

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 #: xx.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021095**Date Inspected:** 10-Feb-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. Shao Jian Yuan.**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:** OBG Trial Assembly & bay14**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Raghavendra Reddy 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:

This QA Inspector observed the following work in progress:

BAY # 14

SMAW welding of Weld Joint DP3174-001-018(14W deck panel diaphragm), And Welder is identified as 037780; ZPMC Quality Control (QC) is identified as Mr. Shao Jian Yuan. The welding variables appeared to comply with the Applicable WPS-B-P-2212-TC-U4b-FCM.

SMAW welding of Weld Joint DP3173-001-018(14W deck panel diaphragm), And Welder is identified as 037779; ZPMC Quality Control (QC) is identified as Mr. Shao Jian Yuan. The welding variables appeared to comply with the Applicable WPS-B-P-2212-TC-U4b-FCM.

FCAW welding of Weld Joint DP3174-001-380(14West deck panel diaphragm), And Welder is identified as 048696; ZPMC Quality Control (QC) is identified as Mr. Shao Jian Yuan. The welding variables appeared to comply with the Applicable WPS-B-T-2132-ESAB.

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FCAW welding of Weld Joint DP3173-001-413(14 West), And Welder is identified as 048433; ZPMC Quality Control (QC) is identified as Mr. Shao Jian Yuan. The welding variables appeared to comply with the Applicable WPS-B-T-2132-ESAB.

SMAW welding of Weld Joint SEG3020BC-012(14W, Floor beam to Stiffner)), And Welder is identified as 069683; ZPMC Quality Control (QC) is identified as Mr. Xiao Jun Peng. The welding variables appeared to comply with the Applicable WPS-B-P-2114-FCM-1.

SMAW welding of Weld Joint SEG3020BC-026(14W, Floor beam to Stiffner)), And Welder is identified as 067764; ZPMC Quality Control (QC) is identified as Mr. Xiao Jun Peng. The welding variables appeared to comply with the Applicable WPS-B-P-2114-FCM-1.

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 08324.

Ultrasonic Testing (UT)

This QA Inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a UT report for this date. The member is identified as OBG Segment 14 East welds. The weld designations reviewed are as follows.

1. SEG3007Q-001-181, 190,197,196,193,202,199,208,205,214,211,230
2. SEG3007Q-001-232, 240,237,245,242,250,247,255,252,260,257,265
3. SEG3007Q-001-262, 270,267,275,312,310

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 (15000422372), who represents the Office of Structural Materials for your project.

Inspected By:	Tharikoppada,Reddy	Quality Assurance Inspector
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Reviewed By:	Miller,Mark	QA Reviewer
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