

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-023467**Date Inspected:** 06-May-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:** 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 components.**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Mr. 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 Inspector observed and/or found the following:

Bay 14:

This QA Inspector observed the following work in progress:

OBG Seg 13CW:

ZPMC personnel were performing gas cutting of weld jt nos: FB3238-001-003, 004 and 005 (at PP124.5) and FB3237-001-001 (at PP124) on Floor Beam (FB) 3338 and FB3237, for the respective welds. This cutting was done as per Welding Repair report (WRR): B-WR 20928 Rev-0. The alignment with Seg 14W Edge Panel is in progress. See attached photos for further details.

OBG Seg 13AW:

This QA Inspector observed that the weld jt no: Seg 3013AH-037 [X3864R I-rib stiffener on K-Plate (KP) 3010A, to FB3180A complete joint penetration (CJP) weld at Panel Point (PP) 118.35] is welded with steel backing bar. However, it was observed that the gap between the backing bar and X3864R stiffener was observed as approx

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10mm. This QA Inspector informed about this issue to ZPMC QC identified as Shen Jian Bo. Also informed to CT Lead QA. See attached photo for further details.

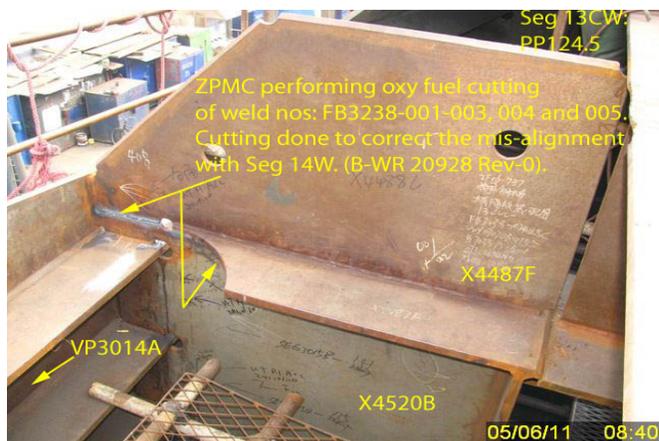
OBG Seg 13AE and Seg 13BE:

Repair welding of weld joint no: OBE13-002 [Deck Plate (DP) to DP CJP transverse splice joint]. The welder is identified as 058100 and was observed welding in the 1G position. Welding process was identified as Shielded Metal Arc Welding (SMAW). ZPMC Quality Control (QC) was identified as Zhou Peng. The welding variables recorded by this QC appeared to comply with welding procedure specification (WPS): 345-SMAW-1G(1F)-FCM-Repair-1. Repair welding was done as per WRR: 20678 Rev-0.

The Flux Cored Arc Welding (FCAW) process on weld joint no: OBE13E-003 [Side Panel (SP) to SP, CJP splice weld]. The welder is identified as 066041 and was observed welding in 3G position. ZPMC QC was identified as Zhou Peng. The welding variables recorded by this QC appeared to comply with WPS: B-T-2233-ESAB.

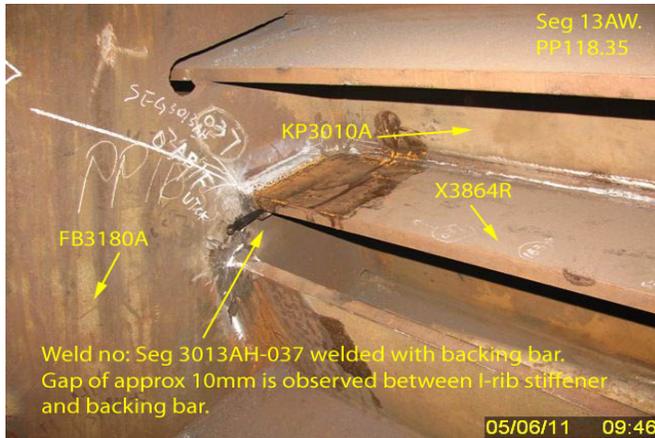
The FCAW process on weld joint no: OBE13D-004 (SP to SP, CJP splice weld). The welder is identified as 066743 and was observed welding in 3G position. ZPMC QC was identified as Zhou Peng. The welding variables recorded by this QC appeared to comply with WPS: B-T-2233-ESAB.

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



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Summary of Conversations:

No significant conversations were 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; phone: 15000422372., who represents the Office of Structural Materials for your project.

Inspected By: Wadkar,Sailesh

Quality Assurance Inspector

Reviewed By: Peterson,Art

QA Reviewer