

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-017418**Date Inspected:** 14-Oct-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:

OBG Seg 10BE and Seg 10CE:

Notification no: 006947.

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC QC personnel. This QA Inspector generated a UT report on this date. The members are identified as OBG components. The weld designations reviewed are as follows:

- 1) DP702-001-041.
- 2) DP715-001-029.
- 3) EP168-001-014.
- 4) EP152-001-017.
- 5) SP712-001-032.
- 6) SP696-001-036.

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This QA Inspector observed the following work in progress:

OBG Seg 11AE:

Repair welding of weld joint no: SEG066A-014. Welding process was identified as Shielded Metal Arc Welding (SMAW). The welder was identified as 040320 and was observed welding in the 4G position. ZPMC QC was identified as Liu Hua Jie. The welding variables recorded by QC appeared to comply with WPS: 345-SMAW-4G(4F)-FCM-Repair-1. Repair welding was done as per Critical Welding Repair Report (CWR): B-CWR-2044 Rev-0. See attached photo for further details.

OBG Seg 10AW:

Repair welding of weld joint no: SSD25-PP87-032. Welding process was identified as SMAW. The welder was identified as 046709 and was observed welding in the 2G position. ZPMC QC was identified as Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with WPS: 345-SMAW-2G(2F)-Repair-1. Repair welding was done as per Welding Repair Report (WRR): B-WR-15952 Rev-0. See attached photo for further details.

OBG Seg 11AE:

The SMAW process on weld joint nos: BP132-001-053 and 054. The welder is identified as 053871 and was observed welding in the 2F position. ZPMC QC was identified as Liu Hua Jie. The welding variables recorded by QC appeared to comply with WPS: B-P-2112-FCM-1.

The SMAW process on weld joint nos: SP380-001-025 and 026. The welder is identified as 500363 and was observed welding in the 2F position. ZPMC QC was identified as Liu Hua Jie. The welding variables recorded by QC appeared to comply with WPS: B-P-2112-FCM-1.

OBG Seg 11BE:

The SMAW process on weld joint nos: BP133-001-041 and 042. The welder is identified as 053871 and was observed welding in the 2F position. ZPMC QC was identified as Liu Hua Jie. The welding variables recorded by QC appeared to comply with WPS: B-P-2112-FCM-1.

The SMAW process on weld joint nos: SP381-001-001 and 002. The welder is identified as 500363 and was observed welding in the 2F position. ZPMC QC was identified as Liu Hua Jie. The welding variables recorded by QC appeared to comply with WPS: B-P-2112-FCM-1.

OBG Seg 11AE and Seg 11BE:

The SMAW process on weld joint no: SP634-001-046. The welder is identified as 044515 and was observed welding in the 3G position. ZPMC QC was identified as Liu Hua Jie. The welding variables recorded by QC appeared to comply with WPS: B-P-2213-B-U2-FCM-1.

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



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