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 #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-018658
Date Inspected: 16-Nov-2010

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 1500
OSM Departure Time: 300
Location: ShangHai, China

CWI Name: Tian Lei

Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**CWI Present:**	☑ Yes	☐ No		
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A	
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A	
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☑ Yes	☐ No	☐ N/A	
				Approved WPS:	☑ Yes	☐ No	☐ N/A	
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A	

Bridge No: 34-0006
Component: OBG

Summary of Items Observed:

Summary of Items Observed: On this date Caltrans OSM Quality Assurance(QA) Inspector, DJ Shin was present during the times noted above for observations relative to the work being performed.

Bay 1
This QA Inspector observed the following work in progress for Bay 1.
ZPMC was using the Flux Core Arc Welding (FCAW) process.
ZPMC QC is identified as Zhu Jun.
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).
Listed below are the locations that were identified by this QA inspector.

Components: Barrier Rail
PCMK: E5-SB1C-048
Welder: 059450
WPS-B-T-2132-3

Bay 2
This QA Inspector observed the following work in progress for Bay 2.
ZPMC was using the Flux Core Arc Welding (FCAW) process.
ZPMC QC is identified as Zhu Jun.
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).
Listed below are the locations that were identified by this QA inspector.

Components: Segment Assembly
PCMK: SEG3020K-012
Welder: 045240
WPS-B-T-2233-TC-U5-F

PCMK: SEG3020K-049
Welder: 048696
WPS-B-T-2233-TC-U5-F

PCMK: SEG3020K-054
Welder: 044227
WPS-B-T-2233-TC-U5-F

Components: Grillage Plate
PCMK: SA7512-001-035
Welder: 066734
WPS-B-T-2233-TC-U5-F

PCMK: SA7512-001-049
Welder: 066443
WPS-B-T-2233-TC-U5-F

PCMK: SA7512-001-063
Welder: 066421
WPS-B-T-2233-TC-U5-F

Bay 3
This QA Inspector observed the following work in progress for Bay 3.
ZPMC was using the Flux Core Arc Welding (FCAW) process.
ZPMC QC is identified as Tian Lei.
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).
Listed below are the locations that were identified by this QA inspector.

Components: Segment Assembly
PCMK: SEG3019K-266
Welder: 052696
WPS-B-T-2233-TC-U5-F

PCMK: SEG3019K-270
Welder: 055564
WPS-B-T-2233-TC-U5-F

PCMK: SEG3019K-208,209

Welder: 066236
WPS-B-T-2232-TC-U5-F

PCMK: SEG3019K-101,102
Welder: 668206
WPS-B-T-2232-TC-U5-F

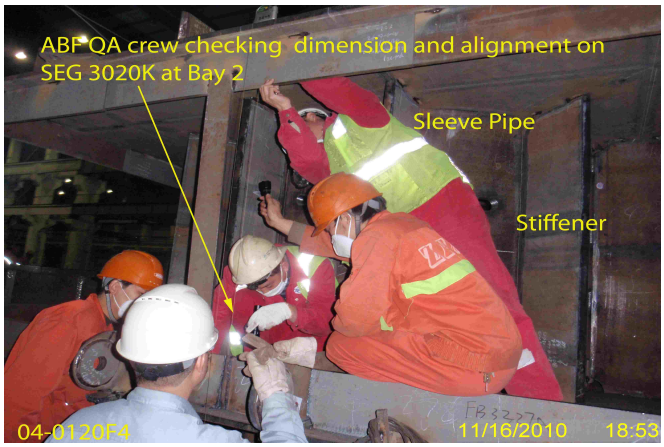
PCMK: SEG3019K-197,198
Welder: 066349
WPS-B-T-2232-TC-U5-F

Components: Floor Beam
PCMK: FB32286-0011-330
Welder: 044830
Report: B-WR16798
WPS-345-FCAW-3G (3F)-Repair

This QA inspector performed Ultrasonic Testing (UT) of approximately 10 % of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member(s) is/are identified as follows; LD3040-001,
Item number 1 of NWIT tracker document # 07382,

Bay 6
Heat straightening of PCMK, DP3168-001, under approved Heat Straightening procedure, HSR (B)-433,The in process temperature was at the time of this observation witnessed at less than 600°C. The ZPMC QC was identified as Huang Min. The approved HSR procedure stated that a maximum temperature of 600°C, with 1-3 applications. The distortion that was previously measured and recorded on the HSR was Maximum 75mm..

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



WELDING INSPECTION REPORT

(Continued Page 4 of 4)

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 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Shin,DJ	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer