

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-023470**Date Inspected:** 07-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 | | |
| Inspected CWI report: | Yes | No | N/A |
| Electrode to specification: | Yes | No | N/A |
| Qualified Welders: | Yes | No | N/A |
| Approved Drawings: | Yes | No | N/A |

| | | | |
|----------------------------------|-----|----|-----|
| CWI Present: | Yes | No | |
| Rod Oven in Use: | Yes | No | N/A |
| Weld Procedures Followed: | Yes | No | N/A |
| Verified Joint Fit-up: | 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 AH3001-004. Welder is identified as 067904. ZPMC QC is identified as Mr. Zhang lin. 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 (WRR) No: B-WR20882.

SMAW repair welding of weld joint identified as SEG3013D-090. Welder is identified as 067609. ZPMC QC is identified as Mr. Zhang lin. 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 WRR No: B-WR20606.

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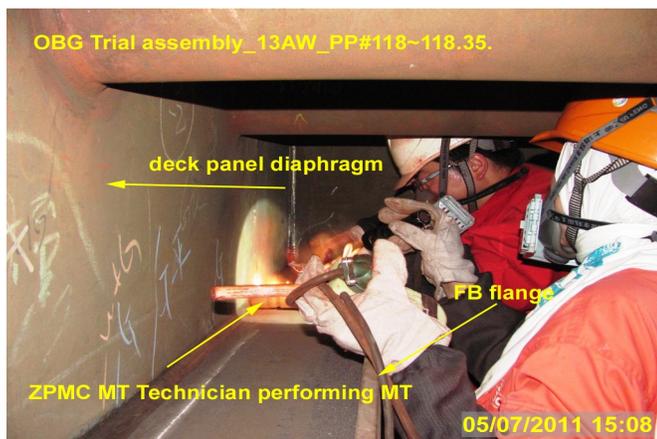
SMAW welding of weld joint identified as SEG3013T-015. Welder is identified as 205048. ZPMC QC is identified as Mr. Zhang lin. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-B-P-2112-FCM-1.

SMAW welding of weld joint identified as SEG3013U-015. Welder is identified as 067184. ZPMC QC is identified as Mr. Zhang lin. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-B-P-2112-FCM-1.

Flux Cored Arc Welding (FCAW) repair welding of weld joint identified as SEG3013F-068. Welder is identified as 203871. ZPMC QC is identified as Mr. Zhang lin. 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-WR20606.

ZPMC MT Technician performing Magnetic Particle Testing for the weld joint joining to deck panel diaphragm to floor beam flange at panel points 118 and 118.35 cross beam side. See attached photos for further details.

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



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