

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-021584**Date Inspected:** 12-Feb-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:** Mr. Xu Le Feng.**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:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

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

This QA Inspector observed the following work in progress:

Back Gouging:

This QA Inspector observed ZPMC personnel identified in Bay 10, Performing Back gouging on backing plate of OBG suspender bracket, the plate were completed buttering from other side. Plate identified as BK17, (BKX51A). For more information see attached picture number 1.

Bay 14, WELDING:**SMAW Process:**

This QA Inspector observed ZPMC qualified welding personnel identified as 067949, Perform Shielded Metal Arc Welding (SMAW) on OBG Segment. Joint identified as SEG3020BC-011. ZPMC QC Identified as Mr. Zhulin. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2112-FCM-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 066734, Perform Shielded Metal Arc

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Welding (SMAW) on OBG Segment. Joint identified as SEG3020BC-013. ZPMC QC Identified as Mr. Zhulin. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2112-FCM-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 067904, Perform Shielded Metal Arc Welding (SMAW) on OBG Segment. Joint identified as SEG3020U-588. ZPMC QC Identified as Mr. Wang xiang pin. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2212-TC-U4b-FCM-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 037779, Perform Shielded Metal Arc Welding (SMAW) on OBG Segment. Joint identified as DP3173-001-021. ZPMC QC Identified as Mr. Shen jian. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2212-TC-U4b-FCM-1.

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 Thomas Ho: 150002048250, who represents the Office of Structural Materials for your project.

Inspected By: Gaikwad,Shailesh

Quality Assurance Inspector

Reviewed By: Clifford,William

QA Reviewer