

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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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-019270**Date Inspected:** 26-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:** Qiu Wen.**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 Inspector observed and/or found the following:

Bay 7:

Notification No: 007933.

Cross Beam 19 (CB19):

This QA Inspector performed visual inspection of the welds of CB19. Observations are as mentioned below:

- Welding (after back gouging) not completed for two (2) nos of welds (one on CB3003J and another on CB3003K-001).
- One MT linear indication (toe-crack) was observed on I-rib stiffener to Floor Beam (CB3003K-001) on Bottom Panel BP3097A.
- Approx 3mm under-fill was observed in FB3344 to Intermediate Panel, fillet weld on CB3003K-001.
- See attached photos for further details.

Bay 14:

This QA Inspector observed the following work in progress:

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OBG Seg 14W:

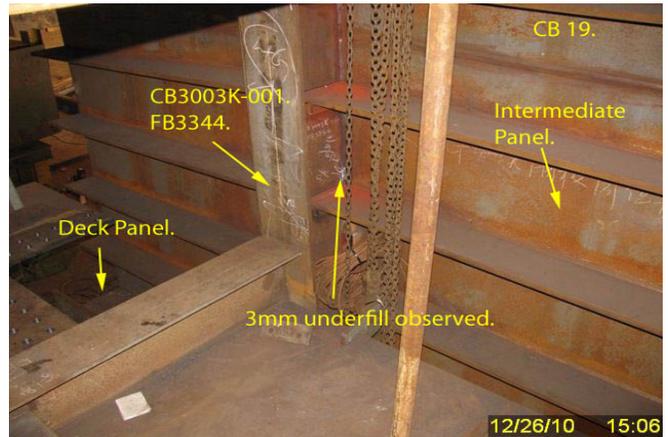
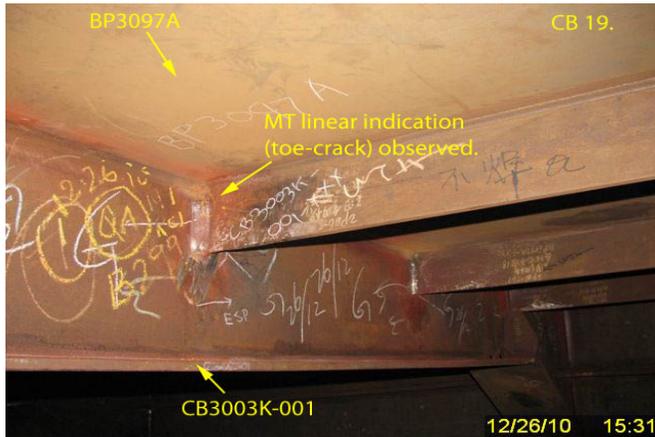
The Flux Cored Arc Welding (FCAW) process on weld joint nos: SEG3020K-007 and 018 [Longitudinal Diaphragm (LD) 3050A to SA3409A, complete joint penetration (CJP) weld, at PP127.3]. The welder is identified as 066239 and was observed welding in the 3G position. ZPMC Quality Control (QC) was identified as Zhang Lin. The welding variables recorded by QC appeared to comply with WPS: B-T-2233-ESAB.

The Shielded Metal Arc Welding (SMAW) process on weld joint no: SEG3020D-062 [I-rib on Floor beam (FB) 3343A to LD3051A, CJP weld, at PP128.3]. The welder is identified as 066038 and was observed welding in the 1G position. ZPMC QC was identified as Zhang Lin. The welding variables recorded by QC appeared to comply with WPS: B-P-2214-TC-U4b-FCM-1.

The SMAW process on weld joint no: SEG3020Z-050 (I-rib stiffener to LD, fillet weld, at PP125). The welder is identified as 068917 and was observed welding in the 4F position. ZPMC QC was identified as Zhang Lin. The welding variables recorded by QC appeared to comply with WPS: B-P-2114.

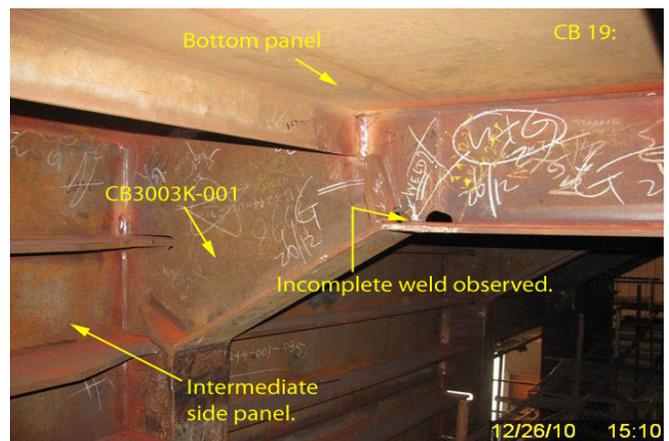
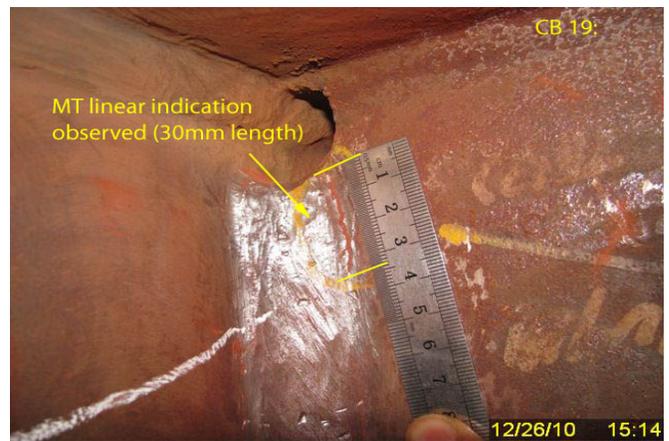
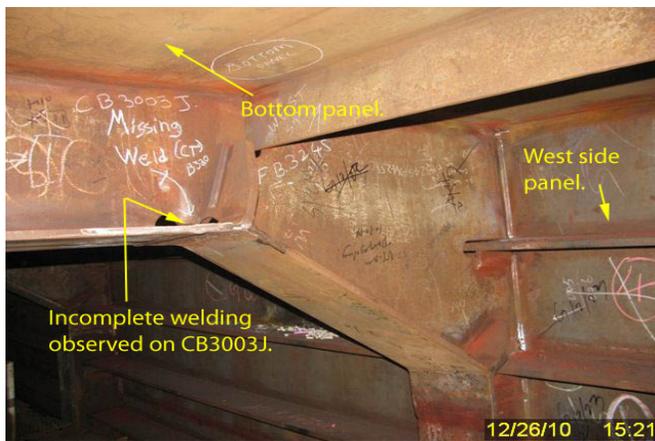
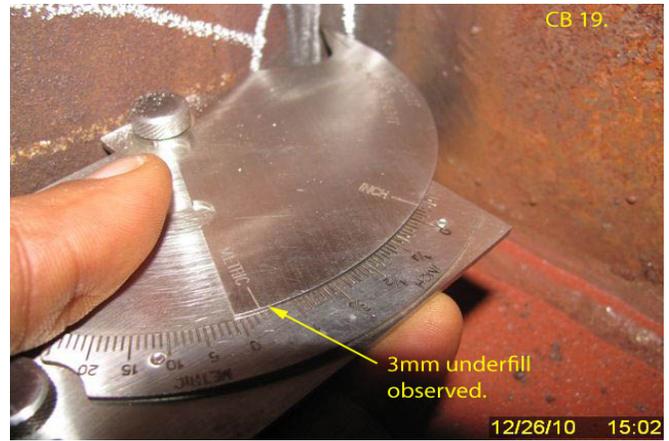
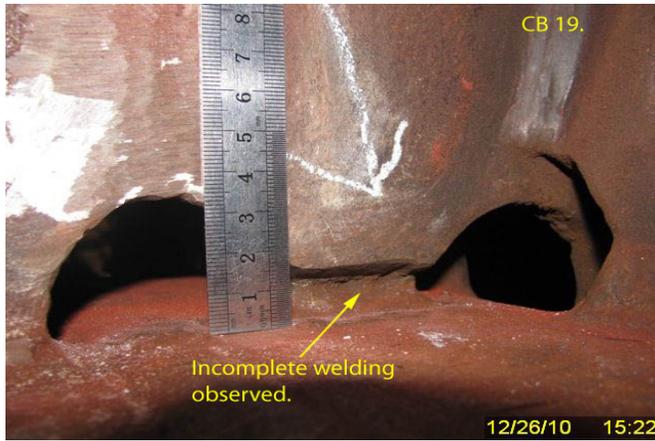
The FCAW process on weld joint no: SEG3020D-020 [FB3342A to Side Panel (SP), fillet weld, at PP128.3]. The welder is identified as 202122 and was observed welding in the 3F position. ZPMC QC was identified as Zhang Lin. The welding variables recorded by QC appeared to comply with WPS: B-T-2133-ESAB.

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.

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Inspected By:	Wadkar,Sailesh	Quality Assurance Inspector
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Reviewed By:	Patterson,Rodney	QA Reviewer
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