

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-017079**Date Inspected:** 29-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 11AE and Seg 11BE:

The Flux Cored Arc Welding (FCAW) process on weld joint no: OBW11-003. The welders are identified as 040367 and 047353 and were observed welding in the 1G position. ZPMC Quality Control (QC) was identified as Wang Li Yang. The welding variables recorded by QC appeared to comply with WPS: B-T-223(2)1T-2.

OBG Seg 11AW and Seg 11BW:

The FCAW process on weld joint no: OBW11B-004. The welders are identified as 040759 and 053316 and were observed welding in the 3G position. ZPMC QC was identified as Wang Zhu. The welding variables recorded by QC appeared to comply with WPS: B-T-2233-T.

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The FCAW process on weld joint nos: BP159-001-022, 024 and 026. The welder is identified as 040609 and was observed welding in the 3G position. ZPMC QC was identified as Wang Zhu. The welding variables recorded by QC appeared to comply with WPS: B-P-2233-B-U2-F.

OBG Seg 11AW:

The FCAW process on weld joint nos: BP051-001-043 to 046. The welder is identified as 066471 and was observed welding in the 2F position. ZPMC QC was identified as Wang Zhu. The welding variables recorded by QC appeared to comply with WPS: B-T-2132.

OBG Seg 11BW:

The FCAW process on weld joint nos: BP052-001-031 to 034. The welder is identified as 066471 and was observed welding in the 2F position. ZPMC QC was identified as Wang Zhu. The welding variables recorded by QC appeared to comply with WPS: B-T-2132.

OBG Seg 10W:

Notification No: 00500.

This QA Inspector did final tension verification for upper and lower Chevron bolting (from panel point 86 to panel point 94). Tension verification was done on random basis and at torque value of 480 Nm. Bolt sizes verified were as mentioned below:

- M22 x 70 DHGM 220028.
- M22 x 80 DHGM 220091.
- M22 x 70 DHGM 220038.

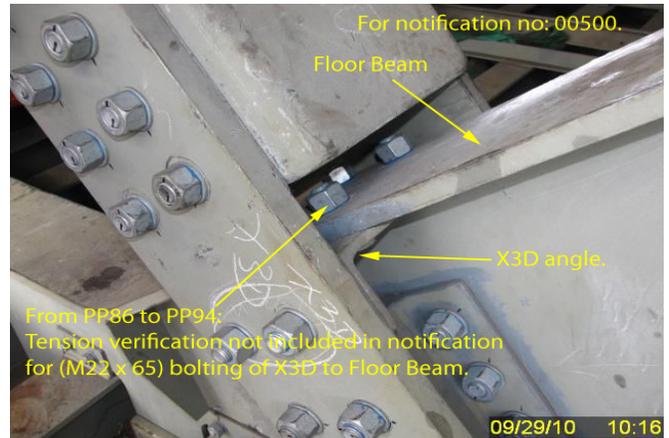
Torque verification was not done for M22 x 6 nos of bolts; for bolting of angle X3D with Lower Chevron and Floor Beam. See attached photos for further details.

Manual Torque wrench been used: Sr. No. XO2-776.

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