

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-016599**Date Inspected:** 27-Aug-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:** Wang 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 and Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Larry Viars was present during the times noted above for observations relative to the work being performed.

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This QA Inspector observed the following work in progress: Submerged Arc Welding (SAW) of OBG Segment 13BW side panel weld, SEG3014M-002. ZPMC welder was identified as 045270. ZPMC QC was identified as Xia Chun Hui. ZPMC CWI was identified as Wang Jie. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2221-B-L2c-S-2.

Flux Cored Arc Welding (FCAW) of OBG Segment 13CW bottom panel weld, SEG3015A-001. ZPMC welder was identified as 201215. ZPMC QC was identified as Xia Chun Hui. ZPMC QC was identified as Wang Xu. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2231-B-U2-F.

Caltrans performed visual inspection of backgouge after grinding on OBG Segment 13AE side panel weld, SEG3007AE-002.

Caltrans performed random visual inspection of OBG Segment 12CW welds. QA observed six (6) longitudinal linear indications on Longitudinal Diaphragm (LD) horizontal stiffener to FL-2-2 and LD vertical stiffener welds. Indications were shown to ZPMC QC for repair. ZPMC has not performed NDT of these welds and fabrication is still in process. See attached photos for additional information.

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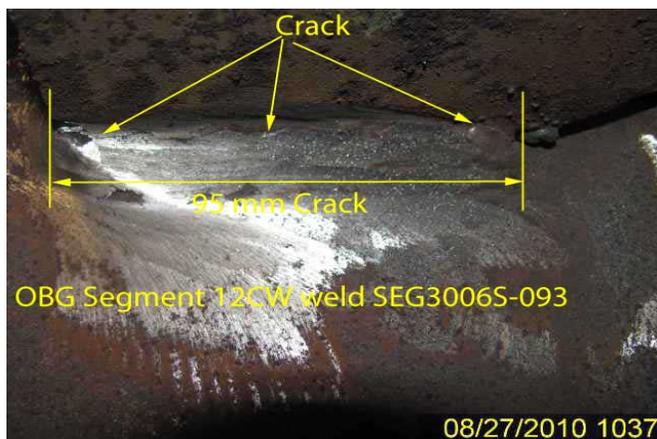
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Bay 16-

This QA Inspector performed Magnetic Particle Testing (MT) verification of welds previously tested and accepted by ZPMC for West Tower façade manhole covers. See MT report TL-6028 generated this date for additional information. The following welds were tested:

- WD1-SA4-66-2 welds, 1~12
- WD1-SA4-66-4 welds, 1~12
- WD1-SA4-66-10 welds, 1~12
- WD1-SA4-66-28 welds, 1~12

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



Summary of Conversations:

Only general conversation between QA and QC occurred 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, 150 0042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Viars,Larry	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
