

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:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016167**Date Inspected:** 12-Aug-2010**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:** Zhu Zhong Hai.**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 observed and/or found the following:

OBG Trial Assembly Yard:

This QA Inspector observed the following work in progress:

OBG Seg 10AW:

The Flux Cored Arc Welding (FCAW) process on weld joint no: SEG059B-007. The welder is identified as 040609 and was observed welding in the 2G position. ZPMC Quality Control (QC) was identified as Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with WPS: B-T-2132.

OBG Seg 9DW:

The FCAW process on weld joint no: SEG055C-044. The welder is identified as 040704 and was observed welding in the 2G position. ZPMC QC was identified as Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with WPS: B-T-2132.

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OBG Seg 9EW:

The FCAW process on weld joint no: SEG057C-029. The welder is identified as 040704 and was observed welding in the 2G position. ZPMC QC was identified as Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with WPS: B-T-2132.

The FCAW process on weld joint no: OBW9K-014. The welder is identified as 049541 and was observed welding in the 1G position. ZPMC QC was identified as Zhou Pan. The welding variables recorded by QC appeared to comply with WPS: B-T-2231-TC-U4b-F.

OBG Seg 9CW:

The FCAW process on weld joint no: OBW9K-007. The welder is identified as 067904 and was observed welding in the 1G position. ZPMC QC was identified as Zhou Pan. The welding variables recorded by QC appeared to comply with WPS: B-T-2231-TC-U4b-F.

Cross Beam 11 (CB11):

The Shielded Metal Arc Welding (SMAW) process on weld joint no: CB202A-011-003. The welder is identified as 067829 and was observed welding in the 4G position. ZPMC QC was identified as Zhou Pan. The welding variables recorded by QC appeared to comply with WPS: B-P-2214-TC-U4b-F. See attached photo for further details.

OBG Seg 9BE:

The SMAW process on weld joint no: SSD18-PP76-169. The welder is identified as 067829 and was observed welding in the 4G position. ZPMC QC was identified as Zhou Pan. The welding variables recorded by QC appeared to comply with WPS: B-P-2214-TC-U4b-F.

OBG Seg 9DE:

Repair welding on weld joint no: SEG056*-047. Welding process was identified as FCAW. The welder was identified as 053609 and was observed welding in the 4G position. ZPMC QC was identified as An Qing Xiang. The welding variables recorded by QC appeared to comply with WPS: 345-FCAW-4G(4F)-FCM-Repair-1. Repair welding was done as per Critical Welding Report (CWR): B-CWR-1788 Rev-0.

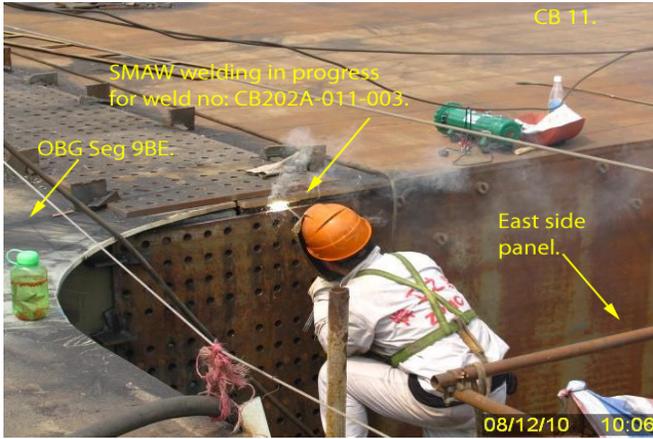
OBG Seg 9DW and Seg 9EW:

Base metal repair welding on Side Panel (Cross Beam side) of OBG Seg 9DW and Seg 9EW; after removal of temporary attachments. Welding process was identified as SMAW. The welder was identified as 067572 and was observed welding in the 4G position. ZPMC QC was identified as Shi Lei. The welding variables recorded by QC appeared to comply with WPS: B-P-2214-B-U2-FCM-Repair-1. Repair welding was done as per CWR: B-CWR-1679 Rev-0.

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



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