

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-016962**Date Inspected:** 21-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:** Mr. Xu Le Fung.**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:** Tower and Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Shailesh Gaikwad 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 observed and/or found the following:

This QA Inspector observed the following work in progress:

BAY 11

This QA Inspector observed ZPMC qualified welding personnel identified as 054460, 044541, Perform Shielded Metal Arc Welding (SMAW) on Lift 5 bracket stiffener. Joint identified as ND1-BRSA5-2-12A, 8A. ZPMC QC Identified as Liu Dao Feng. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-3213-Tc-U4b.

This QA Inspector observed ZPMC qualified welding personnel identified as 041271, 046769, Perform Shielded Metal Arc Welding (SMAW) on Lift 5 bracket stiffener. Joint identified as SD1-BRSA5-1-9B, 13B. ZPMC QC Identified as Liu Dao Feng. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-3213-Tc-U4b.

OBG Bike path stringer plate FCAW process:

This QA Inspector observed ZPMC qualified welding personnel identified as 040759, 053316, Perform Flux Core Arc Welding (FCAW) on OBG bike path stringer plate. Joint identified as BK004A-017-005. ZPMC QC

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Identified as Wang Chang Xin. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2232-Tc-U4c-F. For more information see below attached picture number 1.

SMAW Process Repair welding:

This QA Inspector observed ZPMC qualified welding personnel identified as 037743 Perform Shielded Metal Arc Welding (SMAW) on West tower lift 5 Grillage plate. Joint identified as WSD1-TL5-4E/F-32A/B. ZPMC QC Identified as Xu Jie with temporary welding repair report WRR-T-WR3640. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-485-SMAW-3G (3F) Repair. For more information see below attached picture number 2.

SMAW Process Repair welding:

This QA Inspector observed ZPMC qualified welding personnel identified as 037743 Perform Shielded Metal Arc Welding (SMAW) on West tower lift 5 Grillage plate. Joint identified as WSD1-TL5-4E/F-29A/B. ZPMC QC Identified as Xu Jie with temporary welding repair report WRR-T-WR3641. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-485-SMAW-3G (3F) Repair.

SMAW Process Repair welding:

This QA Inspector observed ZPMC qualified welding personnel identified as 066326 Perform Shielded Metal Arc Welding (SMAW) on West tower lift 5 Grillage plate. Joint identified as WSD1-TL5-4B/F-16A/B. ZPMC QC Identified as Xu Jie with Critical welding repair report CWR-T-CWR687. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-485-SMAW-3G (3F) Repair.

BAY 10

OBG Bike path stringer plate FCAW process:

This QA Inspector observed ZPMC qualified welding personnel identified as 057266, Perform Flux Core Arc Welding (FCAW) on OBG bike path stringer plate. Joint identified as BK007A6-001-068, 069. ZPMC QC Identified as Ma Qianli Ma. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2131.

This QA Inspector observed ZPMC qualified welding personnel identified as 057180, 052075, Perform Flux Core Arc Welding (FCAW) on OBG bike path stringer plate. Joint identified as BK007A6-001-074, 075. ZPMC QC Identified as Ma Qianli Ma. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2131 and WPS-B-T-2133.

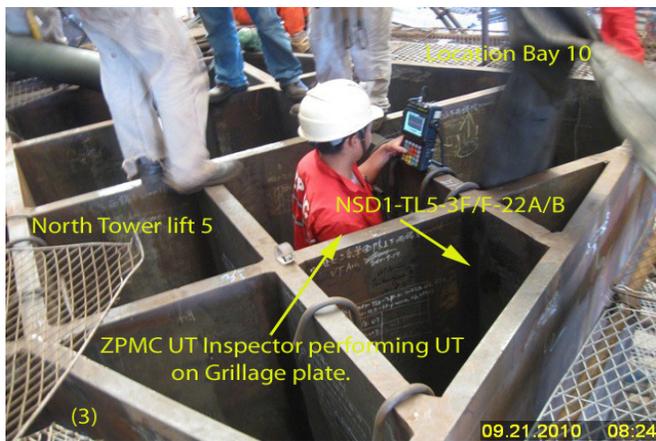
Ultrasonic Testing:

This QA Inspector observed ZPMC Ultrasonic Testing Inspector, performing UT on North Tower lift 5 Grillage plate. Joint identified as NSD1-TL5-3F-F-22A/B. For more information see below attached picture number 3.

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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



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 Michael Ng Phone: 15921845703, who represents the Office of Structural Materials for your project.

Inspected By: Gaikwad,Shailesh

Quality Assurance Inspector

Reviewed By: Clifford,William

QA Reviewer