

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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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-011416**Date Inspected:** 26-Dec-2009**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:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Surendra Prabhu 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:

Heavy Dock

This QA Inspector performed photo documentation on segment lift 1 (East) located on ZPMC ship prior to being shipped to San Francisco California for erection. The following locations and members are as followed:

Lift 1 East (Panel Point 8.5~12.5)

1. Corner Assembly (bike path and crossbeam side of segment).
2. Longitudinal Diaphragm (bike path and crossbeam side of segment).
3. Longitudinal Diaphragm Truss (bike path and crossbeam side of segment).
4. Chevron Diagonals members (upper and lower) on bike path and crossbeam side of segment.

TRIAL ASSEMBLY AREA.

This QA Inspector observed the following work in progress:

Weld Process Shielded Metal Arc Welding (SMAW) of weld joint 002 located on CA-014. Welder is identified as 220069. ZPMC Quality Control (QC) is identified as Zang Hai Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T2232-TC-U4b-F.

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

Summary of Conversations:

Only general conversation was held between QA and Quality Control (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:	Prabhu,Surendra	Quality Assurance Inspector
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Reviewed By:	Miller,Mark	QA Reviewer
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