

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-021597**Date Inspected:** 24-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:** 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

BAY 10:

This QA Inspector performed randomly Visual Inspection of the area previously tested and accepted by ZPMC Quality Control personnel. The member is identified as OBG Bike Path. The weld designations reviewed are as follows.

BK007-001

NDT Notification No-08379

BAY 10:

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 Bike Path. The weld designations reviewed are as follows.

BK010A3-001-047, 053, 061

BK010A2-001-031, 049, 061, 083, 093

BK010A7-001-016, 022, 147, 075, 081, 018

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BK010A6-001-074, 075

BK010A2-001-035, 053, 065, 087, 095

BK010A7-001-024, 153, 084

NDT Notification No-08383

This QA Inspector observed the following work in progress:

BAY 10, FCAW Process:

This QA Inspector observed ZPMC qualified welding personnel identified as 052075, 053869, 040302, 040533 Perform Flux Core Arc Welding (FCAW) on OBG Bike path deck plate to stringer plate. Joint identified as BK009A5-001-049, 050, 116, 117, 112, 115. ZPMC QC Identified as Lijun. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2132-ESAB and WPS-B-T-2133-ESAB.

Gouging:

This QA Inspector observed ZPMC personnel gouge out (cut) the weld on OBG Cantilever Box, due to distortion. Joint identified as BK15A-001-001~010. ZPMC QC Identified as Yin Chung Fang.

SMAW Process:

This QA Inspector observed ZPMC qualified welding personnel identified as 057258, 052493, 052930, 0500363, 044511, Perform Shielded Metal Arc Welding (SMAW) on OBG Traveler Rail. Joint identified as 2OTR2-039-009, 013, 015, 017. ZPMC QC Identified as Jiang Xian Bo. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2211-Tc-U5b. For more information see attached picture number 1.

This QA Inspector observed ZPMC qualified welding personnel identified as 053829, Perform Shielded Metal Arc Welding (SMAW) on OBG Bike Path. Joint identified as BK008A4-032, 033, 047, 048. ZPMC QC Identified as Li Peng Fei. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2113. For more information see attached picture number 2.

BAY 11, SMAW Process:

This QA Inspector observed ZPMC qualified welding personnel identified as 044541, Perform Shielded Metal Arc Welding (SMAW) on OBG Bike Path stringer plate. Joint identified as BK011A2-001-022, 023, 024, 025 and BK012A2-001-022, 023, 024, 025. ZPMC CWI Identified as Yu Dong Ping. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2211-B-U2b.

Green Tagging

This QA inspector performed Visual Inspection for Green Tagging which were previously tested and accepted by ZPMC Quality Control personnel Mr. Guo Yan Fei and ABF QA personnel Mr. Zhao Xian He. The members are identified as OBG Bike Path BK007A-001. The green Tag number is identified as # 13785.

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

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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