

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-022305**Date Inspected:** 21-Mar-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:** Li Yang**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 date Caltrans Office of Structural Material (OSM) Quality Assurance (QA) Inspector, D.Sukanthan was present during the time noted above for observations relative to the work being performed.

OBG # BAY16

This QA inspector received ZPMC Non Destructive Testing (NDT) notification 08590 to perform Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated a Ultrasonic Test report for this date. The member is identified as Steel Barrier. The weld tested is identified as follows:

(W2-SB14-001-019)

(W2-SB15-001-081)

(W2-SB16-001-081)

(W2-SB16B-001-081)

(W2-SB17-001-019)

(W2-SB18-001-081)

(W2-SB18A-001-081)

(W2-SB19-001-081)

(W2-SB20-001-019)

(W2-SB16A-001-019)

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

This QA Inspector randomly observed the following work in progress:

OBG # BAY16

This QA observed ZPMC qualified welding personnel identified as 201074 perform Flux Cored Arc Welding (FCAW) Process on weld joint W5-SB31A-001-032. ZPMC Quality Control Personnel (QC) identified as Mr. Guo xin hui was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2133-ESAB.

This QA observed ZPMC qualified welding personnel identified as 201889 perform Flux Cored Arc Welding (FCAW) Process on weld joint E2-SB36-001-084. ZPMC Quality Control Personnel (QC) identified as Mr. Guo xin hui was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132-ESAB.

This QA observed ZPMC qualified welding personnel identified as 206296 perform Flux Cored Arc Welding (FCAW) Process on weld joint W5-SB30D-001-085. ZPMC Quality Control Personnel (QC) identified as Mr. Guo xin hui was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132-ESAB.

This QA observed ZPMC qualified welding personnel identified as 201905 perform Flux Cored Arc Welding (FCAW) Process on weld joint E5-SB22-001-168. ZPMC Quality Control Personnel (QC) identified as Mr. Guo xin hui was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2133-ESAB.

OBG # CROSSBEAM CB17

This QA observed that no significant work was being performed on this crossbeam during the time QA was present.

OBG # CROSSBEAM CB18

This QA Inspector observed that ABF personnel continuously perform Magnetic particle Testing (MT) on various weld joints. No other signification work was being performed on this crossbeam during the time QA was present.

OBG # CROSSBEAM CB19

This QA observed that no significant work was being performed on this crossbeam during the time QA was present.

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

Summary of Conversations:

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

As mention above

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 150-00422372, who represents the Office of Structural Materials for your project.

| | | |
|----------------------|----------------------|-----------------------------|
| Inspected By: | Sukanthan,Dhanasingh | Quality Assurance Inspector |
|----------------------|----------------------|-----------------------------|

| | | |
|---------------------|-------------|-------------|
| Reviewed By: | Hall,Steven | QA Reviewer |
|---------------------|-------------|-------------|