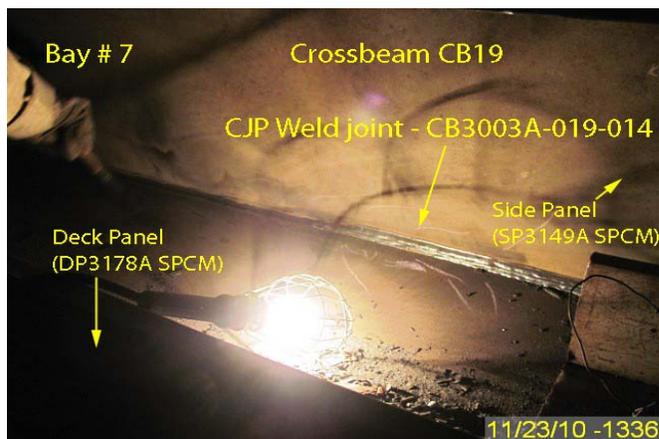
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This QA observed ZPMC qualified welding personnel identified as 068924 perform Flux Cored Arc Welding (FCAW) Process on weld joint DP3180-001-018. ZPMC Quality Control Personnel (QC) identified as Mr. Xu hai yang was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2233-B-U2-F.

This QA observed ZPMC qualified welding personnel identified as 068924 perform Flux Cored Arc Welding (FCAW) Process on weld joint DP3180-001-017. ZPMC Quality Control Personnel (QC) identified as Mr. Xu hai yang was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2233-B-U2-F.

During Caltrans QA in process observations of the fabrication of Crossbeam CB19, this QA discovered the following issues. ZPMC welding personnel did not appear to be following the NEW WELD PROCEDURE (Rager / McQuaid). The weld is identified as CB3003A-019-014. The welding process used was Flux Cored Arc Welding (FCAW). The area was being preheated using electric strip heaters. The weld is a complete joint penetration weld (CJP) joining Side Panel SP3149A SPCM to Deck Panel DP3178A SPCM. The weld is Seismic Performance Critical Member (SPCM). For more information please refer incident report generated as on date.

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



Summary of Conversations:

As mention above

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 150-00422372, who represents the Office of Structural Materials for your project.

Inspected By: Sukanthan,Dhanasingh

Quality Assurance Inspector

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Reviewed By: Hall, Steven

QA Reviewer