

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:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008122**Date Inspected:** 07-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Yu Zhi Lai**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 OBG segments**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Steve Hall 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:

Tower bay 10

This QA observed ZPMC qualified welding personnel identified as 057266 perform FCAW welding on north tower stiffener to skin plate four weld joint identified as NSD1-FDSA4-3D/D-019. ZPMC QC CWI identified as Mr. Yu Zhi Lai 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-2332-Tc-P5-F.

This QA observed ZPMC qualified welding personnel identified as 057244 perform FCAW welding on north tower stiffener to skin plate four weld joint identified as NSD1-FDSA4-3D/D-020. ZPMC QC CWI identified as Mr. Yu Zhi Lai 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-2332-Tc-P5-F.

OBG trial assembly

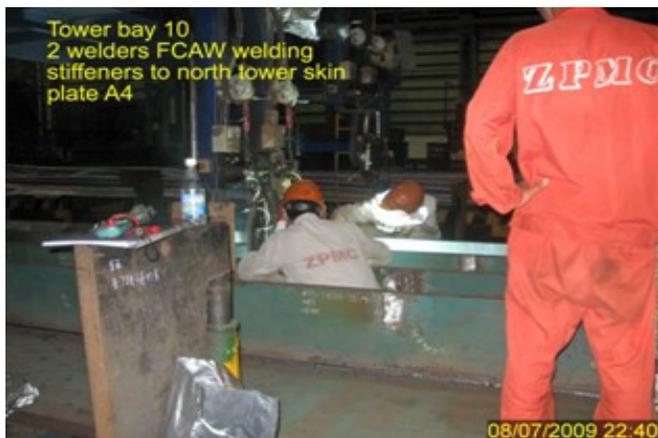
This QA observed ZPMC qualified welding personnel identified as 045240 perform FCAW root welding on joining OBG segments 1AAE to 1AE, weld joint identified as OBE1-003. ZPMC QC identified as Mr. Wu Zhi Cheng was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2231-B-U2a-F-3.

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This QA observed ZPMC personnel removing temporary fit up lugs from the deck panel of crossbeam identified as CB4 and the deck panel of OBG segment identified as 5BE. The lugs were being removed utilizing the carbon arc gouge method. The removal of these lugs appeared to be in general compliance with the applicable contract documents.

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

Inspected By:	Hall,Steven	Quality Assurance Inspector
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Reviewed By:	Prue,Erik	QA Reviewer
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