

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-011684**Date Inspected:** 22-Jan-2010**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:** Liu Hua Jie.**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) Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

Bay 14:

This QA Inspector observed the following work in progress:

Submerged Arc Welding (SAW) of weld joint SEG3005*- 007 (for 12BW). Welder is identified as 045270. ZPMC Quality Control (QC) is identified as Liming Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2221-B-L2C-S-2.

Shielded Metal Arc Welding (SMAW) of weld joint SP785-001 – 001 to 012 (for 11DW). Welder is identified as 207540. ZPMC Quality Control (QC) is identified as Liming Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-P-2213-B-U2-FCM-1.

SMAW of weld joint SP745-001 – 037 to 048 (for 11DW). Welder is identified as 207540. ZPMC Quality Control (QC) is identified as Liming Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-P-2213-B-U2-FCM-1.

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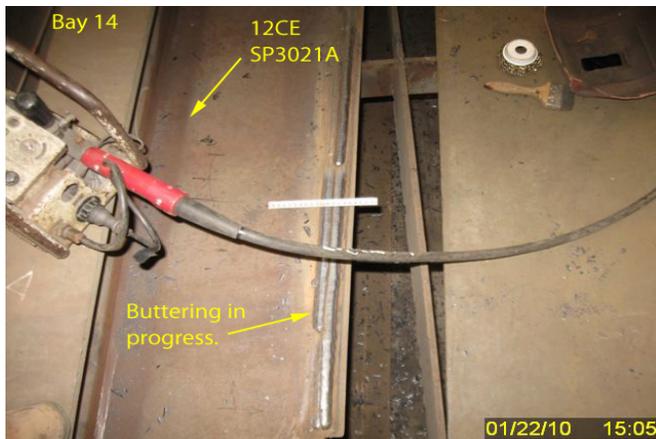
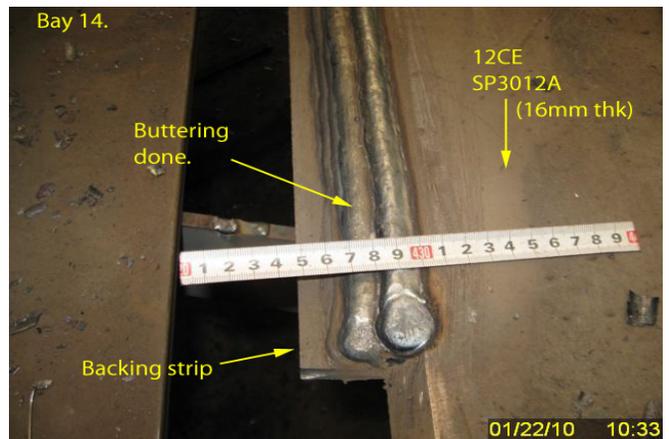
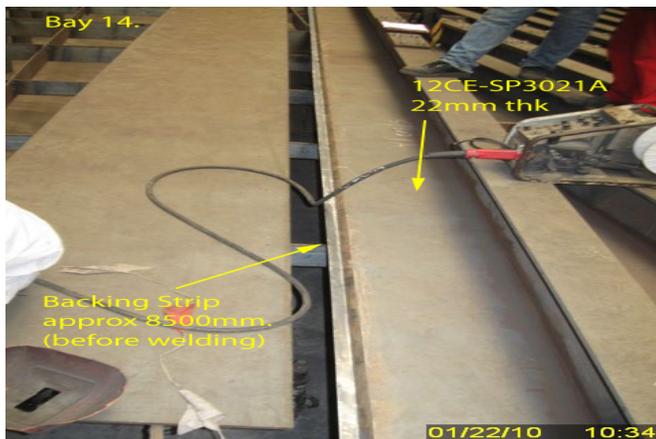
SMAW of weld joint SP745-001 – 014, 016, 018, 021, 022, 024 (for 11DW). Welder is identified as 051348. ZPMC Quality Control (QC) is identified as Liming Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-P-2214-B-U2-FCM-1.

During inprocess visual inspection (in Bay 14); the below mentioned activity was noted, which did not appear to comply with the applicable contract document.

Deposition of weld metal (buttering / build up) on base metal by FCAW done on SP3012A (for 12CE) and SP3021A (for 12 CE). Buttering done approx 38mm x L1500mm & 30mm x L2000mm for SP3012A & SP3021 respectively. Critical Welding Report (CWR) was not available. Welding done with Welding Repair Report (WRR) – B-WR-10076 Dt: 19th Jan 2010. Welder identified as 055491. This QA informed ZPMC Quality Control (QC) identified as Mr. Guo Xing Hui and American Bridge Fluor (ABF) QA identified as Mr. Wang Wei Nan Aaron of this issue and that an incident report would be generated.

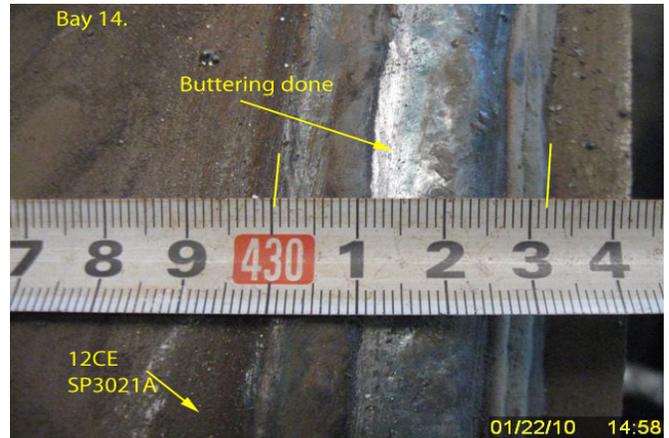
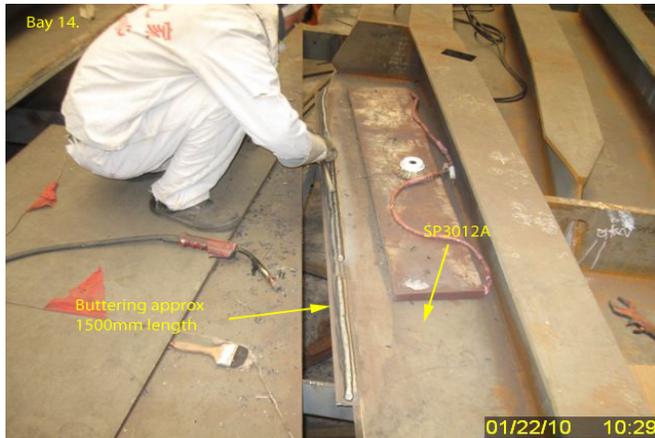
For further information, please see the attached photos.

Unless otherwise noted, all work observed on this date appeared to generally comply with 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; phone: 15000422372., who represents the Office of Structural Materials for your project.

Inspected By: Wadkar,Sailesh

Quality Assurance Inspector

Reviewed By: Hall,Steven

QA Reviewer