

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-019344**Date Inspected:** 15-Jan-2011**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
Inspected CWI report: Yes No N/A
Electrode to specification: Yes No N/A
Qualified Welders: Yes No N/A
Approved Drawings: Yes No N/A

CWI Present: Yes No
Rod Oven in Use: Yes No N/A
Weld Procedures Followed: Yes No N/A
Verified Joint Fit-up: 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.

OBG # BAY 8

This QA inspector received ZPMC Non Destructive Testing (NDT) notification 08178 to perform Magnetic particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated a Magnetic particle Test report for this date. The member is identified as Bike Path. The weld tested is identified as follows:

(BK004A6-059-072,073)
(BK004A8-059-073)
(BK004A2-059-006,007,011,012)
(BK004A4-059-058,059,074,073)
(BK004A4-059-056,057,071,072)
(BK004A5-059-054,055,074,075)
(BK004A5-059-116,117,119,120,129,130)
(BK004A5-059-118,121,128,007,009,002,003)
(BK004A6-059-086,088,090,092,096,098,100,102)
(BK004A8-059-086,088,090,092,096,098,100,102)

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

This QA Inspector randomly observed the following work in progress:

OBG # SEGMENT 12BE 12CE

This QA observed ZPMC qualified welding personnel identified as 044515 perform Shielded Metal Arc Welding (SMAW) Process on weld joint OBE12A-001. ZPMC Quality Control Personnel (QC) identified as Mr. Li 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-B-U2-FCM-1.

This QA observed ZPMC qualified welding personnel identified as 040320 perform Shielded Metal Arc Welding (SMAW) Process on weld joint OBE12A-002. ZPMC Quality Control Personnel (QC) identified as Mr. Li 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-B-U2-FCM-1.

This QA observed ZPMC qualified welding personnel identified as 050289 perform Shielded Metal Arc Welding (SMAW) Process on weld joint OBE12A-010. ZPMC Quality Control Personnel (QC) identified as Mr. Li 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-2213-B-U2-FCM-1.

OBG # SEGMENT 12BW 12CW

This QA observed ZPMC qualified welding personnel identified as 041713 perform Shielded Metal Arc Welding (SMAW) Process on weld joint OBE12C-001. ZPMC Quality Control Personnel (QC) identified as Mr. Zhu zhong hai 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-B-U2-FCM-1.

This QA observed ZPMC qualified welding personnel identified as 044551 perform Shielded Metal Arc Welding (SMAW) Process on weld joint OBE12C-001. ZPMC Quality Control Personnel (QC) identified as Mr. Zhu zhong hai 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-B-U2-FCM-1.

OBG # SEGMENT 12CW

This QA observed ZPMC qualified welding personnel identified as 046704 perform Shielded Metal Arc Welding (SMAW) Process on weld joint SEG3006A-011. ZPMC Quality Control Personnel (QC) identified as Mr. Zhoo peng 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-2212-B-U2-FCM-1.

OBG # SEGMENT 12AW 12BW

This QA observed that ABF personnel perform MT on transverse splice weld joint OBW12B-001. See attached pictures.

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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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

Reviewed By: Hall,Steven

QA Reviewer
