

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-023494**Date Inspected:** 10-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 13AW:

ZPMC personnel performing fit-up of Architectural WT splice sub-assembly (X3869A) with Side Panel (SP) 3102A and Architectural Housing (AH) 3001A. See attached photo for details.

ZPMC personnel performing fit-up of Bottom Panel (BP) 3056A with Seg 13AW. See attached photo for details.

OBG Seg 13AE:

ZPMC personnel performing drilling of 24mm dia holes on Architectural WT splice sub-assembly (SA3219A) with SP3070A and AH3150A. See attached photo for details.

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ZPMC personnel performing fit-up of BP3050A with Seg 13AE. See attached photo for details.

ABF personnel performing Magnetic Particle Testing (MT) after removal of temporary attachments at weld jt no: OBE13-002 [Deck Panel (DP) to DP complete joint penetration (CJP) splice weld. See attached photo for details.

OBG Seg 13CW and Seg 14W:

ZPMC personnel performing fit-up of SP to SP; CJP splice weld (south side). Photo attached for details.

OBG Seg 13CW:

ZPMC personnel performing fit-up of X4099B stiffener splice plate with I-ribs on SP3098A at PP123 – PP123.5. Photo attached for details.

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