

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-016659**Date Inspected:** 09-Sep-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 Seg 11EE (Green Tag DCP):

This QA Inspector, along with Mr. Manoj Prabhune; performed Green Tag DCP for OBG Seg 11EE from Panel Point (PP) 107 to PP108.5.

The details are as mentioned below:

- Dimension measurements of corner assembly cope holes at PP107 and PP107.5 [at both Cross Beam (CB) side and Bike Path (BP) side].
- Plumbness and flatness measurement of Deck Panel (DP) to DP diaphragm at PP107 and PP108.
- Floor beam flatness at PP107 and PP108 (at both CB side and BP side).
- Skin flatness of Side Panel (SP) to Corner assembly from PP107 to PP108.5 (at both; CB side and BP side)
- Skin flatness of DP to DP (of corner assembly – at both CB and BP side).

OBG Trial Assembly Yard:

For Cross Beam 12 (CB12):

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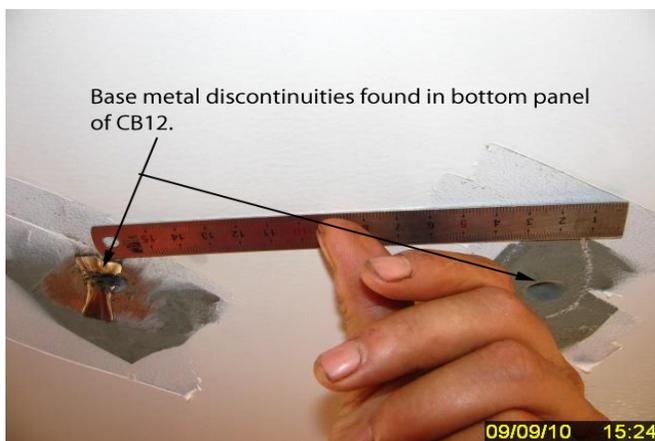
Punch list item no: 395 (for comments noted during visual inspection after blasting).

This QA Inspector did visual inspection (VT) of the above mentioned CB for its punch list item no 395. It was observed that none of the noted punch list item was attended for repair. This was informed to ZPMC Quality Control (QC) Mr. Xu Xing Ping.

Additional to the punch items, this QA Inspector observed base metal porosity on the bottom panel (outer surface) of this CB. This QA Inspector informed ZPMC QC to ensure a Critical Welding Report (CWR) is approved before any repair welding is done.

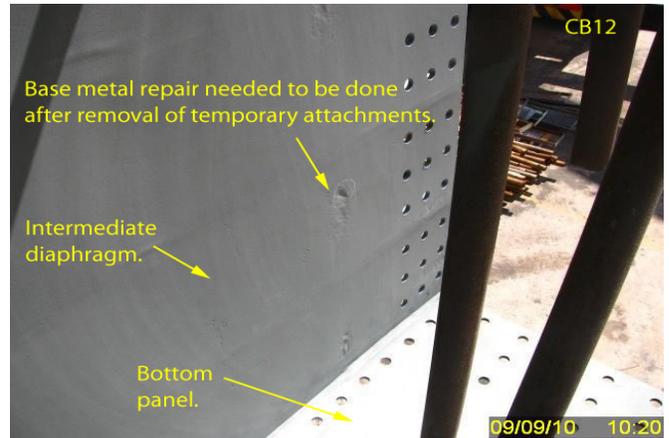
See attached photos for further details.

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
