

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-024665**Date Inspected:** 06-Jun-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:** Mr. An Qing Xiang**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:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

This CALTRANS OSM Quality Assurance Inspector (QA) Surendra Prabhu 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 observed and/or found the following:

OBG Trial Assembly open yard.

Segment: 13AW

This QA Inspector randomly observed the following work in progress:

ZPMC personnel performing bolt hole drilling at FL3 area. See attached photos for further details.

Segment: 14W

Shielded Metal Arc Welding (SMAW) repair welding of weld joint identified as SEG3020W-184. Welder is identified as 066156. ZPMC QC is identified as Mr. Zhulin. The welding variables recorded by QC personnel observed appeared to comply with Welding Procedure Specification (WPS): WPS-345-SMAW-4G (4F)-FCM-repair-1. The repair welding was being performed as per Welding Repair Report (WRR) No: B-WR21216.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

SMAW repair welding of weld joint identified as SEG3020AQ-012. Welder is identified as 066002. ZPMC QC is identified as Mr. Zhulin. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-345-SMAW-4G (4F)-FCM-repair-1. The repair welding was being performed as per WRR No: B-WR21173.

SMAW repair welding of weld joint identified as SEG3020AG-024. Welder is identified as 069118. ZPMC QC is identified as Mr. Zhulin. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-345-SMAW-4G (4F)-FCM-repair-1. The repair welding was being performed as per WRR No: B-WR21007.

SMAW welding of weld joint identified as SEG3020L-015. Welder is identified as 066361. ZPMC QC is identified as Mr. Zhulin. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-B-P-2212-TC-U4b-FCM-1.

SMAW welding of weld joint identified as SEG3020L-016. Welder is identified as 066398. ZPMC QC is identified as Mr. Zhulin. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-B-P-2213-TC-U4b-FCM-1.

ZPMC MT Technicians performing Magnetic Particle Testing for the "I" rib stiffener plate weld joints located at panel point 125.5 and 126 side plate cross beam side. See attached photos for further details.

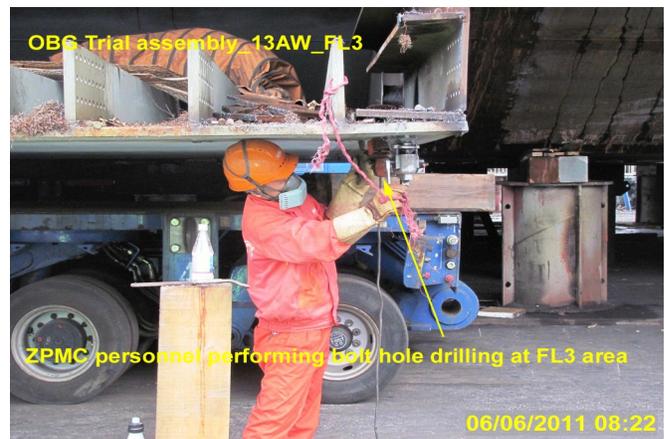
ZPMC personnel performing weld back gouging by using air-carbon arc gouging for the weld joints connected to deck panel diaphragm to floor beam. The weld joints are identified as SEG3020V-027,029 and 031. See attached photos for further details.

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



WELDING INSPECTION REPORT

(Continued Page 3 of 3)



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 15000422372, who represents the Office of Structural Materials for your project.

Inspected By: Prabhu,Surendra

Quality Assurance Inspector

Reviewed By: Peterson,Art

QA Reviewer