

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-018688**Date Inspected:** 22-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**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:** Tower and OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA Inspector) George Goulet was present during the times noted above for observations relative to the work being performed.

OBG Trial Assembly Area

This QA Inspector randomly observed the following work in progress in the OBG Trial Assembly Area:

SMAW repair welding of weld joint SEG068A-044 located outside PCMK OBG 11BE/11CE, side plate to bottom plate, south (bikepath) side, holdback weld. Welder was identified as 053871. QC was identified as ZPMC CWI Zhu Yuan Yuan (QC1). Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC Lead CWI Gu Rong Jian (QC2). Welding variables recorded by QC1 appeared to comply with WPS-345-SMAW-4G(4F)-FCM-repair as displayed on ZPMC Weld Repair Report B-CWR2217 presented to this QA Inspector and verbally identified by QC1. See photo below of page 1 of the weld repair report. Note the preheat and postheat temperatures at the bottom of the page. The thickness of the plates being welded was less than 40mm, therefore the required minimum preheat and postheat temperatures was 160°C. ZPMC Weld Repair Report B-CWR2217 referred to ZPMC NDT Report UT-11E-048R4. Also present at this location and appearing to be monitoring the welding operation was ABF Representative Cai Hai Zhou.

No other welding was observed being performed in the Trial Assembly Area on this night.

Heavy Dock

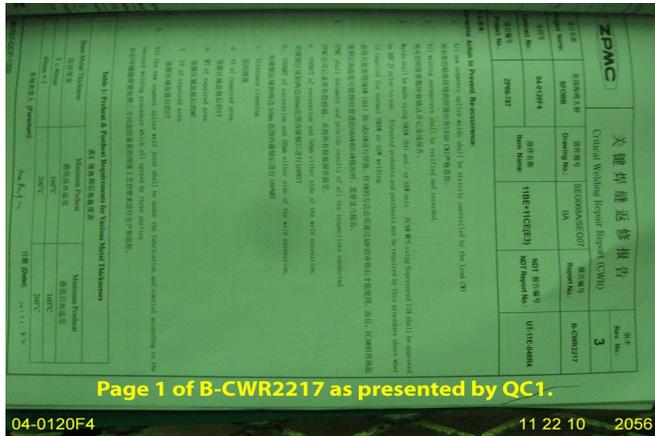
This QA Inspector randomly observed the following on the Heavy Dock:

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

All 4 towers, lift 4 were positioned on a base pedestal at end of the Heavy Dock. All four towers, lift 5 were positioned on top of the respective lift 4. No work was being performed on the Heavy Dock and no floating crane was in the area of the Heavy Dock.

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



Summary of Conversations:

As noted above.

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 Micheal Ng, 159-2184-5703, who represents the Office of Structural Materials for your project.

Inspected By: Goulet, George Quality Assurance Inspector

Reviewed By: Carreon, Albert QA Reviewer