

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-021914**Date Inspected:** 25-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:** Qiu Wen**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 Components**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector, Anand Upadhye was present during the times noted above for observations relative to the work being performed.

NDT

BAY 14

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted notification number 08393.

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 MT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows:

SEG3007AE- 088, 090, 092, 094, 096.

WELDING

This QA Inspector observed the following work in progress:

BAY 14

This QA Inspector observed ZPMC qualified welding personnel identified as 066002 perform welding by Shielded

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Metal Arc Welding (SMAW), on Floor beam to Vertical plate weld of OBG Segment 13AW. Weld joint is identified as SEG3013B-262. ZPMC Quality Control (QC) Inspector identified as Liu Feng was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2213-Tc-U4b-FCM-1. See attached picture.

This QA Inspector observed ZPMC qualified welding personnel identified as 037996 perform welding by Shielded Metal Arc Welding (SMAW), on Floor beam to corner assembly diaphragm weld of OBG Segment 13CW. Weld joint is identified as SEG3015C-146. ZPMC Quality Control (QC) Inspector identified as Zhang Lin was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2213-Tc-U4b-FCM-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 067765 perform welding by Shielded Metal Arc Welding (SMAW), on Corner assembly diaphragm to Deck panel diaphragm weld of OBG Segment 13CW. Weld joint is identified as SEG3015C-013. ZPMC Quality Control (QC) Inspector identified as Zhang Lin was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2213-Tc-U4b-FCM-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 045143 perform welding by Flux Cored Arc Welding (FCAW), on Deck panel diaphragm to Floor beam flange weld of OBG Segment 13AW. Weld joint is identified as SEG3013F-025. ZPMC Quality Control (QC) Inspector identified as Liu Fang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-T-2232-ESAB.

This QA Inspector observed ZPMC qualified welding personnel identified as 048433 perform welding by Flux Cored Arc Welding (FCAW), on Deck panel diaphragm to Floor beam flange weld of OBG Segment 13AW. Weld joint is identified as SEG3013K-024. ZPMC Quality Control (QC) Inspector identified as Liu Fang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-T-2232-ESAB.

This QA Inspector observed ZPMC qualified welding personnel identified as 045143 perform welding by Flux Cored Arc Welding (FCAW), on Deck panel diaphragm to Floor beam flange weld of OBG Segment 13AW. Weld joint is identified as SEG3013M-024. ZPMC Quality Control (QC) Inspector identified as Liu Fang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-T-2232-ESAB.

This QA Inspector observed ZPMC qualified welding personnel identified as 066239 perform welding by Flux Cored Arc Welding (FCAW), on Floor beam to Floor beam weld of OBG Segment 14W. Weld joint is identified as SEG3020R-020. ZPMC Quality Control (QC) Inspector identified as Zhu Lin was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-T-2232-ESAB. See attached picture.

This QA Inspector observed ZPMC qualified welding personnel identified as 069896 perform welding by Shielded Metal Arc Welding (SMAW), on Floor beam to Anchor plate weld of OBG Segment 14W. Weld joint is identified as SEG3020R-023, 024, 025. ZPMC Quality Control (QC) Inspector identified as Sun Tian Liang was present to

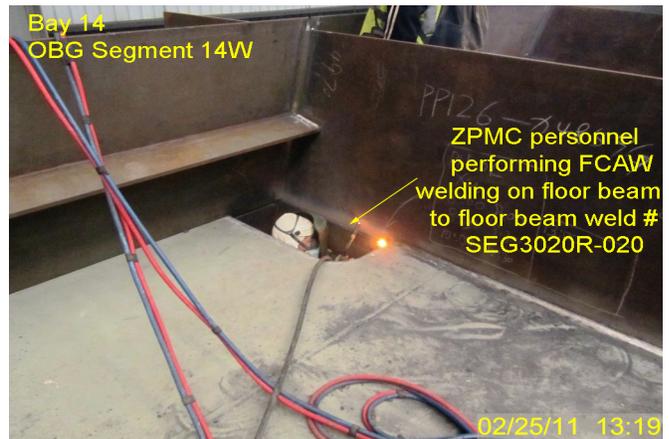
WELDING INSPECTION REPORT

(Continued Page 3 of 3)

monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2114-FCM.

This QA Inspector observed ZPMC qualified welding personnel identified as 067829 perform welding by Shielded Metal Arc Welding (SMAW), on Floor beam to Anchor plate weld of OBG Segment 14W. Weld joint is identified as SEG3020R-028, 029, 030. ZPMC Quality Control (QC) Inspector identified as Sun Tian Liang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2114-FCM.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No significant conversations were reported on this date.

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

Inspected By: Upadhye, Anand

Quality Assurance Inspector

Reviewed By: Clifford, William

QA Reviewer