

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-019734**Date Inspected:** 14-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:

This QA Inspector observed the following work in progress:

OBG Seg 13AW:

During random inprocess visual inspection, this QA Inspector observed that the welding of Bearing stiffener – X4322W (at Floor Beam 3192A) and RS3478B (PP119+1500) is done. However, the gap between X4322W and RS3478B was observed as 6mm. This is informed to CT Lead QA Inspector and also referred to Design. See attached photos for further information.

During random inprocess visual inspection of RS Flanges welded with Floor Beams, this QA Inspector observed the following:

1) At PP118.35 (W4 side), FB3181A to Flange of RS3477B, complete joint penetration (CJP) weld, the gap between backing bar and RS flange was observed as 7.5mm. Welding of this joint is completed (as per weld

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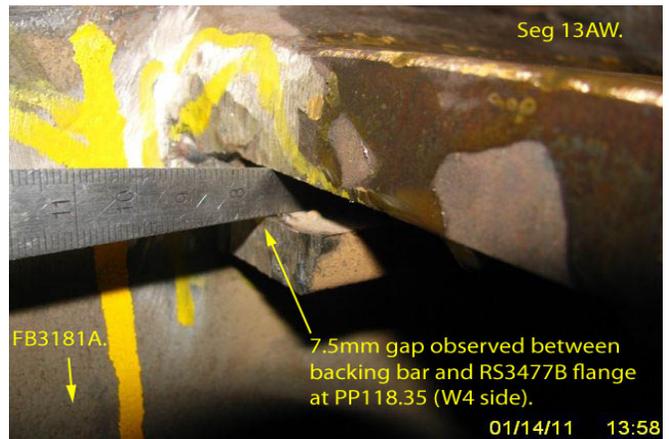
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details, backing bar to remain in place after welding). See attached photos for further information.

2) At PP118.35 (W3 side), FB3181A to Flange of RS3477A, CJP weld, the gap between backing bar and RS flange was observed as 7mm. Welding of this joint is completed (as per weld details, backing bar to remain in place after welding). See attached photos for further information.

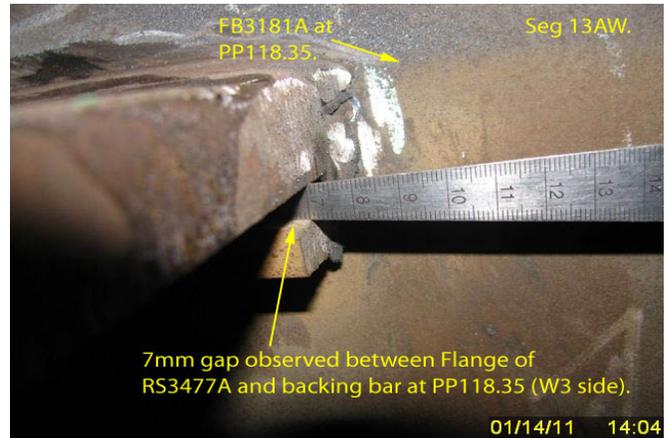
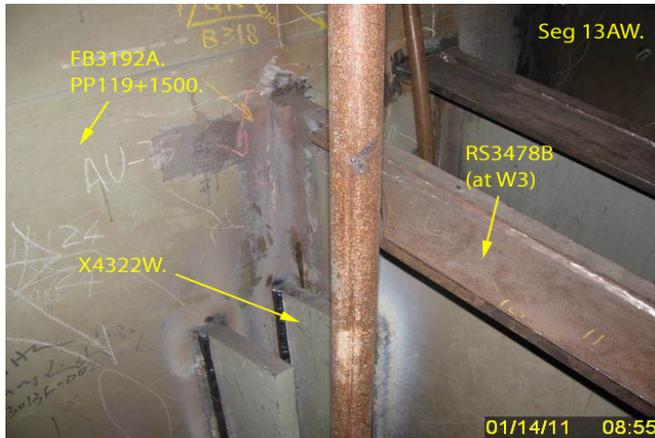
NDT of the above mentioned two welds is to be done. This is also informed to CT Lead QA Inspector.

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.

Inspected By: Wadkar,Sailesh

Quality Assurance Inspector

Reviewed By: Patterson,Rodney

QA Reviewer