

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-019686**Date Inspected:** 17-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:** Mr. Xu Le Feng.**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 11:

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 5 top plate with skin. The weld designations reviewed are as follows.

GTTHAS1-1-E, 2-E, 3-E

GTTHAS1-1-S, 2-S, 3-S

GTTHAS1-1-W, 2-W, 3-W

GTTHAS1-1-N, 2-N, 3-N

NDT Notification No-08209

BAY 10

This QA Inspector performed randomly Visual Inspection and Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-

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6027 (UT) report for this date. The member is identified as OBG Traveler Rail. The weld designations reviewed are as follows.

37TR2-001, 012, 36TR1-001, 012
31TR3-036, 31TR3-033, 26TR1-014, 26TR1-001, 012
26TR2-031, 26TR2-017, 31TR1-014, 31TR1-001,
29TR1-001, 012, 28TR1-001, 002

NDT Notification No-08199

BAY 10

This QA Inspector performed randomly Visual Inspection and Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6027 (UT) report for this date. The member is identified as OBG Traveler Rail. The weld designations reviewed are as follows.

31TR2-017, 028
27TR1-001, 012

NDT Notification No-08206

BAY 11

This QA Inspector performed randomly Visual Inspection and Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6027 (UT) report for this date. The member is identified as Tower. The weld designations reviewed are as follows.

ESD1-TPSA6-2-19A/B
WSD1-TPSA6-3-20A/B

NDT Notification No-08207

This QA Inspector observed the following work in progress:

BAY 11:

SMAW Process:

This QA Inspector observed ZPMC qualified welding personnel identified as 046769, Perform Shielded Metal Arc Welding (SMAW) on Tower lift 5 Top Plate to skin. Joint identified as GTTHAS1-1-W, 2-W, 3-W and GTTHAS1-1-S, 2-S, 3-S. ZPMC QC Identified as Xu Le Feng. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-4212-Tc-U4b-3. For more information see attached picture number 1.

FCAW Process:

This QA Inspector observed ZPMC qualified welding personnel identified as 205649, Perform Flux Core Arc

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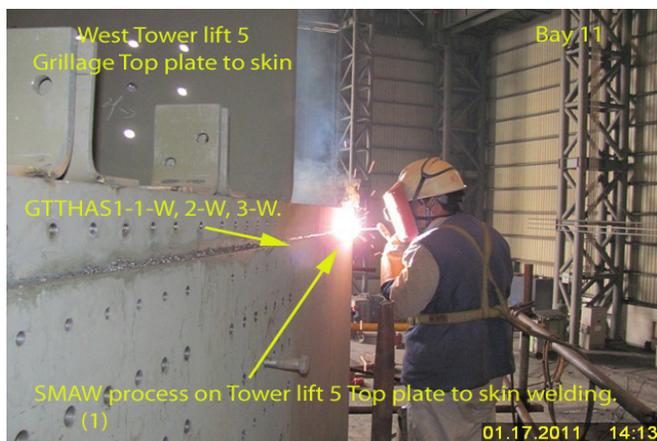
Welding (FCAW) on OBG Bike Path. Joint identified as BK004A1-057-008, 038. ZPMC QC Identified as Shao Hai Lang. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2132-ESAB.

BAY 10:

Magnetic Particle Testing:

This QA Inspector observed ZPMC Magnetic Particle Testing Inspector, performed MT on OBG Bike path bottom cover plate welds. Joint identified as BK004A2-032-002, 008, 013, 021. 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

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: 150002048250, who represents the Office of Structural Materials for your project.

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