

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-021129**Date Inspected:** 10-Oct-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:** Xu Tao**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 Segment Assembly**Summary of Items Observed:**

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

Bay 16 / OBG Segment 13AW

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) in the 2F position of weld joint BP3050A-001-057 located on Bottom Panel. The welder is identified as 020009. ZPMC Quality Control (QC) is identified as Liu Dao Feng. The welding variables recorded by QC appeared to comply with the WPS B-T-2132. See attached photograph Pic_001.

Bay 14 / OBG Segment 13AW

This QA Inspector observed the following work in progress:

Sub Arc Welding (SAW) in the 1G position of weld joint SEG3013-007 located on Deck Panel Plate DP3121A to DP3122A. The welder is identified as 250050. ABF Quality Assurance (QA) is identified as Shao Jian Yuan. The welding variables recorded by QC appeared to comply with the WPS B-T-2221-B-L2c-S-2.

Bay 14 / OBG Segment 14W

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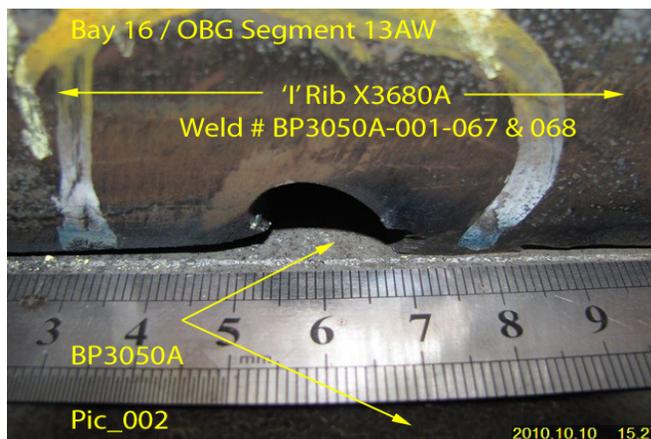
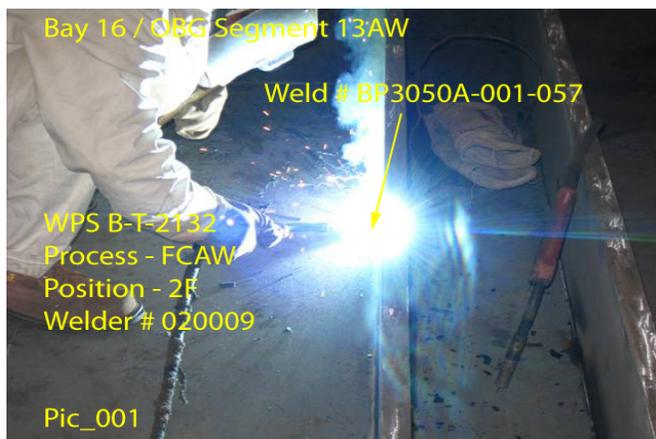
This QA Inspector observed the following work in progress:

Sub Arc Welding (SAW) in the 1G position of weld joint SEG3020-007 located on Bottom Panel Plate BP3090A to BP3091A. The welder is identified as 045265. ABF Quality Assurance (QA) is identified as Shao Jian Yuan. The welding variables recorded by QC appeared to comply with the WPS B-T-2221-B-L2c-S-2.

Bay 16/ OBG Segment 13AW

This QA Inspector observed the following work in progress:

During in process inspection This QA inspector found base metal discontinuity on 'I' rib # X3680A connected to Bottom Panel BP3050A at weld # BP3050A-001-067 & 068. 'I' rib butting face was damaged around 15 mm \varnothing & 28 mm depth. This QA informed this incident to Lead QA & shown to ZPMC QC & ABF QA personnel. ABF QA agreed to for repair & after repair NDT. ZPMC Quality Control (QC) is identified as Liu Dao Feng. See attached Photograph Pic_002 & 003.



Summary of Conversations:

No relevant conversations reported on 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 (+86)15000 42 2372, who represents the Office of Structural Materials

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for your project.

Inspected By:	Gade,Ramesh	Quality Assurance Inspector
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Reviewed By:	McClendon,Timothy	QA Reviewer
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