

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-023465**Date Inspected:** 05-May-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. Liu hua jie**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:**

This CALTRANS OSM Quality Assurance Inspector (QA) Surendra Prabhu 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 observed and/or found the following:

OBG Trial Assembly open yard.

Segment: 13AW

This QA Inspector randomly observed the following work in progress:

Shielded Metal Arc Welding (SMAW) repair welding of weld joint identified as SEG3013M-192. Welder is identified as 066019. ZPMC QC is identified as Mr. Shen jian bo. The welding variables recorded by QC personnel observed appeared to comply with Welding Procedure Specification (WPS): WPS-345-SMAW-3G (3F)-FCM-repair-1. The repair welding was being performed as per Welding Repair Report No: B-WR20695.

SMAW repair welding of weld joint identified as SEG3013AH-098. Welder is identified as 067609. ZPMC QC is identified as Mr. Shen jian bo. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-345-SMAW-4G (4F)-FCM-repair-1. The repair welding was being performed as per WRR No: B-WR20812.

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SMAW repair welding of weld joint identified as AH3001-059. Welder is identified as 067904. ZPMC QC is identified as Mr. Shen jian bo. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-345-SMAW-4G (4F)-FCM-repair-1. The repair welding was being performed as per WRR No: B-WR20812.

Flux Cored Arc Welding (FCAW) repair welding of weld joint identified as SEG3013X-022. Welder is identified as 048696. ZPMC QC is identified as Mr. Shen jian bo. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-345-FCAW-3G (3F)-ESAB-repair-FCM. The repair welding was being performed as per WRR No: B-WR20648.

FCAW repair welding of weld joint identified as SEG3013M-123. Welder is identified as 048433. ZPMC QC is identified as Mr. Shen jian bo. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-345-FCAW-3G (3F)-ESAB-repair-FCM. The repair welding was being performed as per WRR No: B-WR20695.

AB/F QA Inspector performing Ultrasonic Testing for the weld joining to bottom plate to side plate at Panel Point 119 FL3 location cross beam side. See attached photos 1 and 2 for further details.

ZPMC personnel removing weld tabs for the welds joining to I rib stiffener to floor beam by using manual cutting device at PP#119+1500 area. See attached photos 3 and 4 for further details.

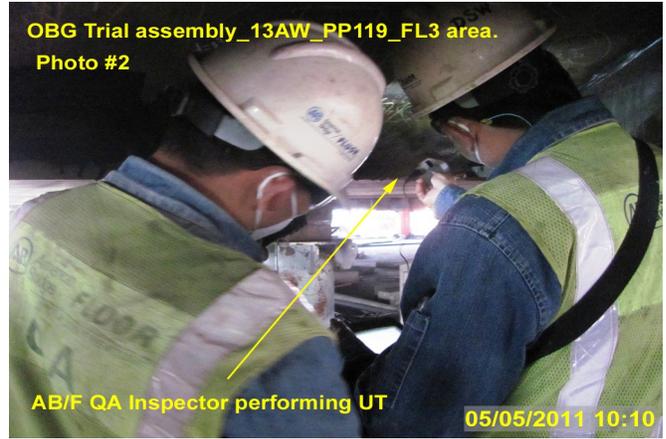
During random in process visual inspection of OBG PP#118.35, this QA observed 1 longitudinal toe crack measuring approximately 50 mm in length. The weld joint is identified as SEG3013U-011. The weld is fillet weld. This QA marked the affected area and informed ZPMC Quality Control (QC) identified as Mr. Shen jian bo of this issue. Mr. Shen jian bo informed this QA that the crack would be corrected in a manner compliant with the contract documents. This QA Inspector also informed to shop Lead QA Inspector of the issue. See attached photos 5 and 6 for further details.

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 15000422372, who represents the Office of Structural Materials for your project.

Inspected By: Prabhu,Surendra

Quality Assurance Inspector

Reviewed By: Peterson,Art

QA Reviewer