

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-018727**Date Inspected:** 05-Dec-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. Zhu Zhong Hai.**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 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 OBG TRIAL ASSEMBLY:

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 Edge panel to side panel back hold area 11DE to 11EE. The weld designations reviewed are as follows.

SEG072A-046

CA093-001

NDT Notification No-07637

This QA Inspector observed the following work in progress:

OBG TRIAL ASSEMBLY

This QA Inspector observed ZPMC qualified welding personnel identified as 067765 Perform Shielded Metal Arc Welding (SMAW) on OBG segment 12AE + 11EE bottom plate to side plate hold back area, location E4. Joint identified as SEG3001A-011. ZPMC QC Identified as Zhang Qiang. The welding parameters as measured using

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QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2214-B-U2.

This QA Inspector observed ZPMC qualified welding personnel identified as 066413 Perform Shielded Metal Arc Welding (SMAW) on Pad eye of OBG segment 12AE Panel point 104. Joint identified as SSD10A-PP104-263. ZPMC QC Identified as Zhang Qiang. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2113 and WPS-B-P-2114.

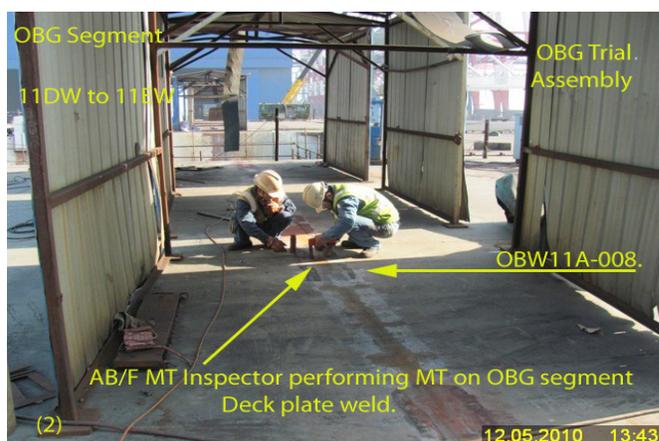
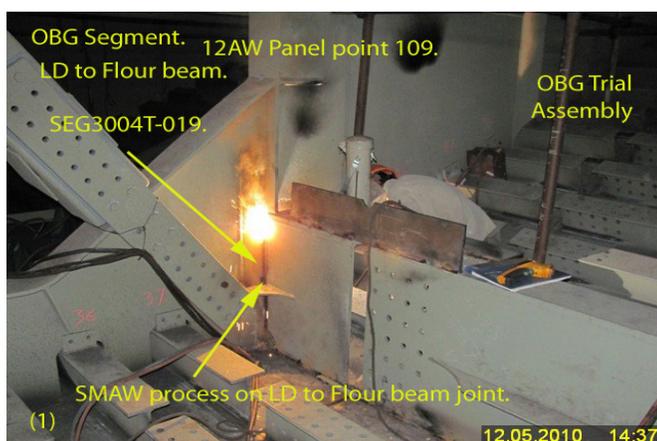
This QA Inspector observed ZPMC qualified welding personnel identified as 046709 Perform Shielded Metal Arc Welding (SMAW) on OBG segment 12AW Panel point 109 cross beam side, longitudinal diaphragm to floor beam. Joint identified as SEG3004T-019. ZPMC CWI Identified as Zhu Zhong Hai. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2213-Tc-U4b-FCM-1. For more information see below attached picture number 1.

This QA Inspector observed ZPMC qualified welding personnel identified as 044504 Perform Shielded Metal Arc Welding (SMAW) on OBG segment 11AE to 11BE Bike path side, Deck plate to Edge plate. Joint identified as OBE11D-088, 089 and 90. ZPMC CWI Identified as An Qian Xian. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2114-FCM-1 and WPS-B-P-2213-B-U2-FCM-1.

Magnetic Particle Testing:

This QA Inspector observed AB/F Magnetic Particle Testing Inspector, performed MT on OBG segment 11DW to 11EW deck plate weld. Joint identified as OBW-11A-008. For more information see below attached picture number 2.

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

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

Inspected By:	Gaikwad,Shailesh	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
