

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-020235**Date Inspected:** 26-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 Segment 11EW Angle assembly plate. The weld designations reviewed are as follows.

SSD029-PP107.5-001, 002

SSD029-PP108.5-001

NDT Notification No-07935

This QA Inspector observed the following work in progress:

OBG TRIAL ASSEMBLY

OBG Segment 12AW~12BW

This QA Inspector observed ZPMC qualified welding personnel identified as 041713, Perform Shielded Metal Arc

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Welding (SMAW) on OBG segment 12AW to 12 BW Deck plate I Rib Cross beam side. Joint identified as DP3039-001-024, 026. ZPMC QC Identified as Zhau Peng. 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 1.

OBG Segment 12AW~12BW

This QA Inspector observed ZPMC qualified welding personnel identified as 057333, Perform Shielded Metal Arc Welding (SMAW) on OBG segment 12AW to 12 BW Deck plate I Rib Counter weight side. Joint identified as DP3049-001-040, 042. ZPMC QC Identified as Zhou Peng. 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 12AW~12BW Repair Welding

This QA Inspector observed ZPMC qualified welding personnel identified as 040656, 044551, 046709 Perform Shielded Metal Arc Welding (SMAW) on OBG segment 12AW~12BW Deck plate to Deck plate from inside. Joint identified as OBW12-001. ZPMC QC Identified as Zhou Peng with temporary welding repair report WRR-B-WR17901. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2214-B-U2-FCM-1. For more information see below attached picture number 2.

OBG Segment 12AW~12BW

This QA Inspector observed ZPMC qualified welding personnel identified as 046704 Perform Shielded Metal Arc Welding (SMAW) on OBG segment 12AW +12BW Longitudinal Diaphragm to Bottom plate. Joint identified as SEG3005M-090. ZPMC QC Identified as Zhou Peng. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2212-Tc-U4b -FCM-1.

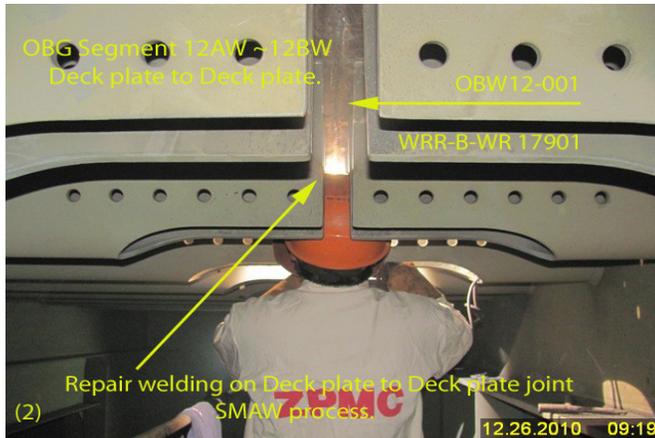
OBG Segment 12AE Repair Welding

This QA Inspector observed ZPMC qualified welding personnel identified as 040320, Perform Shielded Metal Arc Welding (SMAW) on OBG segment 12AE Bottom plate to Side plate joint Counter weight side. Joint identified as SEG3001A-015. ZPMC CWI Identified as An Qing Xiang with Critical Welding repair report CWR-B-CWR2457 Rev 1. 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 3.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



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
Reviewed By:	Carreon,Albert	QA Reviewer
