

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:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019436**Date Inspected:** 11-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

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|------------------------------------|-------------------------------------|----|-----|----------------------------------|-----|----|-----|
| CWI Name: | Shi Lei (east) Bao Lei Zhang (west) | | | 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 (QA) Inspector Kenneth Riley 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.

Bay 19

On this date the QA inspector was present at ZPMC and witness the following work in progress: FCAW welding of joint 006 in the horizontal (2G) welding position located on PCMK, BK4A1-12. Welders were identified as 062757 and 062788. ZPMC QC is identified as Zhoa Cheng who was onsite recording and documenting the welding parameters for this location under WPS-B-T-2232-B-U4c-F.

Bay 16

On this date the QA inspector was present at ZPMC and witness the following work in progress: SAW welding of joint 003 in the flat (1G) welding position located on PCMK, BP 3074-001. The Welding operator was identified as 045265. ZPMC QC is identified as Xu Tao who was onsite recording and documenting the welding parameters for this location under WPS-B-T-2221-B-U3c-S-2.

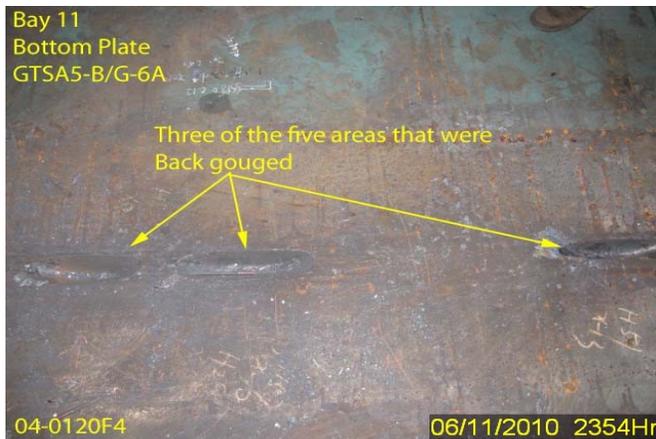
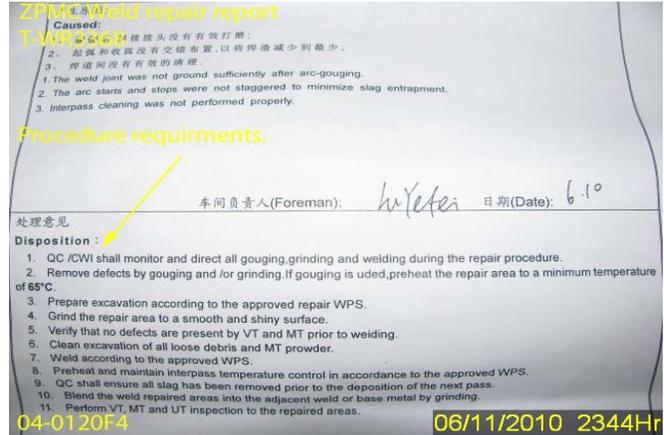
Bay 11

This Caltrans QA inspector observed ZPMC performing weld repairs on Tower Bottom Plate GTSA5-B/G-6A using the carbon arc gouging method. This QA inspector observed that there was no preheat being utilized prior to the start of the repair process and was able to place his hand on the part which was at ambient temperature. ZPMC's Repair procedure required a minimum preheat of 65 degrees C. The weld repair procedure was onsite

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with the ZPMC individual who was performing the back gouging and gave the copy to this QA inspector for review. When this QA inspector asked for the identification card he was told that the ZPMC individual did not have one nor would he give his name to the QA inspector. Also observed was that ZPMC did not have QC personnel onsite for the monitoring of the repair process which is also outlined in their repair process and in the special provisions. An incident report was written for this location.



Summary of Conversations:

No Conversations This date.

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.

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| Inspected By: | Riley, Ken | Quality Assurance Inspector |
| Reviewed By: | Carreon, Albert | QA Reviewer |