

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-025474**Date Inspected:** 14-Jul-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:** 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:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad 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 TA YARD, SEGMENT 14W

This QA Inspector performed verification of the punch list item for OBG Segment 14W.

Punch list Item No. 3670:

ZPMC personnel performed grinding, welding and Magnetic Particle Testing (MT) wherever required.

Punch list Item No. 3682:

All points verified except the following two points.

1) In between PP127 and PP128 cross beam side, scattered porosity observed on side plate (SP3143A). Areas were taped prior to blast and paint.

2) At PP 127 cross beam side, scattered porosity observed on floor beam outside 2rd stiffener to floor beam (FL3). Areas were taped prior to blast and paint.

During random in process inspection this QA Inspector observed that ZPMC personnel were performing match

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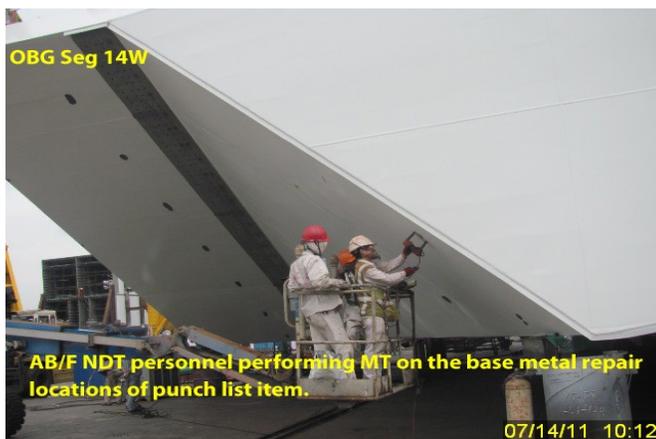
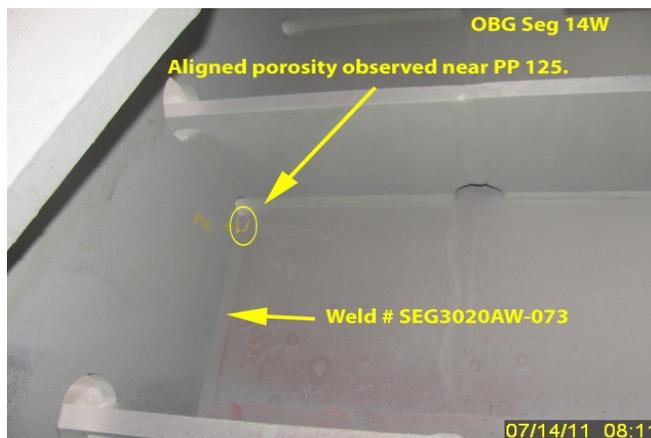
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drilling on the splice plate of OBG Segment 14W. For more details please see attached photograph.

During random in process inspection this QA Inspector observed aligned porosity on weld joint SEG3020AW-073 near PP 125. This issue was discussed with ZPMC CWI Mr. An Qing Xiang. ZPMC CWI Mr. An Qing Xiang informed this QA that ZPMC will perform repair with comply to contract documents. For more details please see attached photograph.

This QA Inspector observed ZPMC qualified welding personnel identified as 22068 perform welding by Shielded Metal Arc Welding (SMAW), on CJP weld joint of OBG Segment 14W at PP 127. Weld joint is identified as SEG3020AT-176. ZPMC Quality Control (QC) Inspector identified as Mr. Li Yang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2214-Tc-U4b-FCM-1.

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



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

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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:	Gaikwad,Umesh	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer
