

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-005805**Date Inspected:** 24-Mar-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 630**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

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|------------------------------------|---------------------------------|----|-----|----------------------------------|---------------------|----|-----|
| CWI Name: | Shi Lei, Chen Likun and Yu Dong | | | 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 Assembly, Tower | | |

Summary of Items Observed:

ZPMC's qualified welding personnel's are identified as Mr. Zhang Jian Long (057220) and Mr. Jian Jinyong (066361) perform SMAW (Tack) welding on weld joint identified as NSD1-A112B/H-3B. ZPMC QC identified Mr. Chen Likun was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-2314-7C-P5-2.

ZPMC's welding personnel's are identified as Mrs. Lu Haixian (040251) and Mrs. Xu Kaozhen (051413) performing groove welding of weld joint SSD1-FESA3-14A/B-13 and NSD1-FASA3-1A/E-1A. The personnel were observed welding in the 1G (flat) position utilizing a Submerged Arc Welding (SAW) process. ZPMC QC identified Mr. Chen Likun and was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-BU3C-S-2.

ZPMC's qualified welding personnel's are identified as Mr. Jin Xianogang (053474), Mr. Zhang Yigui (048627), Wang Qingbo (068501), Zhu Zhongyun (057194), Yu Chaoye (053869) and Ni Xiuba (040533) perform FCAW welding on weld joint identified as ED1-A27 A/E-1A (repair), and NSD1-A112B/H-2B, NSD1-A116E/J-124B, SSD1-A164E/J-243A and SSD1-A111B/H-125A. ZPMC QC identified Mr. Chen Likun was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-345-FCAW-1G (1F) Repair and WPS-B-T-2232-TC-U2-F.

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ZPMC's qualified welding personnel's are identified as Mr. Lie Xiuchan (040733), Mr. Yang Lei (040690), Mr. Ge Hongqi (037780), Mr. Qian Zenglan (062795), Mr. Lu Xianjie (067904) and Mr. Shen Zhinhua (062772) perform SMAW welding on weld joint identified as WD1-A467-43M-5B, WD1-A467-46.5M-41, 65, 87 and 68. ZPMC QC identified Mr. Yu Dong Ping was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2212-TC-U5B.

ZPMC's welding personnel's are identified as Mrs. Xue Yian (040634) performing groove welding of weld joint FSD1-TL7 B/L-1A. The personnel were observed welding in the 1G (flat) position utilizing a Submerged Arc Welding (SAW) process. ZPMC QC identified Mr. Li Hong Fie and was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-C-U2B-S-2.

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ZPMC's qualified welding personnel's are identified as Mr. Wang Quanlin (066746) and Mr. Cao Tao (066163) perform FCAW welding on weld joint identified as SSP19-PP18-10-041 and SSP18-PP15-253. ZPMC QC identified Mr. Shi Lei was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-TC-44b-F and WPS-B-T-2133 and WPS-B-T-2232-TC-U4c-F.

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ZPMC welding personnel Mrs. Wang Lanying (045265) performing groove welding of weld joint SEG004*-003. The personnel were observed welding in the 1G (flat) position utilizing a Submerged Arc Welding (SAW) process. ZPMC QC identified Mr. Li Ming and was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-L2C-S-2.

ZPMC's qualified welding personnel's are identified as Mr. Li Xianyou (047866) perform FCAW welding on weld joint identified as DP550-001-158 thru 196. ZPMC QC identified Mr. Shi Lei was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2133.

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

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Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

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 (134-8257-0045), who represents the Office of Structural Materials for your project.

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| Inspected By: | Alaniz,Joe | Quality Assurance Inspector |
| Reviewed By: | Carreon,Albert | QA Reviewer |
