

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-023060**Date Inspected:** 20-Apr-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 Chang xing Island in Shanghai, China. QA observed and/or found the following:

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.

BK014A-001

NDT Notification No-08878

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.

BK009A3-001-038, 026, 047, 057, 058,

BK009A4-001-014, 029, 048, 049, 038, 057, 058

BK009A5-001-008, 009, 024,

BK009A6-001-037, 019, 028, 029,

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BK009A8-001-039, 028, 029

NDT Notification No-08876

This QA Inspector observed the following work in progress:

BAY 10

SMAW Process:

This QA Inspector observed ZPMC qualified welding personnel identified as 057220 Perform Shielded Metal Arc Welding (SMAW) on OBG Bike Path U Rib splice plate. Joint identified as X3305K-018-001, 002. ZPMC QC Identified as Lijun. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2213-Tc-U4b. For more information see attached picture number 1.

This QA Inspector observed ZPMC qualified welding personnel identified as 500363 Perform Shielded Metal Arc Welding (SMAW) on OBG Bike Path U Rib splice plate. Joint identified as X3305K-014-001, 002. ZPMC QC Identified as Lijun. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2213-Tc-U4b.

FCAW Process:

This QA Inspector observed ZPMC qualified welding personnel identified as 057266 Perform Flux Core Arc Welding (FCAW) on OBG Bike Path U Rib splice plate. Joint identified as X3305K-021-001, 002. ZPMC QC Identified as Lijun. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2233-ESAB.

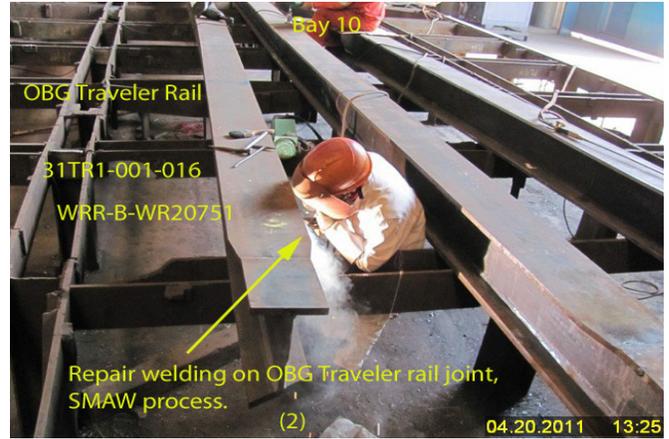
Repair welding, SMAW Process:

This QA Inspector observed ZPMC qualified welding personnel identified as 053829 Perform Shielded Metal Arc Welding (SMAW) on OBG Traveler Rail. Joint identified as 31TR1-001-016. ZPMC QC Identified as Lijun with Temporary welding repair report WWR-B-WR20751. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-2G (2F)-Repair-1. For more information see attached picture number 2.

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

Inspected By: Gaikwad,Shailesh

Quality Assurance Inspector

Reviewed By: Clifford,William

QA Reviewer