

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-024149**Date Inspected:** 24-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:** 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:** 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:

Trial Assembly Yard:

This QA Inspector observed the following work in progress:

OBG Seg 13CW:

ZPMC personnel performing heat straightening on Longitudinal Diaphragm (LD) 3036, at Panel Point (PP) 122.5. Heat straightening was done as per heat straightening report (HSR) no: 10383. ZPMC Quality Control (QC) was identified as Shi Lei. See attached photo for details.

ZPMC personnel performing fit-up of Deck Panel (DP) 3155A with Architectural Housing (AH) 3003A. Photo attached for details.

OBG Seg 14W:

During random in-process visual inspection of the welds on this segment, this QA Inspector observed a toe crack

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

at weld joint no: Seg3020Z-023 (at PP126 – PP126.5). Also weld no: Seg3020Z-055 was observed to be cracked. See attached photos for details. This QA Inspector informed the ZPMC CWI, identified as Zhu Lin regarding the locations of the cracked welds. The ZPMC QC Inspector agreed to submit a Critical Welding report (CWR) prior to repairing these welds.

Blasting Inspection:

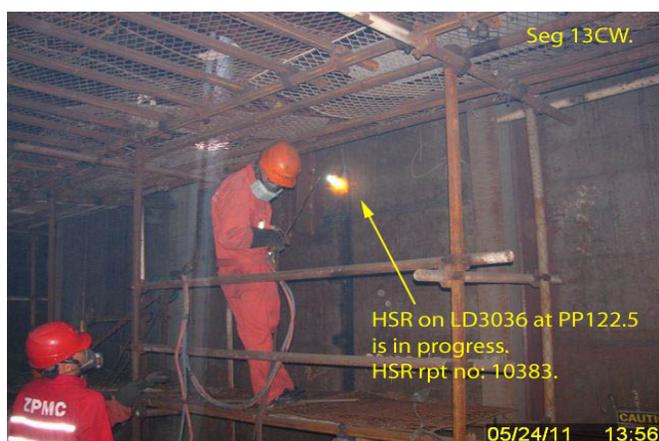
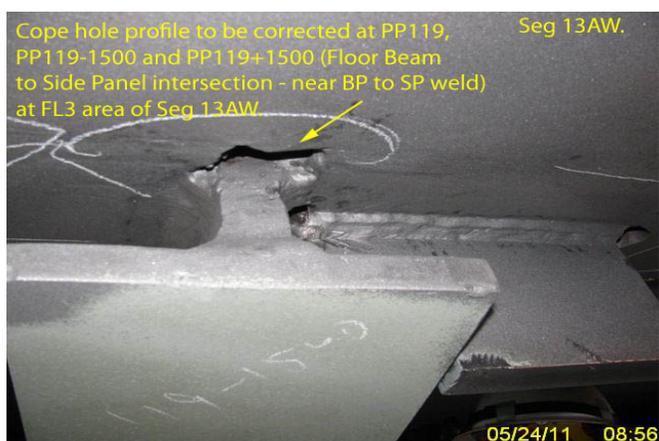
OBG Seg 13AW:

Blast inspection was performed on weld joint no's: Seg 3013A-010 to 017 [Bottom Panel (BP) to Side Panel (SP) complete joint penetration (CJP) welds, from panel point (PP) 117.5 to PP120], external surfaces of BP3056A (at PP120, PP119+1500 and PP119-1500) and the Side Panel (SP) 3092E. It was observed that the Ultrasonic Testing (UT) of the above mentioned weld no's has yet to performed by QC. Also, the Floor Beam (FB) to Side Panel (SP) cope holes (at PP119, PP119-1500 and PP119+1500) need to be profiled correctly. These locations were identified and informed to ZPMC CWI, identified as Mr. An Qing Xiang. See attached photos for further details.

OBG Seg 13AE:

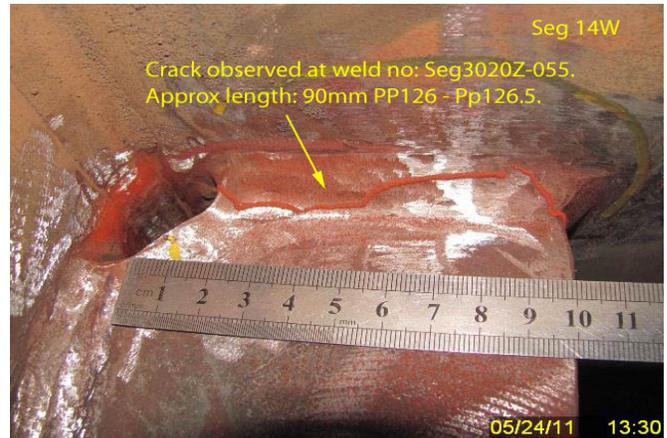
Blast inspection was performed on Floor Beam (FB) 3104A (at PP117.5), FB3101A (PP117.5), East side of FB3108A and FB 3106A (PP118), Deck Panel and Corner Assembly areas (from the inside of the segment) at PP117.5 to PP118. Areas were identified for additional grinding and / or welding and were marked up and were informed to ZPMC QC personnel. These locations were recorded on the drawings / weld maps and were submitted to the Lead Inspector for review and further disposition.

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



WELDING INSPECTION REPORT

(Continued Page 3 of 3)



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: Peterson,Art

QA Reviewer