DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-005721
Date Inspected: 08-Mar-2009

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 645
OSM Departure Time: 1645
Location: Shanghai, China

CWI Name: Li Yan Hua

Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**CWI Present:**	☑ Yes	☐ No	
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☐ Yes	☑ No	☐ N/A
				Approved WPS:	☑ Yes	☐ No	☐ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: OBG

Summary of Items Observed:

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

Segment 4AE: QA Inspector randomly observed ZPMC qualified welder ID #044772 repair welding Seg-018A-010 side plate to bottom plate complete joint penetration (CJP) butt weld. Welder was observed welding in the 4G (overhead) position utilizing the Shielded Metal Arc Welding (SMAW) process. QA Inspector observed the ZPMC QC Inspector Geng Wei verifying welding parameters and pre-heat were in accordance with the Welding Procedure Specification (WPS). QA Inspector with QC Inspector observed parameters taken for welder # 044772 as follows: preheat temperature to be at 178°C and measured the welding parameters to be 178 amps, 25.4 volts, a travel speed of 118 mm/min. Welding parameters verified by QA Inspector appear to be in general compliance with the approved WPS-3435-SMAW-4G (4F) and critical welding repair B-CWR-402-Rev-0.

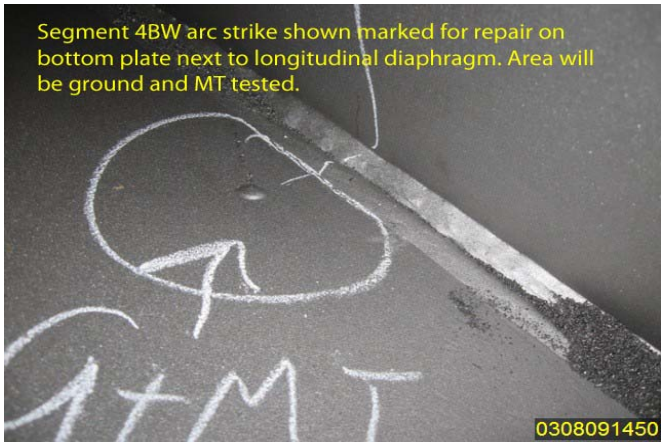
Segment 4BW: QA Inspector received notification that segment 4BW side plates, bottom plates, longitudinal diaphragms, and floor beams welds and base material on inside bottom of segment had been visually inspected by ABF and ZPMC QC personnel after blast and are ready for QA visual verification. QA Inspector performed visual verification on QC inspector inspection. QA Inspector noted several indications marked for repair by ABF QC Inspectors and concur with QC findings. QA Inspector marked eleven (11) indications not marked by QC Inspection for repair by grinding. QA Inspector marked one (1) area for repair by welding. Area marked for weld repair that is unacceptable to AWS D1.5 (02) section 6.26 has been taped and documented for tracking after segment painting. QA Inspector verified areas marked for repair by grinding on inside of segment (top & bottom)

have been repaired and appear to be acceptable to AWS D1.5 (02).

Unless otherwise noted, all work observed on this date appears to be in general compliance with the applicable contract documents.

Summary of Conversations:

No significant conversations this day.



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:	Prue,Erik	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer