

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-018736**Date Inspected:** 13-Dec-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:** Mr. 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:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Shailesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector observed the following work in progress:

OBG TRIAL ASSEMBLY**OBG Segment 12AW**

This QA Inspector observed ZPMC qualified welding personnel identified as 045268 Perform Shielded Metal Arc Welding (SMAW) on OBG segment 12AW panel point 110.5 Angle stiffener to corner assembly X74 C plate to X37L. Joint identified as SEG3004N-001. ZPMC QC Identified as Zhang Qiang. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2112, WPS-B-P-2113 and WPS-B-P-2114. For more information see below attached picture number 1.

This QA Inspector observed ZPMC qualified welding personnel identified as 045268 Perform Shielded Metal Arc Welding (SMAW) on OBG segment 12AW panel point 110.5 Angle stiffener to corner assembly X74 D plate to X37L. Joint identified as SEG3004N-002. ZPMC QC Identified as Zhang Qiang. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2112, WPS-B-P-2113 and WPS-B-P-2114.

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OBG U Rib Splice plate Repair welding:

This QA Inspector observed ZPMC qualified welding personnel identified as 046709 Perform Shielded Metal Arc Welding (SMAW) on OBG U Rib splice plate. Joint identified as USPL1-655-001 repair on U rib after Ultrasonic testing. ZPMC QC Identified as Zhao Peng with temporary welding repair report WRR-B-WR 19044. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-1G (1F)-FCM-Repair-1. For more information see below attached picture number 2.

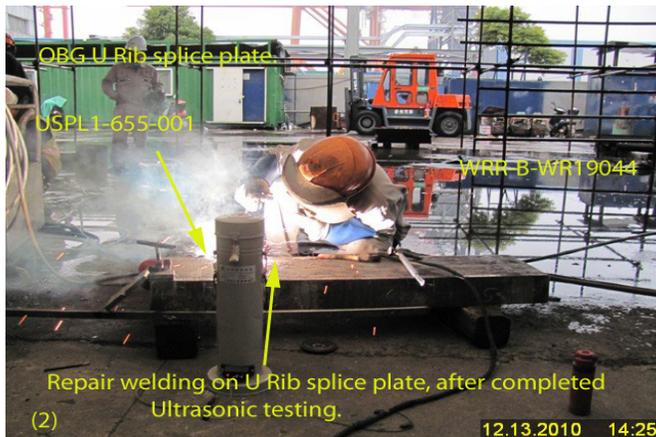
Magnetic Particle Testing:

This QA Inspector observed AB/F Magnetic particle testing inspector performing MT on repair area marked by Ultrasonic Testing of OBG U Rib splice plate gouged area. Joint identified as UPSL1-655-001, 002. For more information see below attached picture number 3.

Magnetic Particle Testing:

This QA Inspector observed AB/F Magnetic particle testing inspector performing MT on Traveler rail brackets of OBG panel point 104.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



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Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

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 :150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Shailesh	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
