

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-019723**Date Inspected:** 03-Jan-2011**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 14:

Notification no: 008030.

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector has generated MT report for this date. The members are identified as OBG components. The weld designations MT inspected are as follows:

- 1) SA3168-035 to 052, 337 to 343, 354 to 356.
- 2) SEG3013D-200, 201.

Notification no: 008032.

This QA inspector performed MT of approximately 15% of an area that has been previously tested and accepted by ZPMC QC personnel. This QA Inspector has generated MT report for this date. The members are identified as

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

OBG components. The weld designations MT inspected are as follows:

- 1) SA3168-243, 244, 245, 246, 247, 248.
- 2) SEG3013M-221, 222, 226, 227, 231, 232, 236.
- 3) SEG3013M-228, 233, 243, 248.
- 4) SEG3013M-052.
- 5) SEG3013Q-069.

Notification no: 008027.

This QA inspector performed MT of approximately 15% of an area that has been previously tested and accepted by ZPMC QC personnel. This QA Inspector has generated MT report for this date. The members are identified as OBG components. The weld designations MT inspected are as follows:

- 1) SEG3013E-020,025,030,035.

OBG Seg 14W:

During random inprocess visual inspection, this QA Inspector observed that some of the tack welds of Deck Panel (DP) Diaphragm to U-ribs were cracked. This was informed to ZPMC CWI Liming Yang. ZPMC QC informed that they will perform visual inspection of all the tack welds. The cracked tack welds will be removed and then the area will be MT tested before performing welding of U-rib to DP Diaphragm. See attached photos for reference.

During random inprocess visual inspection, this QA Inspector that R30 cope holes are not provided on FB3323B at PP126.5. This is informed to ZPMC QC Sun Tian Liang. See attached photos for reference.

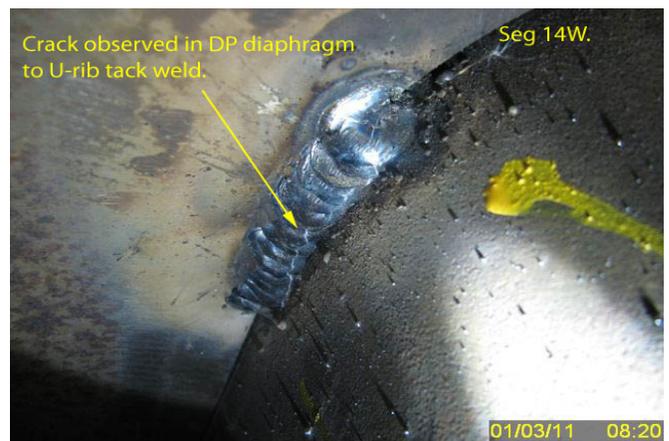
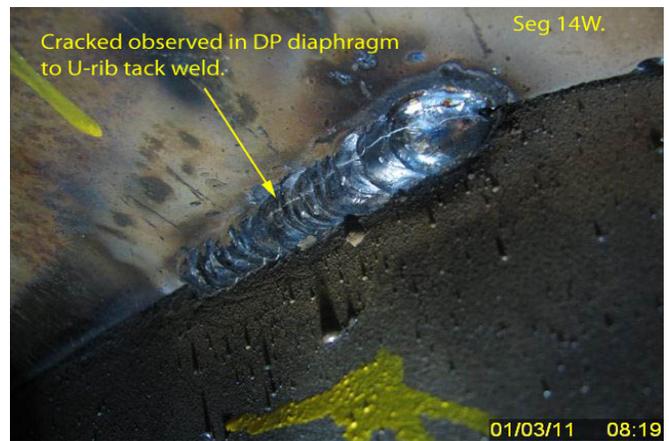
OBG Seg 13AW:

This QA Inspector observed that the back gouging is done for I-ribs (on Side Panel) to Floor Beam (FB) 3191A, complete joint penetration (CJP) welds (at PP119+1500). However, for weld no: SEG3013F-064, crack was observed after back gouging. This QA Inspector informed about this to ZPMC CWI Liming Yang. ZPMC will be submitting CWR, before proceeding welding of this joint. See attached photos for reference.

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

WELDING INSPECTION REPORT

(Continued Page 3 of 4)



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.

WELDING INSPECTION REPORT

(Continued Page 4 of 4)

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