

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-017629**Date Inspected:** 27-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:

Notification no: 007134.

OBE 10:

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control (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) OBE10D-043 and 046

This QA Inspector observed the following work in progress:

OBG Seg 11BW and Seg 11CW:

The Shielded Metal Arc Welding (SMAW) process on weld joint no: OBW11B-008. The welders are identified as

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040656 and 046709 and were observed welding in the 4G position. ZPMC QC was identified as Zhou Peng. The welding variables recorded by QC appeared to comply with WPS: B-P-2214-B-U2-FCM-1. See attached photo for further details.

The SMAW process on weld joint no: OBW11B-007. The welder is identified as 041713 and was observed welding in the 4G position. ZPMC QC was identified as Zhou Peng. The welding variables recorded by QC appeared to comply with WPS: B-P-2214-B-U2-FCM-1. See attached photo for further details.

The SMAW process on weld joint no: DP693-001-019. The welder is identified as 040611 and was observed welding in the 3G position. ZPMC QC was identified as Shi Lei. The welding variables recorded by QC appeared to comply with WPS: B-T-3213-B-U3b.

The SMAW process on weld joint no: DP679-001-021. The welder is identified as 046704 and was observed welding in the 3G position. ZPMC QC was identified as Shi Lei. The welding variables recorded by QC appeared to comply with WPS: B-T-3213-B-U3b.

The SMAW process on weld joint no: SP664-001-031. The welder is identified as 057333 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: B-P-2214-B-U2-FCM-1.

OBG Seg 11BE and Seg 11CE:

The SMAW process on weld joint no: OBE11B-008. The welder is identified as 053871 and was observed welding in the 4G position. ZPMC QC was identified as Zhou Peng. The welding variables recorded by QC appeared to comply with WPS: B-P-2214-B-U2-FCM-1.

Blast Shop 1:

Cross Beam 13 (CB13):

This QA Inspector performed random visual inspection of CB13 after grit blasting. Inspection was done only for the external surfaces of Bottom panel, Deck panel, East side panel and the West side panel of this CB. Areas identified for any grinding and / or welding were marked and informed to ZPMC personnel. Also the same were recorded on the drawings / weld maps and was submitted to the Task Leader for review.

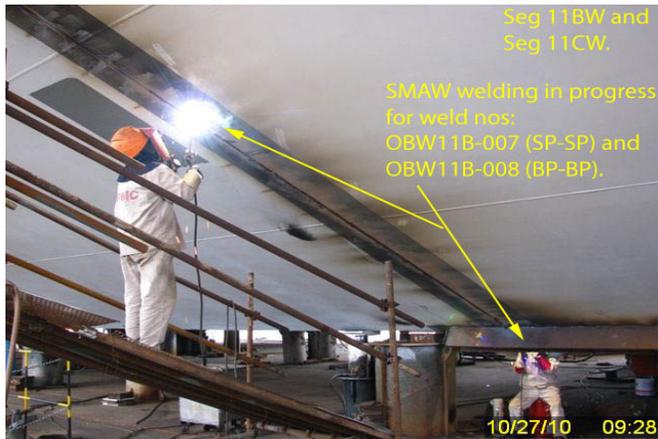
Cross beam 14 (CB14):

This QA Inspector performed random visual inspection of CB14 after grit blasting. Inspection was done for both; internal and external surfaces of this CB. Areas identified for any grinding and / or welding were marked and informed to ZPMC personnel. Also the same were recorded on the drawings / weld maps and was submitted to the Task Leader for review.

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:	Dsouza,Christopher	QA Reviewer
