

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-019432**Date Inspected:** 05-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Shi Lei (east) Bao Lei Zhang (west)			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 Deck Panels		

Summary of Items Observed:

On this day Caltrans OSM Quality Assurance (QA) Inspector Kenneth Riley 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 Chang Xing Island in Shanghai, China.

Bay 9

On this date the QA inspector was present at ZPMC to witness the welding of U-Ribs to Deck plates for two (2) deck panels with the following identification numbers, DP3137(PL3333B)-001 and DP3137(PL3333A)-001. It was observed that ZPMC had 4 welders at gantry #2, welders identifications and the welds that were welded by each welder per deck panel are as follows;

DP3137(PL3333A)-001

059416-W001 / 201788-W002 / 203805-W005, W003 / 059378-W004, W006 / 059418-W007 / 059371-W008

DP3137(PL3333A)-001

059416-W145 / 201788-W146 / 203805 -W147, W149 / 059378-W148, W150 / 059418-W151 / 059371-W152

DP3130(PL3326A)-001

059378-W001, W003 / 203805-W002, W004 / 201788-W005 / 059416-W006

DP3130(PL3326B)-001

059378-W111, W113 / 203805-W112, W114 / 201788-W115 / 059416-W116

ZPMC had a CWI Quality control personnel onsite who was identified as Zhao Cheng Jian and ABF personnel Shao Jian Yuan. The Deck Panels that were being welded are SPMC material and the following Welding

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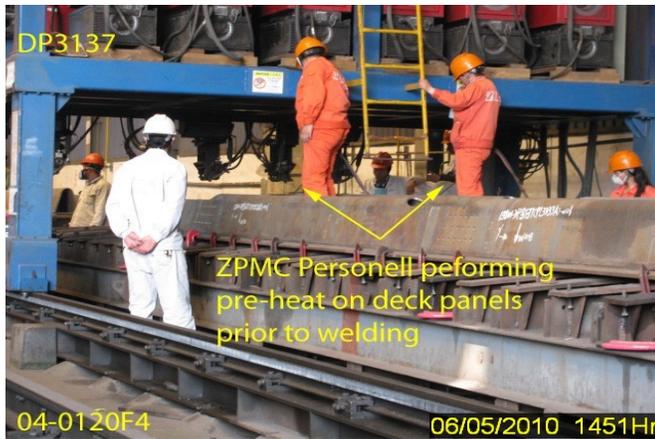
(Continued Page 2 of 3)

Procedure Specification (WPS) was followed; WPS-B-T-2342-U1-Rev 5, which includes a 60 degree celsius minimum preheat for welding which this QA inspector had witnessed and observed. During the welding of the GMAW root pass on Deck Panel DP3137 plate A, the equipment malfunctioned and the welding had stopped at a Y location of 2560mm for weld W008 at approximatley 1000 hrs. It was determined that the welding tip was clogged which prevented the wire from traveling freely through the tip. At Approximately 1300 hrs the area was ground and Magnetic Particle (MT) was performed by ZPMC Quality Control (QC) personnel. ZPMC and ABF representitives witnessed this process and agreed with the acceptable results. ZPMC completed the welding process of the above stated Deck Panels at aproximatley 1600hrs.

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

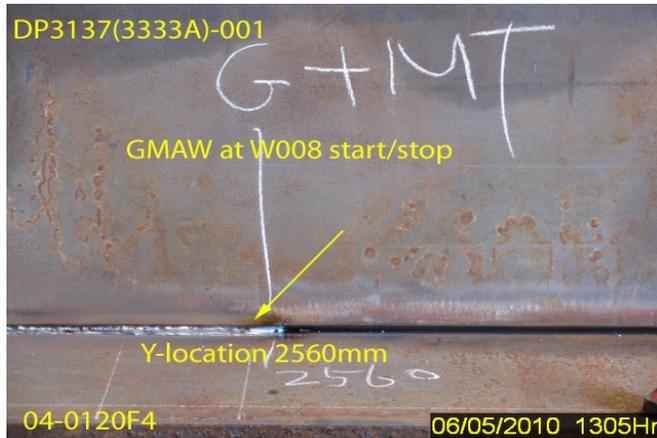
Summary of Conversations:

No Conversations This date.



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(Continued Page 3 of 3)



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:	Riley, Ken	Quality Assurance Inspector
Reviewed By:	Carreon, Albert	QA Reviewer
