

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-021834**Date Inspected:** 15-Mar-2011**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:** Zhou Zhong Hai**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 COMPONENT**Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Subhasis Bera was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China. QA Inspector observed and/or found the following:

In process Inspection

Trial Assembly

This QA Inspector observed the following work in progress:

SMAW in the 4F position for the OBG Segment 12CW, weld No. CA3010E-283/284. The welder is identified as #057333. ZPMC QC is identified as Mr. Zhou Peng. The welding variables recorded by QC appear to comply with WPS-B-P-2114-FCM-1. The welding variables were recorded at, Amperage 133, volts 24.5. The In-process SMAW appears to be progressing in compliance with approved contract documents.

SMAW in the 3F position for the OBG Segment 12CW, weld No. DP3070-001-030. The welder is identified as #057333. ZPMC QC is identified as Mr. Zhou Peng. The welding variables recorded by QC appear to comply with WPS-B-P-2113-FCM-1. The welding variables were recorded at, Amperage 149, volts 24. The In-process SMAW appears to be progressing in compliance with approved contract documents.

SMAW in the 2G position for the OBG Segment 12AE, UT repair weld No. CA3001-006. The welder is identified as #067752. ZPMC QC is identified as Mr. Wang Zhou. The welding variables recorded by QC appear to comply

WELDING INSPECTION REPORT

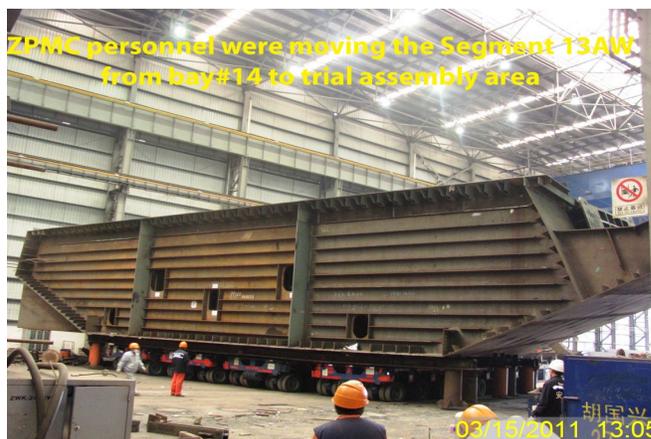
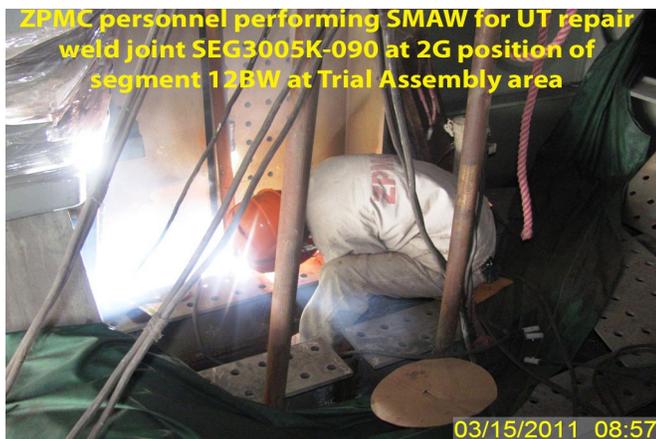
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with WPS-345-SMAW-2G(2F)-FCM-REPAIR-1. The weld repair report is identified as WR20471. The welding variables were recorded at, Amperage 152, volts 24.5. The In-process SMAW appears to be progressing in compliance with approved contract documents.

SMAW in the 2G position for the OBG Segment 12BW, UT repair weld No. SEG3005K-090. The welder is identified as #046709. ZPMC QC is identified as Mr. Zhou Zhong Hai. The welding variables recorded by QC appear to comply with WPS-345-SMAW-2G(2F)-FCM-REPAIR-1. The weld repair report is identified as WR20338. The welding variables were recorded at, Amperage 155, volts 24.8. The In-process SMAW appears to be progressing in compliance with approved contract documents.

SMAW in the 2G position for the OBG Segment 12BW, UT repair weld No. SEG3006T-035. The welder is identified as #046709. ZPMC QC is identified as Mr. Zhou Zhong Hai. The welding variables recorded by QC appear to comply with WPS-345-SMAW-2G(2F)-FCM-REPAIR-1. The weld repair report is identified as WR20338. The welding variables were recorded at, Amperage 151, volts 24.3. The In-process SMAW appears to be progressing in compliance with approved contract documents.

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



Summary of Conversations:

No relevant conversations

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: Bera, Subhasis

Quality Assurance Inspector

Reviewed By: Dsouza, Christopher

QA Reviewer