

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-021106**Date Inspected:** 22-Aug-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 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:

SEGMENT # 10W:

Flux Cored Arc Welding (FCAW) of weld joint SP165-001-005~012(10AW+10BW, CB Side), Welder is identified as 202384. ZPMC Quality Control (QC) is identified as Mr. Zhu Peng. The welding variables appeared to comply with the Applicable WPS: WPS-B-T-2132.

Flux Cored Arc Welding FCAW of weld joint SP164-001-025~036(10AW+10BW, CB Side), Welder is identified as 040704. ZPMC Quality Control (QC) is identified as Mr. Zhu Yuan Yuan. The welding variables appeared to comply with the Applicable WPS: WPS-B-T-2132.

Flux Cored Arc Welding FCAW of weld joint BP048-001-043~054(10AW), Welder is identified as 202384. ZPMC Quality Control (QC) is identified as Mr. Zhu Yuan Yuan. The welding variables appeared to comply with the Applicable WPS: WPS-B-T-2132.

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Flux Cored Arc Welding FCAW of weld joint

SP777-001-001~012/BP103-001-031~042/BP049-001-031~042(10AW), Welder is identified as 040704/202384/040609. ZPMC Quality Control (QC) is identified as Mr. Zhu Yuan Yuan. The welding variables appeared to comply with the Applicable WPS: WPS-B-T-2132.

Shielded Metal Arc Welding (SMAW) welding of welds joint OBW10B-004/005(10AW+10BW), Welder is identified as 067752,067829. ZPMC Quality Control (QC) is identified as Mr. Zhu Zhong Hai. The welding variables appeared to comply with the Applicable WPS-B-P-2214-B-U2-FCM-1.

Ultrasonic Testing (UT)

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 06456

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 CB11&9BW tagging weld. The weld designations reviewed are as follows.

1. I-Rib on CB#11 (B-WR-14630) Miss Drilled hole area.
2. I-Rib on CB#11 (B-WR-14631) Miss Drilled hole area.
3. I-Rib on 9BW FL3 (B-WR-14630) Miss Drilled hole area.
4. I-Rib on 9BW FL3 (B-WR-14631) Miss Drilled hole area.

Magnetic Particle Testing (MT)

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 06461

Magnetic Particle Testing (MT):

This QA Inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a MT report for this date. The member is identified as Bike Path tagging weld. The weld designations reviewed are as follows.

1. BK001-043-025

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

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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 Michael Ng (15921845703), who represents the Office of Structural Materials for your project.

Inspected By: Tharikoppada,Reddy

Quality Assurance Inspector

Reviewed By: Miller,Mark

QA Reviewer