

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-021583**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. 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:** 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:

This QA Inspector observed the following work in progress:

Magnetic Particle Testing:

This QA Inspector observed AB/F Magnetic Particle Testing Inspector, performing MT on OBG Bike path Stringer plate. Joint identified as BK010A2-001, (30A). For more information see attached picture number 1.

BAY 14 Welding:

Segment 13BW, FCAW Process:

This QA Inspector observed ZPMC qualified welding personnel identified as 067888 perform Flux Cored Arc Welding (FCAW), weld joint identified as SEG3014D-350; located On Orthotropic Box Girder (OBG) Deck Panel Diaphragm to Upper Floor Beam Flange CJP Weld; ABF Quality Assurance (QA) is identified as Mr. Cao Hai Zhou. This QA Inspector observed a welding current of approximately 301 amps and 25.8 volts and the base material appears to have been being preheated by an electrical heating elements prior to welding. ABF Quality Assurance (QA) Mr. Cao Hai Zhou was onsite monitoring the welding variables. The welding variables recorded

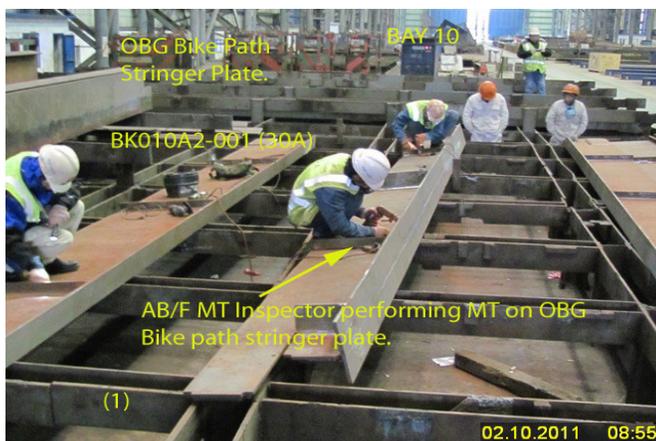
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by QA appeared to comply with applicable WPS-B-T-2232-ESAB.

This QA Inspector observed ZPMC qualified welding personnel identified as 066695 perform Flux Cored Arc Welding (FCAW), weld joint identified as SEG3014B-021; located On Orthotropic Box Girder (OBG) Deck Panel Diaphragm to Upper Floor Beam Flange CJP Weld; ABF Quality Assurance (QA) is identified as Mr. Cao Hai Zhou. This QA Inspector observed a welding current of approximately 288 amps and 26.4 volts and the base material appears to have been being preheated by an electrical heating elements prior to welding. ABF Quality Assurance (QA) Mr. Cao Hai Zhou was onsite monitoring the welding variables. The welding variables recorded by QA appeared to comply with applicable WPS-B-T-2232-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 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
