

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-020233**Date Inspected:** 24-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:** 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

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 Segment 11DW. The weld designations reviewed are as follows.

BP025-001-028, 029

FB019-009-001, 002, 011, 012, 017, 018

SEG071E-095, 096, 122, 123

NDT Notification No-07910

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 Segment 11DE. The weld designations

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

reviewed are as follows.

BP026-016-026, 027

FB020-009-001, 002, 011,012, 017, 018

FB024-011-001,002, 011, 012, 017, 018

SEG072D-176, 177

SEG072E-034, 035

NDT Notification No-07907

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 Segment 11EE and 11DW. The weld designations reviewed are as follows.

OBE11E-139, 143, 147

FB019-009-128

SSD10A-PP104-170

NDT Notification No-07912

This QA Inspector observed the following work in progress:

OBG TRIAL ASSEMBLY

OBG Segment 12AE~12BE Repair Welding

This QA Inspector observed ZPMC qualified welding personnel identified as 040378, Perform Shielded Metal Arc Welding (SMAW) on OBG segment 12AE to 12 BE Side plate to Side plate bike path side base metal repair. ZPMC CWI Identified as An Qing Xiang with Critical Welding repair report CWR-B-CWR2126. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-4G (4F)-FCM-Repair-1. For more information see below attached picture number 1.

OBG Segment 12AE~12BE

This QA Inspector observed ZPMC qualified welding personnel identified as 050289 Perform Shielded Metal Arc Welding (SMAW) on OBG segment 12AE~12BE Deck plate I Rib joint Cross beam side. Joint identified as DP3001-001-026. ZPMC QC Identified as Liu Hua Jie. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-3213-B-U3b. For more information see below attached picture number 2.

OBG Segment 12AE~12BE

This QA Inspector observed ZPMC qualified welding personnel identified as 053871 Perform Shielded Metal Arc Welding (SMAW) on OBG segment 12AE~12BE Deck plate I Rib joint Bike path side. Joint identified as DP3011-001-042. ZPMC QC Identified as Liu Hua Jie. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-3213-B-U3b.

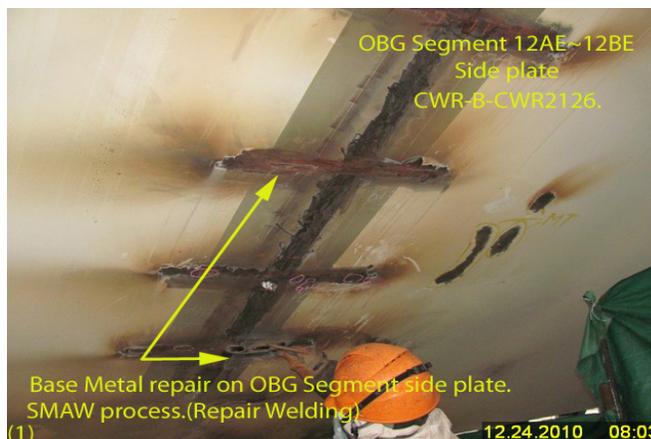
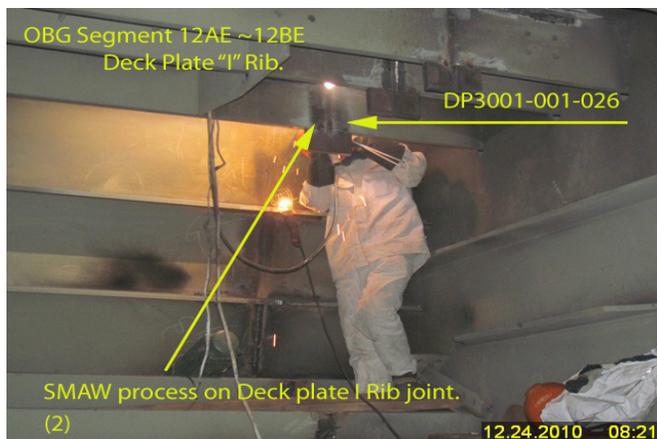
OBG Segment 12AE~12BE

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

This QA Inspector observed ZPMC qualified welding personnel identified as 047353 Perform Flux Core Arc Welding (FCAW) on OBG segment 12AE~12BE Bottom plate to Side plate joint from inside. Joint identified as OBE12B-001. ZPMC QC Identified as Liu Hua Jie. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2231T-ESAB.

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

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