

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-024656**Date Inspected:** 08-Jun-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. An Qing Xiang**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: 13BE

This QA Inspector randomly observed the following work in progress:

During random in process visual inspection of OBG member identified as deck plate, this QA observed 3 longitudinal linear cracks on deck plate base metal where the temporary attachment removed area. The length of cracks measuring approximately 180 mm ~ mm in length. The deck plate member is identified as PL3332A. The deck plate is designated as Seismic Performance Critical Material (SPCM) on the approved shop drawing. The nearest welds are identified as SEG3014-001 and OBW13-001. The "Y" locations measured to be approximately 470 mm and 40 mm from the weld toes respectively as shown on the picture below. The thickness of the deck plate is 20 mm. This QA marked the affected area and informed ZPMC Quality Control (QC) CWI identified as Mr. Liu hua jie of this issue. Mr. Liu hua jie informed this QA that the cracks would be corrected in a manner compliant with the contract documents. This QA Inspector also informed to Lead QA Inspector of the issue. See attached photos for further details.

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Segment: 14W

Shielded Metal Arc Welding (SMAW) welding of weld joint identified as SEG3020F-115,116. Welder is identified as 067588. ZPMC QC is identified as Mr. An Qing xiang. The welding variables recorded by QC personnel observed appeared to comply with Welding Procedure Specification (WPS): WPS-B-P-2113-FCM-1.

SMAW welding of weld joint identified as SEG3020V-034. Welder is identified as 066479. ZPMC QC is identified as Mr. An Qing xiang. The welding variables recorded by QC personnel observed appeared to comply with (WPS): WPS-B-P-2212-TC-U4b-FCM.

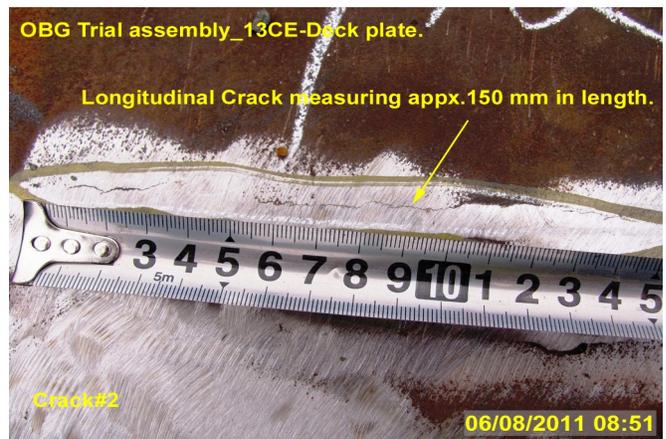
SMAW welding of weld joint identified as SEG3020V-029. Welder is identified as 066002. ZPMC QC is identified as Mr. An Qing xiang. The welding variables recorded by QC personnel observed appeared to comply with (WPS): WPS-B-P-2212-TC-U4b-FCM.

SMAW welding of weld joint identified as SEG3020V-027. Welder is identified as 067520. ZPMC QC is identified as Mr. An Qing xiang. The welding variables recorded by QC personnel observed appeared to comply with (WPS): WPS-B-P-2212-TC-U4b-FCM.

SMAW welding of weld joint identified as SEG3020R-215. Welder is identified as 069118. ZPMC QC is identified as Mr. An Qing xiang. The welding variables recorded by QC personnel observed appeared to comply with (WPS): WPS-B-P-2114-FCM-1.

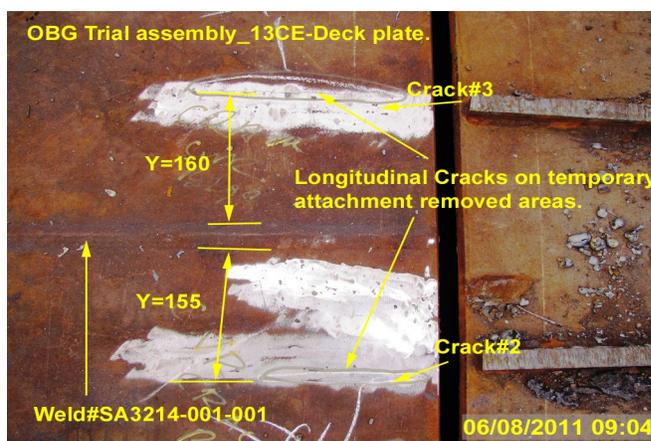
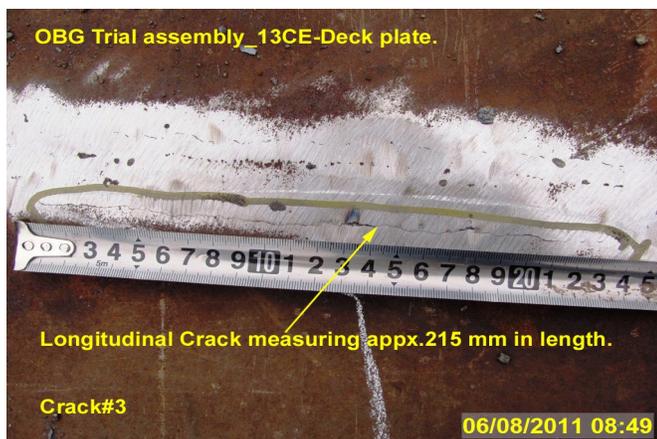
SMAW welding of weld joint identified as SEG3020M-107. Welder is identified as 069683. ZPMC QC is identified as Mr. An Qing xiang. The welding variables recorded by QC personnel observed appeared to comply with (WPS): WPS-B-P-2114-FCM-1.

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