

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-016915**Date Inspected:** 26-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 Trial Assembly Yard:

This QA Inspector observed the following work in progress:

OBG Seg 10CW:

Base metal repair welding on bottom panel and side panel after removal of temporary attachments at weld no: SEG063A-041. Welding process was identified as Shielded Metal Arc Welding (SMAW). The welder was identified as 202316 and was observed welding in the 4G position. ZPMC Quality Control (QC) was identified as Shi Lei. The welding variables recorded by QC appeared to comply with WPS: 345-SMAW-4G(4F)-FCM-Repair. Repair welding was done as per Critical Welding Repair Report CWR: B-CWR-1835 Rev-0. See attached photos for further details.

OBG Seg 11AW:

Base metal repair welding on bottom panel and side panel after removal of temporary attachments at weld no:

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SEG065A-014. Welding process was identified as SMAW. The welder was identified as 202316 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: 345-SMAW-4G(4F)-FCM-Repair. Repair welding was done as per Critical Welding Repair Report CWR: B-CWR-1842 Rev-0. See attached photos for further details.

Cross Beam 13 (CB 13):

The SMAW process on weld joint no: SSD25-PP87-032. The welder is identified as 040611 and was observed welding in the 2G position. ZPMC QC was identified as Zhu Zhong Hai. The welding variables recorded by QC appeared to comply with WPS: B-P-2212-B-U2-FCM-1.

OBG Seg 11AE:

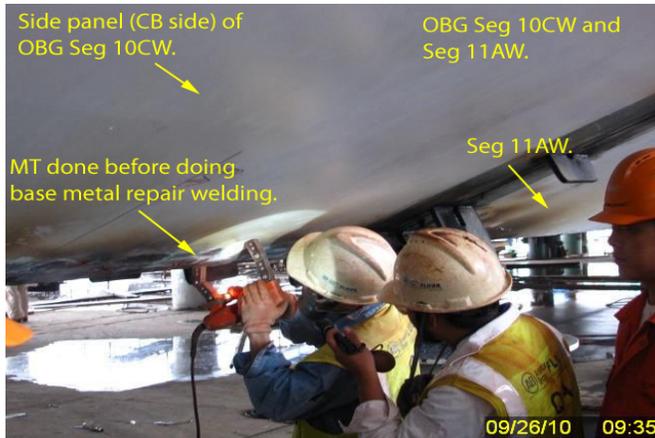
Repair welding (weld built-up) on small longitudinal diaphragm of OBG Seg 11AE at panel point (PP) 95. Welding process was identified as Flux Cored Arc Welding (FCAW). The welders are identified as 040367 and 040458 and were observed welding in the 2F position. ZPMC QC was identified as Wang Li Yang. The welding variables recorded by QC appeared to comply with WPS: 345-FCAW-2G(2F)-Repair-1. Repair welding was done as per Welding Repair Report WRR: B-WR-15055 Rev-0. See attached photo 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
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Reviewed By:	Peterson,Art	QA Reviewer
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