

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-016990**Date Inspected:** 28-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:** Li Yang**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:** PQR Test Plates**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Dan Hernandez was present during the times noted above to observe the fit up, welding and related activities associated with the fabrication of the San Francisco Oakland Bay Self Anchored Suspension Bridge at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Weld Lab

This QA Inspector observed the welding of Procedure Qualification Record (PQR) HP2010116 using the Flux Cored Arc Welding (FCAW) process in the 1G (flat) position using Supercored 71H E71T1-1 electrode. The electrode is 1.4mm in diameter. The Welding Procedure Specification (WPS) followed was PWPS-B-T-2231. The test plate configuration was a Complete Joint Penetration (CJP) Single Bevel Groove weld Butt Joint, 50mm in thickness and 700mm in length using a 10mm x 100mm backing bar. The test plate material is identified as ZG230-450 (casting). The welder was identified as Liu Xie.

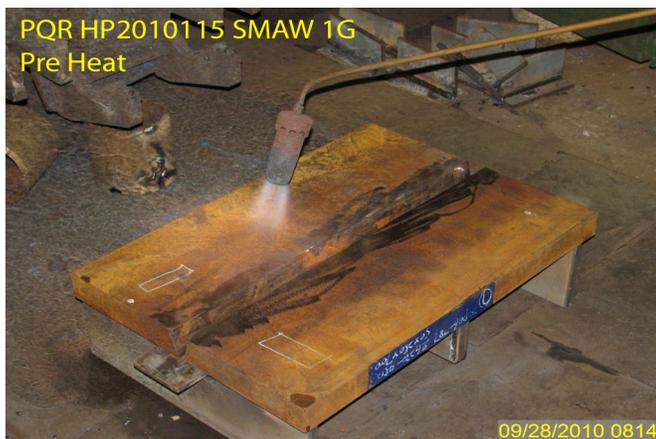
This QA Inspector observed the welding of Procedure Qualification Record (PQR) HP2010115 using the Shielded Metal Arc Welding (SMAW) process in the 1G (flat) position using TL-508 E7018-1 electrode. The electrode is 5mm in diameter. The Welding Procedure Specification (WPS) followed was PWPS-B-T-2211. The test plate configuration was a Complete Joint Penetration (CJP) Single Bevel Groove weld Butt Joint, 50mm in thickness and 700mm in length using a 10mm x 100mm backing bar. The test plate material is identified as ZG230-450 (casting). The welder was identified as Hu Luncai.

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ZPMC CWI Li Yang was present during PQR testing.

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



Summary of Conversations:

No relevant conversations.

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, 150-0042-2372 , who represents the Office of Structural Materials for your project.

Inspected By: Hernandez, Dan

Quality Assurance Inspector

Reviewed By: Peterson, Art

QA Reviewer