

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 #: xx.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020782**Date Inspected:** 04-Jul-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. Wu Zhi Zang.**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 Trial Assembly**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Raghavendra Reddy 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 Changing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector observed the following work in progress:

SEGMENT # 9AE & 9AW:

Shielded Metal Arc Welding (SMAW) welding of welds joint 9AW-SEG049A-012(BP to SP Crossbeam side).

And Critical welding Repair Report (CWR) B-CWR-1695, Welder is identified as 045196. ZPMC Quality Control (QC) is identified as Mr. Shan Hai Tao. The welding variables appeared to comply with the Applicable WPS: WPS-345-SMAW-4G (4F)-Repair-1.

SMAW welding of weld joint 9BW-SEG051A-045(BP to SP Crossbeam side). Welder is identified as 045196. ZPMC Quality Control (QC) is identified as Mr. Shan Hai Tao. The welding variables appeared to comply with the Applicable WPS: WPS-345-SMAW-4G (4F)-Repair-1.

SMAW welding of weld joint OBW9-002(9AW-9BW, DP to DP). Welding Repair Report (WR) B-WR-13910. Welder is identified as 037723. ZPMC Quality Control (QC) is identified as Mr. Zang Hai Tao. The welding variables appeared to comply with the Applicable WPS: WPS-345-SMAW-4G (4F)-FCM-Repair-1.

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SMAW welding of weld joint OBW9-003(9AW-9BW, DP to DP).And welding Repair Report (WR) B-WR-13911.

Welder is identified as 045196. ZPMC Quality Control (QC) is identified as Mr. Zang Hai Tao. The welding variables appeared to comply with the Applicable WPS: WPS-345-SMAW-4G (4F)-FCM-Repair-1.

SMAW welding of weld joint OBW9-004(9AW-9BW, DP to DP).And welding Repair Report (WR) B-WR13912.

Welder is identified as 045196. ZPMC Quality Control (QC) is identified as Mr. Zang Hai Tao. The welding variables appeared to comply with the Applicable WPS: WPS-345-SMAW-4G (4F)-FCM-Repair-1.

Flux Cored Arc Welding (FCAW) of Buttering for the weld joint LD12 B on Segment #9E, Panel Points (PP) 76-77, longitudinal diaphragm repair area. Welder is identified as 220069. ZPMC Quality Control (QC) is identified as Mr. Wu Zhi Zang. The welding variables appeared to comply with the Applicable WPS: WPS-345-FCAW-1G (1F)-Repair-1.

And during surveillance observed some gouging & grinding activity of UT Repair spots for the Weld no-0BE9-008, and

The ZPMC QC Identified as Wu Zhi Zang was monitoring the in-process activity.

Segment # 8W:

This QA observed that no significant work was being performed on this segment during the time QA was present,

Segment # 7E:

This QA observed that ZPMC is Continuing the temporary structural fit up for shipment on this segment during the

Time QA was present.

Segment # 7W:

This QA observed that no significant work was being performed on this segment during the time QA was present.

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

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 Michael Ng (15921845703), who represents the Office of Structural Materials for your project.

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| Inspected By: | Tharikoppada,Reddy | Quality Assurance Inspector |
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| Reviewed By: | Miller,Mark | QA Reviewer |
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